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Product Description Sheet

FREKOTE® WOLO Mold Release Agent

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Description

Loctite® Frekote® WOLO is a unique polymer release agent that cures quickly and provides multiple release of all polyester resins. Application and use of a release agent has never been easier, simply wipe on and leave on to produce a high gloss finish with no need to polish.

Features

High gloss finish
Easy application
Fast curing
Multiple releases
Minimal mold build-up

Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Specific Gravity	0.725+/-0.02
Solvents Aliphatic	Hydrocarbon
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.
Shelf Life	1 year from date of manufacture
Application Temperature	13°C - 41°C (55-105°F)
Cured thermal stability	400°C (750°F)

Mold Preparation

Cleaning

To work effectively, Frekote Release products must be applied to thoroughly cleaned and dried mold surfaces. All traces of waxes, sealers, rubbing compounds or other release agents must be completely removed. Wax and most release agent contamination can be removed with Frekote Polyester Mold Cleaner (PMC) or another suitable cleaning solvent. Consult the technical data sheet for proper use and best cleaning results.

Sealing Repaired Areas or Green Molds

Fresh or "production line" repairs, new fiberglass and epoxy molds should be cured per manufacturer's instructions, usually a minimum of two to three weeks (at room temperature), before starting full-scale production. Occasionally, green or freshly repaired molds are rushed into service prior to complete cure causing an abnormal amount of free styrene on the mold surface. This is not a recommended practice, but happens from time to time. These types of areas would be considered "extremely green" due to the short cure time and will require the extra styrene sealing capability of the Frekote Fiberglass Mold Sealer (FMS). Sealing may be accomplished by simply wiping on 2-3 coats of FMS onto the repair area(s). Refer to the FMS data sheet for instructions. Allow 15-20 minutes after the last coat before continuing with the application of the WOLO as outlined below. A "blow coat" or one foot squares of gel-coat should be applied and released to check for good release following the application of the sealer and release. Normal mold "break in" procedures and instructions should be followed thereafter.

Sealing New Molds

Fully cured molds, previously unused molds should be sealed before use. This can be accomplished by applying four additional coats of WOLO, following the application instructions outlined below.

Application

Apply WOLO with a clean wiping cloth. For optimal results we recommend the following cloths; Kimberly Clark "WypAll" or "Work Horse", Ft. James "Task Mate" or "Tuff Mate", Scott "Sontara" or equivalent. Wet cloth with WOLO until it is damp and not dripping.

Wipe a smooth, wet film over the entire mold surface. For larger molds, apply WOLO to one section at a time starting at one end and working towards the other. Continue to work the material into the mold by lightly wiping the wet film (10-30 seconds) until a thin and uniform coating is obtained and allow to evaporate. If wipe cloth dries out for any reason, use a fresh clean cloth for the next coat of WOLO. This prevents resin accumulation on the cloth from being deposited on the mold.

When complete, allow a minimum of 5 minutes before the next coat is applied. Apply a minimum of 4 coats in this manner. Dampen cloth lightly as needed.

After the final coat has been applied, allow WOLO to cure for a minimum of 15 minutes at 20°C (68°F). The mold is now ready for use.

For maximum numbers of releases apply a touch-up coat after the first 2-3 parts are released as a break-in period after the initial application. On deep or high wear areas; apply an extra 1-2 coats of WOLO. This will help increase the slip/release in those areas.

If streaking occurs, replace cloth with a clean dry one and/or make sure that the cloth is just damp - not soaking wet. Avoid over-application, as this will cause streaking on the mold. Streaks or wipe lines can be removed easily by wiping the mold lightly with a dry cloth.

Mold Touch Up

Abrasion will gradually cause wear and parts will begin to adhere to the mold surface if a continuous release film is not maintained. It's best to always touch-up the mold at the first sign of diminished release, before release becomes difficult. Simply touch-up the entire mold or apply spot touch-ups to high wear areas following steps 1-3 under Application. Only one coat is usually required for touch-up. Typically, 15 minutes cure time is required prior to resumption of molding.

Flammability & Storage

Frekote WOLO 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.

Note

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, Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite 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 Loctite 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.