

6. **NOTE:** If you are spraying onto a mold large enough that you must walk on the mold, use this simple technique - start at one end and apply all of the recommended number of coats to one specific section at a time. This can be accomplished because after evaporation of one coat of LOCTITE® FREKOTE 1-STEP™ the next coat can be applied immediately. Repeat this process working your way section by section to the opposite side of the mold. After application is complete, the normal 20 to 30 minutes cure needs to be followed. This technique will eliminate any walking on the mold during the initial application. Some type of foot covering is always recommended when entering a mold to apply.

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 diminished 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 February 07, 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 Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference 0.0