



## Frekote<sup>®</sup> 900 WB

### Waterbase Mold Release

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#### Description

Frekote 900 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:	1.03 ± 0.03
Shelf Life:	5 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 900 WB.

#### Application

Frekote 900 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 900 WB must be cured for a minimum of one hour 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 900 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 minutes (or until the released surface is completely dry) dry time between coats. Frekote 900 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 900 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.

Frekote is a registered trademark of Henkel Corporation.

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Users should review the Materials Safety Data Sheet (MSDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the MSDS and label are available upon request.

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