IsoKote 449AW

IsoKote 449AW is a water and alcohol based mold release.

PRODUCT ADVANTAGES

- Silicone Free

*Values given are not intended to be used in specific preparation

Component Properties	
Specific Gravity - 74°F	.94
Viscosity - ASTM D-2196 - 74°F, ISO	0 - 10 cps
% Solids	7.20 - 8.50 %
Release Type	non silicone
Typical Physical Properties	
Flash Point	105 °F

RECOMMENDED HANDLING INSTRUCTIONS

Most release agents contain an inert film forming material in a highly volatile anhydrous solvent. They are packaged in bulk or in aerosol containers for ease of application.

The most important requirement of a release system is that is release. It must also be capable of providing separation as a very thin continuous film that does not blur the details of the master model by filling in lines and undercuts.

If properly applied, IsoMold elastomers will reproduce every minute detail of the master model except where it is filled in with an excess of release agent or surface moisture has destroyed the integrity of cast elastomers.

The surface of the master model should be clean and dry before applying the release agent. All crevices, lines and undercuts should be clean.

The preferred method of applying the release agent is from an aerosol spray can. After coating the surface with a thin film of liquid spray in a well ventilated area, allow the solvent to evaporate and inspect the surface for any excessive buildup of release agent. If it appears that too much release agent has been applied to the master model, wipe the surface gently with a lint free piece of cloth or lens paper lightly moistened with the release agent to distribute the material uniformly over the surface of the master model and remove any excess. Wiping serves a secondary purpose in that it coats any areas that may not have been reached during the original application of spray.

THE NEXT STEP IS IMPORTANT!

When the highly volatile solvent from the release agent evaporates, it causes a sudden cooling of the surface of the master model and a condensation of moisture; particularly if the humidity is high. Often this layer of moisture is not visible but it is sufficient to react with the polyurethane casting materials, contacting the surface causing the formation of bubbles, softening or both. It will destroy the ability of casting materials to exactly duplicate the surface of the master model.

Allow all the solvent to evaporate from the master model after spraying.

Place the master model in a warm stream of air, or heated chamber, to allow any moisture on the surface to evaporate.

Do not apply IsoMold elastomers to a master model immediately after spraying it with release agent. This practice will lead to poor surface reproduction. Allow at least 10-15 minutes for the surface to dry.

Before using any release agent, test its compatibility with the surface of the master model. It is possible that the solvent in the release system will lift or distort the surface coating. Also test its compatibility with products that are being used. If it contains water or other active ingredients, you may ruin a great deal of material. We recommend IsoKote 449AW for use with our IsoMold and IsoCast products.

STORAGE

SAFETY

-Refer to the product SDS for all relevant safety information.

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