



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

MATERIALS COMPATIBILITY

- Highest compatibility for Peroxide-Cured compounds
- P-EPDM
- Polyacrylate
- FKM Fluoroelastomers
- SBR
- HNBR
- Silicone Elastomers

DIRECTIONS

For best results the surface of the mold must be cleaned prior to application of DiamondKote DKW-4168. 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
Odor	no odor
pH Value	8.0-10.0 at 10%
Specific Gravity	1.00 g/cm ³
Boiling Point / Range	212°F (100°C)
VOC Content	0.01
Viscosity	water thin
Prop 65 Warning	No



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DiamondKote™ DKW-4168

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 will degrade the active ingredients of this product. For safety precautions consult SDS.

DISPOSAL

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



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