FREKOTE®

WOLO™

October 2009

PRODUCT DESCRIPTION

WOLO™ provides the following product characteristics:

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

WOLO™ is a unique, polymer release agent that cures quickly and provides multiple release of all polyester resins. Applications 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.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	0.71 to 0.73[LMS]
Flash Point - See MSDS	

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).

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 WOLO™. 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 WOLO™ as outlined in the directions of use.

Directions for use:

1. Apply WOLO™ with a clean, lint free, cotton wiping cloth. Wet the cloth with WOLO™ until it is damp but not dripping.
2. Wipe a smooth, wet film over the entire mold surface. For larger molds, apply WOLO™ to the surface 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 then allow the product to evaporate.
3. Allow a minimum of 5 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 15 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 WOLO™. This will help increase the slip even further in these high drag areas.

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 diinished 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 directions for use. Only 1 coat is usually required for touch-up. Typically, 15 minutes cure time is required prior to resumption of molding.

Loctite Material Specification[LMS]

LMS dated January 24, 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.

Henkel

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

Note
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Reference 0.0