

LOCTITE FREKOTE C800 AERO

Release Coating

(KNOWN AS X257489 / X325204B System)

INTRODUCTION

LOCTITE FREKOTE C800 AERO is a mold release agent that is designed for releasing composite materials. This product offers easy application and higher number of releases which causes lower product usage and less operator exposure to chemicals.

FEATURES

Technology	Mold Release
Appearance	White Emulsion
Chemical Type	Semi-Permanent
Odor	Mild to none
Cure	Room temperature cure (increase mold temperature can shorten the curing time)
Cured Thermal Stability	≤572°F (300 °C)
Application	Release Coatings
Application Temperature	68-122°F (15 to 50 °C)
Solid Contents	1 – 5%
Specific Benefit	<ul style="list-style-type: none">• High slip• Easy application• Multiple releases• Low transfer• No corrosion/oxidation of the mold surface• Minimal mold build-up

Typical Uncured Properties:

Density @ 77°F (25 °C), g/cm ³	0.98 to 1.02
Flash Point	None
Shelf Life	Nine Months

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

LOCTITE FREKOTE C800 AERO

Release Coating

(KNOWN AS X257489 / X325204B System)

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. Mix the 2 components, LOCTITE FREKOTE C800 AERO. Use equal amounts, either by weight or by volume, of each component. Mix the 2-components well before using. Note: the mixed release agent has a pot life of 8-10 hours, so only mix the amount that will be used within this time frame. Discard any unused release agent after 9 hours. The coverage of the mixed release agent is 1000-1500 square feet per gallon for every coat.
2. Apply the mixed release agent by spraying with a high volume low pressure spray system or by wiping with a clean, lint free, wiping cloth, such as WipeAll[®] L40.
3. For a wipe-on application, wet the cloth with release agent until it is damp but not dripping. Wipe a smooth, wet film over the entire mold surface. For larger molds, apply the release agent to the surface one section at a time starting at one end and working towards the other. Lightly wipe-off the wet film until a thin and uniform coating is obtained. Wipe a total of 4-5 coats onto the mold using this method, allowing for 5 - 10 minutes of drying time between coats. Allow 3 hours of final cure time after the last coat is applied.
4. If spraying the material, adjust the spray gun to apply 60-90 grams/minute, using a minimum air pressure of 30-40psi. The speed of spray is about 1 – 1.5 ft/second. Hold the spray gun at a distance of 8-12 inches away from the mold surfaces. If using a pressure pot with dual regulation, set pot pressure to a minimum of 10 psi and the air atomization pressure to a minimum of 40 psi. Spray 4 - 5 box coats, waiting 5 - 10 minutes between each coat.
5. After the final coat has been applied, allow the release agent to cure for 3 hours at room temperature.
6. For maximum number of releases, determine the threshold of number of parts per cycle and re-apply a touch up coat before release become difficult.

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 material type, mold configuration, and abrasion parameters. **For releasing LOCTITE EA 9895WPP AERO, apply touch up coat after each release.**



Technical Process Bulletin

LOCTITE FREKOTE C800 AERO Release Coating (KNOWN AS X257489 / X325204B System)

Storage:

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

Optimal Storage: 37° to 68°F (3 °C to 20 °C). Storage at greater than 77°F (25 °C) can adversely affect product properties. The product is not freeze stable.

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.

Cleanup

DISPOSAL INFORMATION

Dispose of spent remover and paint residue per local, state and regional regulations. Refer to HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional disposal information.

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, **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.

Rev. 06/2014

Henkel Corporation Aerospace | 2850 Willow Pass Road | Bay Point, CA 94565
PHONE: +1.925.458.8000 | FAX: +1.925.458.8030 | www.henkel.com/aerospace

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.

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.

