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Product Description Sheet

Draft: FREKOTE[®] 901 WB

Mold Release Agents

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Description

Frekote[®] 901 WB mold release is a proprietary waterbased emulsion developed for releasing Aerospace and other High Performance Composite structures. This release is designed to be applied and cured at ambient shop temperatures.

Features

Non toxic waterbased system
Can be applied and cured at ambient shop temperatures
Can be autoclaved at either 250 F or 350 F
Low VOC
Non-flammable

Properties

Appearance: Milky white emulsion
Flash Point: Does not flash
Odor: Mild
Specific Gravity: 1.00 ± 0.03
Shelf Life: 9 months from date of manufacture
Application Temperature: 70°F to 90°F (21°C to 32°C)

Mold Preparation

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. Light abrasives can be used for heavy build-up. **NOTE:** Optimum results will be achieved when molds are cleaned prior to use of Frekote 901 WB.

Application

Frekote 901 WB can be applied to molds at room temperature (70°F to 90°F). When spraying, ensure a dry air source is used or use an airless spray system.

1. Only a thin wet film is required. Spray on a smooth, thin, continuous, wet film. Avoid spraying over the same area that was just coated until the water has evaporated. When spraying, hold nozzle 8-10 inches (20-30 cm.) from mold surface. It is suggested that small areas be coated working progressively from one side of the mold to the other.
2. Apply four thin coats, allowing 5-10 minutes after each application for complete water evaporation. The film should be dry and not feel tacky. Frekote 901 WB must be cured for a minimum of three hours at ambient temperature after last coat.
3. Performance is enhanced by recoating once, after the first few initial pulls. Maximum releases will be obtained as the mold surface becomes conditioned.
4. When any release difficulty is experienced, the area in

question can be "touched-up" by recoating the entire mold surface or just those areas where release difficulty is occurring.

If the application does not lend itself to spraying, a wipe on method can be used. Wipe applications usually produce streaks in the finished part as the water evaporates. The streaking is a visual phenomena and does not equate to transfer of release.

5. Wipe on Frekote 901 WB with a Kimberly-Clark WypAll (L40) or suitable non-linting paper wipe. Apply a thin, even coat, removing excess product by wiping with a slightly damp wipe. Do not over apply. A minimum of 4 coats should be applied allowing for a 5-10 minute (or until the released surface is completely dry) dry time between coats. Frekote 901 WB must be cured for a minimum of three hours at ambient temperature after last coat. The mold must be lightly wiped with a cleaner before applying touch-up coats. This will insure a smooth, even coat. Allow cleaner to dry before applying touch-up coat.

Storage

Frekote 901 WB should always be used in well ventilated areas. Store in a cool, dry place. Consult MSDS for complete details. Keep container tightly closed when not in use. Keep from freezing.

Handling Precautions

Do not handle or use until the Material Safety Data Sheet has been read and understood.
For industrial use only.

Note

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