

## LOCTITE® Frekote® 800-NC

November 2015

### Product description

LOCTITE® Frekote® 800-NC provides the following product characteristics:

LOCTITE® Frekote® 800-NC has been designed to form a semi-permanent release film on mold surfaces above 150°C (300°F). The multiple release polymer system chemically bonds to the mold surface to form a micro thin chemically resistant coating. LOCTITE® Frekote® 800-NC will release all natural and synthetic organic rubber compounds and should be considered for all molding processes with mold temperatures continually above 150°C (300°F). LOCTITE® Frekote® 800-NC cures upon solvent evaporation when applied at temperatures above 150°C (300°F).

### Features

- No chlorinated solvents
- Instant curing
- No mold build-up
- Releases most rubber compounds
- Reduced reject rates

### Properties

Color	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic naphtha
Specific gravity	0.780 +/- 0.020
Shelf life	18 month from date of manufacture
Cured thermal stability	400°C (750°F)
Special cautions	Moisture sensitive, keep container tightly closed when not in use

### Mold preparation

The mold surface must be clean and free of any release agent or other contaminants for LOCTITE® Frekote® 800-NC to be completely effective. Remove any contaminants with LOCTITE® Frekote® PMC or another suitable cleaning solvent. Grit blasting or other abrasive methods can be used to remove heavy resin build up. Always follow with a solvent wipe to remove residue.

Note: For porous or damaged molds, LOCTITE® Frekote® B-15 aealer should be considered - technical data is available.

### Application \*Consult MSDS prior to use\*

When the mold is clean and free from other release agent or contaminant, it should be heated to a minimum temperature of 150°C (300°F). This normally represents the minimum preheating temperature for rubber presses.

LOCTITE® Frekote® 800-NC may be applied by spraying (ensuring a dry air source), airless spray, brushing, dipping or wiping. Spray applications are the preferred method for applying LOCTITE® Frekote® 800-NC to a hot mold surface.

### Spraying

1. When spraying bulk material, it is essential to always use a dry, oil free air source.
2. Keeping the nozzle 8-10" from the mold surface spray on a light uniform coating. At 150°C (300°F) solvents will evaporate within 30 seconds and at 180°C (355°F) evaporation will be instantaneous.
3. Apply a minimum of three base coats to the hot mold. Care should be taken not to over apply the material to the hot surface. Maximum releases will be obtained as the mold becomes conditioned to LOCTITE® Frekote® 800-NC. Performance will be improved by applying a touch-up coat after the first few multiple releases. LOCTITE® Frekote® 800-NC efficiency may be lessened in processes involving heavily filled polymers and additional touch-ups may be necessary in such areas.

### Mold Touch up

Touch up coats should only be applied to areas where poor release is noticed and should be applied using the same method as base coats. The frequency of touch ups will depend on the polymer type, mold configuration, and abrasion parameters. This will reduce the possibility of release agent or polymer build-up.

### Flammability/Storage

LOCTITE® Frekote® 800-NC contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool dry place. Keep container tightly closed when not in use. Consult MSDS for complete details.

### Disclaimer

The information provided in this Technical data sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical data sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.1