



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	slight
pH Value	>8-<10
Boiling Point / Range	212°F (100°C)
Flash Point	>212.0°F (>100.0°C)
Specific Gravity	1.00 g/CM ³
Prop 65 Warning	No



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DiamondKote™

DKW-4168

Water-Based Semi-Permanent Mold Release

HANDLING

Avoid prolonged exposure. Observe good industrial hygiene practices.

STORAGE

Store in a tightly closed container. Store away from incompatible materials (see Section 10 of the SDS).

DISPOSAL

Collect and reclaim or dispose in sealed containers at licensed waste disposal site. Dispose in accordance with all applicable regulations. The waste code should be assigned in discussion between the user, the producer, and the waste disposal company. Dispose of in accordance with local regulations. Empty containers or liners may retain some product residues. This material and its container must be disposed of in a safe manner. Since emptied containers may retain product residue, follow label warnings even after container is emptied. Empty containers should be taken to an approved waste handling site for recycling or disposal.



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