



FEATURES

- Stable, low-transfer, with excellent release properties,
- Improved cosmetics, and fewer defects
- Increased mold life and less frequent mold cleaning required
- Forms a tough, durable release film
- Water-based formula avoids complications found in solvent-based products
- Promotes good rubber flow
- Does not need to be diluted prior to use

APPLICATIONS

- Seals
- O-rings
- Gaskets
- EPDM
- FKM
- HNBR
- Silicone

MATERIALS COMPATIBILITY

- Silicone & Fluorosilicone
- Elastomers
- Peroxide-Cured Elastomers
- EPDM
- FKM Fluoroelastomers
- HNBR

DIRECTIONS

For best results the surface of the mold must be cleaned prior to application of DiamondKote DKW-4013D. Typical cleaning methods would be media/dry ice blasting or treatment with alkaline detergent followed by neutralization and rinsing with water.

Base Coat: For best results, the tool should be above 180°F when applying DiamondKote mold release agents. For spray application, utilize an air atomizing spray gun or an airless spray gun which produces a finely atomized spray particle. Apply 4 or 5 light coats, varying the direction of each to ensure total tool coverage and sealing. Allow each pass to dry completely prior to application of the next coat.

Touch-up: Use the same application equipment used for basecoating. Typically a single pass application of the undiluted material prior to failure of the basecoat proves to be effective.



PROPERTIES

Appearance / Physical State	Liquid.
Color	Brownish yellow.
Odor	None.
pH Value	9
Melting / Freezing Point	N/A
Boiling Point / Range	199 °F (92.78 °C)
Flash Point	122.0 °F (50.0 °C)
Vapor Pressure	17.5 mm Hg @ 20°C
Vapor Density	< 1 (Air=1)
Specific Gravity	1



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DiamondKote™

DKW-4013D

Water-Based Semi-Permanent Mold Release

HANDLING

Containers should be kept closed prior to and during use to avoid external contamination. Store below 100°F and above 32°F. Keep product from freezing.

STORAGE

Storage in steel, galvanized steel, or black iron vessels will degrade the active ingredients of this product. For safety precautions consult MSDS.

DISPOSAL

N/A - Dispose of unused material in accordance with local/regional/state laws based on SDS



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