



DiamondKote

DKW-4013D

DESCRIPTION:

DiamondKote DKW-4013D is a water-based, **silicone free** semi-permanent mold release agent designed for use in the molding of silicone elastomers. **DiamondKote DKW-4013D** promotes good rubber flow without significant transfer and excellent release characteristics. Typical applications include the molding of seals, o-rings, gaskets. **DiamondKote DKW-4013D** can also be effective on a variety of peroxide cured elastomers including EPDM, FKM, and HNBR. **DiamondKote DKW-4013D** is sold as a ready to use material and does not need to be diluted prior to use.

PACKAGING, HANDLING, AND STORAGE CONDITIONS:

Available in 5 Gal pails, 55 Gal drums and 330 Gal totes.

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

Seals/Gaskets/O-Rings

PHYSICAL PROPERTIES:

| | |
|-------------------|------------------------|
| Appearance | Translucent liquid |
| pH | 9.5 |
| Viscosity | Water Thin |
| Odor | Alcoholic |
| Specific Gravity | 1.00 g/CM ³ |
| Water Solubility: | Fully Miscible |
| Shelf Life | 12 months |

APPLICATION INSTRUCTIONS:

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 base-coating. Typically a single pass application of the un-diluted material prior to failure of the basecoat proves to be effective.