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Product Description Sheet

FREKOTE[®] 720-NC

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Description

Loctite[®] Frekote[®] 720-NC is formulated specifically as a release agent for all cast polymer products and for releasing highly filled resins. Frekote 720-NC contains a unique cross-linking polymer designed for cast polymer manufacturers needing to reduce their cycle time by releasing "hot" parts. Frekote 720-NC is also well suited for certain abrasive, closed molding processes such as RTM and filament winding. Additionally, Frekote 720-NC's unique chemistry makes it ideal for application on highly porous mold surfaces.

Features

Fast curing
Gloss finish
Easy application
Multiple releases per application
High slip/low surface energy coating

Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Solvents	Dibutyl Ether/Aliphatic Naphtha
Specific Gravity	0.762 +/- 0.015
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.
Application Temp	55°F -110°F
Shelf Life	Six months from date of manufacture in an unopened container <i>Product should be used after 2-3 weeks of opening container</i>

Mold Preparation

The mold surface must be dry, clean and free of any release agent or other contaminants for the product to be completely effective. Remove any contaminants with Frekote PMC or other suitable cleaning solvent(s). Full curing of green/new molds is highly recommended to ensure optimal performance of the release. Always follow tooling supplier's guidelines for proper curing of new molds.

Application *Consult MSDS prior to use*

720-NC should be applied at room temperature (less than 105°F or 43°C) by wiping on with a clean, lint-free, cotton cloth.

1. Soak cloth with 720-NC until it is wet, but not dripping. Wipe on a smooth, wet film over a 2' x 2' to 2' x 3' area of the mold surface. Do not over apply.
2. For a gloss finish, wait 15-20 seconds (at 70°F) after application. Gently wipe dry starting from the outside of the wet area, and working inward with a second clean and dry, cotton cloth. Note: Changes in temperature will affect solvent dry time. At temperatures below 65°F, waiting time between wiping on and drying off can be slightly longer. A general guideline is to wait until the edges of the wiped area begins to creep inwards indicating that evaporation has just begun. Wipe from the outside and

slowly work your way towards the center. Light hand pressure is all that is needed. No hard rubbing is required. Change cloth frequently to ensure proper drying of the mold. On small molds, allow up to 15 minutes between coats. If one coat takes more than 15 minutes, simply go back to starting point and begin to apply next coat.

3. Coat the entire mold surface overlapping the last area coated. Green molds will need a minimum of four coats and fully cured molds (not green) require 2-3 coats.
4. Once the final coat is applied, the coating should ideally, be cured at room temperature for 15-20 minutes.

Flammability/Storage

Frekote 720-NC contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool, dry place. **Product should be used after 2-3 weeks of opening container. Keep container tightly closed when not in use.** Consult MSDS for complete details.

Note

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