

IsoKote M2

IsoKote M2, formulated by Isotec International, Inc., is a non-transferring and environmentally friendly, water and alcohol based mold release. IsoKote releases the molded product easily, allowing for immediate mold prep which aids in decreasing shot cycle time. IsoKote M2 is available to meet the most exacting needs in mold release applications for metal molds (including aluminum or steel), gel coat molds and elastomer molds. IsoKote M2 yields clean release and indications are that extended mold life will result.

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

Component Properties

Specific Gravity - 74°F	.99
Viscosity - ASTM-D-2196 - 74°F	8 - 15 cps
% Solids	9 - 10

PRODUCT ADVANTAGES

- Helps reduce cycle time
- Is effective with Integral Skin Foam, Rigid Foams and Casting Elastomers
- Prevents mold build-up, allowing molds to stay cleaner up to 30 times longer
- Reduces downtime between applications by providing a clean release
- Works well with elastomer molds to release other soft elastomer products

RECOMMENDED HANDLING INSTRUCTIONS

Application Guide:

For a new mold:

The mold should be prepared before using the IsoKote M2 mold release. This prep step is critical and is a time consuming process, but worth it in the end. A mold prep like “Hi-Lo” should be used and can usually be purchased in small cans from fiberglass supply distributors. It should be applied like wax and buffed out after drying 6 times or so to get a very smooth glossy surface.

Then, a very fine mist of the IsoKote M2 mold release can be applied from a cup gun or small touch up paint gun before using the mold. The use of the IsoKote M2 mold release should enable multiple pulls or parts with no sticking. A mold should be “cured” by applying IsoKote M2 for the first 3-5 pours. Following these pours, apply IsoKote M2 to every other pour. Increase the number of pours between applications until the first evidence of “sticking” occurs. Be careful to NOT allow the poured product to stick in large areas. The exact number of parts possible with each application of the mold release will vary and should be determined with trial and error. However, 4-6 parts would be typical before another application of IsoKote M2 is required. If the mold begins to “stick” to the part, then the mold should be cleaned, repaired if needed, prepped again with the mold prep, and treated with a mist coat of mold release.

It is imperative that the IsoKote M2 be applied as a “mist” and not so heavy that droplets and/or rivulets result. If left on the surface as a liquid it can cause sticking. To avoid this, blow excess IsoKote M2 off with air gun so that the surface appears to be dry.

STORAGE

SAFETY

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

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