



Aqualine[®] C-600[™]

August 2007

PRODUCT DESCRIPTION

Aqualine[®] C-600[™] provides the following product characteristics:

Technology	Mold Release
Appearance	Milky white emulsion ^{LMS}
Chemical Type	Water based emulsion
Odor	Mild
Cure	Room temperature cure
Cured Thermal Stability	≤315 °C
Application	Release Coatings
Application Temperature	20 to 40 °C
Specific Benefit	<ul style="list-style-type: none"> • Non-flammable • Autoclaved resistant at either 121°C or 177°C • Multiple releases

Aqualine[®] C-600[™] mold release agent is a proprietary, water based emulsion originally developed for releasing large scale parts such as wind blades, and is ideal for numerous other high performance composite structures. When fully cured, this product chemically bonds to the mold surface to form a thin, inert, thermally stable coating. Aqualine[®] C-600[™] is designed to be applied and cured at ambient shop temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 20 °C 0.97 to 1.03^{LMS}
Flash Point - See MSDS

TYPICAL PROPERTIES OF CURED MATERIAL

4 total coats applied @ 22°C, 5 minute cure per coat, and final 30 minute cure @ 22°C
Epoxy Release Test ≥5^{LMS}

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Mold Preparation

Cleaning:

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release must be removed. This may be accomplished by using Frekote[®] PMC or other suitable cleaner. Frekote[®] 915WB[™] or light abrasives can be used for heavy build-up.

Directions for use

1. Wipe on a smooth, thin continuous, wet film.
2. Wait 1-2 minutes before the coating is fully dried, then lightly wipe off the coated surface with a new wipe.
3. Allow a minimum of 15 minutes before applying next coat. Apply a minimum of 3 coats in this manner. Dampen cloth lightly as needed.
4. Allow the final coat to cure for 30 minutes at 22°C.
5. The release agent can also be spray applied. Wiping off is not necessary. 2-3 coats are needed for a new mold. One coat is needed for touch-ups. Curing between coats is 5-10 minutes, until the coating dries. The final curing time is 30 minutes.

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. This will reduce the possibility of release agent or polymer build-up. The frequency of touch ups will depend on the polymer type, mold configuration, and abrasion parameters.

Loctite Material Specification^{LMS}

LMS dated July 18, 2007. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note

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