



1001 Trout Brook Crossing  
Rocky Hill, CT 06067-3910  
Telephone: (860) 571-5100  
FAX: (860) 571-5465

## Product Description Sheet FREKOTE® D770-NC

Mold Release Agent  
formerly Frekote 770-NC

Industrial Products, August 2001

### Description

Loctite® Frekote® D770-NC is a low odor, fast evaporating version of Frekote 700-NC. Frekote D770-NC offers excellent release for various molding applications and can be used as a direct replacement for Frekote 700-NC. Frekote D770-NC releases epoxies (thermosets and prepregs), polyester resins, and thermoplastic compounds. Frekote

### Features

Versatile - releases most polymers  
No contaminating transfer  
High gloss and high slip  
Room temperature cure  
No mold build-up  
Low odor

### Physical Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic Hydrocarbon
Specific Gravity	0.720 +/- .015
Flash Point	7°C (45°F) Tag Closed Cup
Shelf Life	One year from date of manufacture
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.
Cured thermal stability	750°F
Application Temp	55°F -140°F

### Mold Preparation

The mold surface must be clean and free of any release agent or other contaminants for Frekote D770-NC to be completely effective. Remove any contaminants with Frekote PMC, PMC Plus or suitable cleaning solvent. Light industrial abrasives can be used to remove heavy resin build up.

New Molds: Full curing of new molds is advisable to ensure the best bonding of the Frekote to the mold surface. New fiberglass and epoxy molds should be cured per manufacturer's instructions before starting full scale production.

**Note:** For porous or repaired molds, a Frekote Sealer should be used - technical data is available. Consult with your Frekote Representative for assistance.

### Application \*Consult MSDS prior to use\*

Frekote D770-NC can be applied to mold surfaces at room temperature up to 60°C (140°F) by spraying, brushing or wiping with a clean lint-free, cloth. When spraying, ensure a dry air source is used or use an airless spray system. If possible, warm the mold prior to applying Frekote D770-NC to approximately 50°C (120°F) to drive off any moisture entrapped on the mold surface.

1. Only a thin wet film is required. Wipe or spray on a smooth, thin, continuous, wet film. Avoid wiping or spraying over the same area that was just coated until the solvent has evaporated. If 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. Initially, apply two or more base coats, allowing up to 5 - 10 minutes after each application for complete solvent evaporation. The film should be dry and not feel tacky.
3. Aerosols may sometimes leave a matte surface finish. To enhance gloss, use a cotton cloth to gently buff up dry film, if required.
4. Performance is enhanced by recoating once, after the first few initial pulls. Maximum releases will be obtained as the mold surface becomes conditioned to Frekote D770-NC.
5. 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. For temperatures up to 60°C (140°F), use Frekote D770-NC and cure as per instructions above. If application temperatures exceed 60°C (140°F), Frekote 800-NC is recommended

**Note:** Touch-up coats applied at regular intervals before the base film breaks down will extend the number of releases obtainable and reduce possible resin attack/build-up.

**Precaution:** Users of closed mold systems (i.e. rotomolding) must be certain that solvent evaporation is complete and that all solvent vapors have been ventilated from the mold cavity prior to closing the mold. An oil-free compressed air source can be used to assist in evaporation of solvents and ventilation of the mold cavity.

### Flammability/Storage

Frekote D770-NC contains flammable solvents. The product should always be used in well ventilated areas. Store in a cool, dry place. Consult MSDS for complete details.

### Packaging

Frekote D770-NC is supplied in the following sizes:  
Aerosol cans  
One US gallon can  
Five US gallon pail  
55 US gallon drum

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THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.  
PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.  
ROCKY HILL, CT FAX: +1 (860)-571-5473 DUBLIN, IRELAND FAX: +353-(1)-451 - 9959

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