Technical Data Sheet

LOCTITE® FREKOTE® WOLO-HL™

Known as Frekote WOLO-HL
June 2015

PRODUCT DESCRIPTION

LOCTITE® FREKOTE® WOLO-HL™ provides the following product characteristics:

Technology	Mold Release
Appearance	Clear colorless liquid[LMS]
Chemical Type	Solvent Based Polymer
Cure	Room temperature cure
Cured Thermal Stability	≤400 °C
Application	Release Coatings
Application Temperature	13 to 41 °C
Specific Benefit	• High slip • High gloss finish • Easy application • Fast curing • Multiple releases • Minimal mold build-up • Reduced VOCs

LOCTITE® FREKOTE® WOLO-HL™ is a solvent-based polymer release agent with a unique high slip formulation that cures quickly and provides multiple releases for low VOC polyester gel-coat and other tough releasing polyester structures. Application and use of this release agent utilizing the wipe-on-leave-on technique produces a high gloss finish with no need to polish.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	0.783 to 0.803[LMS]
Flash Point - See SDS	

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 Safety Data Sheet (SDS).

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.

Sealing New/Repaired Molds:

Fully cured unused molds should be sealed before use. This can be accomplished by applying 4 additional coats of LOCTITE® FREKOTE® WOLO-HL™. Fresh or "production line" repairs, new fiberglass and epoxy molds should be cured per manufacturer's instructions, usually a minimum of 2 -3 weeks at 22°C before starting full-scale production. Occasionally, green or freshly repaired molds are rushed into service prior to complete cure causing an increased amount of free styrene on the mold surface. These areas of the mold surface would be considered extremely green due to the short cure time and will require the extra styrene sealing capability of Frekote® Mold Sealer. Sealing may be accomplished by wiping 2-3 coats of Frekote® Mold Sealer onto the repaired area(s). Allow full cure of the appropriate Frekote® mold sealer before you apply the first coat of LOCTITE® FREKOTE® WOLO-HL™ as outlined in the directions of use.

Directions for use:

1. Apply LOCTITE® FREKOTE® WOLO-HL™ with a clean, lint free, cotton wiping cloth. Wet the cloth with LOCTITE® FREKOTE® WOLO-HL™ until it is damp but not dripping.
2. Wipe a smooth, wet film over the entire mold surface. Be sure to avoid drips and puddles. Allow the product to evaporate. For larger molds, apply LOCTITE® FREKOTE ® WOLO-HL™ to the surface one section at a time, being sure not to miss any areas.
3. Allow a minimum of 15 minutes before applying next coat. Apply a minimum of four coats in this manner. Dampen cloth lightly as needed.
4. Allow the final coat to cure for 30 minutes at 20°C.
5. **NOTE:** If the cloth dries out during your coating process, use a fresh clean cloth to apply the next coat. This prevents resin accumulation on the cloth from being deposited on the mold surface. If streaking occurs, replace the cloth with a clean dry one and/or make sure that the cloth is just damp and not soaking wet. Avoid over-application, as this will cause streaking on the tooling surface. Streaks or wipe lines can be removed easily by wiping the mold surface lightly with a dry cloth. Product is moisture sensitive, keep container tightly closed when not in use.
6. **NOTE**: For maximum number 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 LOCTITE® FREKOTE® WOLO-HL™. This will help increase the slip even further in these high drag areas.

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 polymer type, mold configuration, and abrasion parameters.

Loctite Material Specification[LMS]
LMS dated September 19, 2007. 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
The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.
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 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 Representive.

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

Reference 0.2