FREKOTE®

901WB™

July 2007

PRODUCT DESCRIPTION

901WB™ provides the following product characteristics:

Technology	Mold Release
Appearance	Milky white emulsion[LMS]
Chemical Type	Water based emulsion
Cure	Room temperature cure
Cured Thermal Stability	250 °C
Application	Molding
Application Temperature	21 to 32 °C
Specific Benefit	• Non-toxic water based system • Low VOC • Can be autoclaved at either 121°C or 177°C

901WB™ mold release is a spray-on proprietary water based emulsion developed for releasing aerospace and other high performance composite structures. This product is designed to be applied and cured at ambient shop temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.0 to 1.06[LMS]
Flash Point - See MSDS	
Odor	Mild
pH @ 25 °C	3.9 to 4.1[LMS]

GENERAL INFORMATION

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

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. Frekote® 915WB™ or light abrasives can be used for heavy build-up.
NOTE: Optimum results will be achieved when molds are cleaned prior to use of 901WB™

Directions for use

1. When spraying 901WB™, hold the nozzle 20cm -30cm from the mold surface utilizing the box spray method. Spray on a smooth, thin continuos, wet film. Avoid spraying over the same area that was just coated until the water has evaporated. Typical application temperature of 901WB™ is between 21°C-32°C.
2. Apply 4 to 6 thin box coats, allowing 15 minutes after each application for complete water evaporation. The film should be dry and not feel tacky. 901WB™ must be cured for a minimum of 3 hours at ambient temperature after the last coat.
3. Performance could be enhanced by recoating once, after the first few 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. Once box coat of release agent is required for touch up. Curing time of the touch up cating is 3 hours.

Loctite Material Specification[LMS]

LMS dated June 15, 2006. 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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Reference 0.2