KLEENMOLD PRECOAT 409

TECHNICAL DATA SHEET

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DESCRIPTION

Kleenmold Precoat 409 is a water-based, precoat used as a glass release agent for blanks, molds, neck rings, and other related equipment used. It is a one component product available either in an aerosol can or in a Binks Gun compatible plastic jar. Kleenmold Precoat 409 deposits a smooth, uniform, tightly bonded film of graphite onto mold equipment surfaces. Proper application is very important.

ADVANTAGES

WATER-BASED
NON-FLAMMABLE
AVAILABLE IN AEROSOL AND BULK PACKAGING [COMPATIBLE WITH BINKS GUNS]
NON-DESTRUCTIVE TO OZONE LAYER [NO CFC'S]
EASY TO APPLY TO MOLD EQUIPMENT AT ROOM TEMPERATURE
SUITABLE FOR BOTH CAST IRON AND BRONZE MOLD EQUIPMENT
PROVIDE EXTENDED TIME WITHOUT SWABBING
IMPROVE PERCENT PACK

TYPICAL PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Graphited liquid</td>
</tr>
<tr>
<td>Odor</td>
<td>Slight chemical odor</td>
</tr>
<tr>
<td>Density</td>
<td>8.9</td>
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<tr>
<td>#’s per gallon</td>
<td></td>
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<tr>
<td>Flash Point</td>
<td>None</td>
</tr>
<tr>
<td>atm d-93 PMCC</td>
<td></td>
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<tr>
<td>Net Weight</td>
<td></td>
</tr>
<tr>
<td>Aerosol</td>
<td>340 grams [0.34 kg]</td>
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<tr>
<td>‘Bulk’ Plastic Jar</td>
<td>450 grams [0.45 kg]</td>
</tr>
</tbody>
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HANDLING & PRECAUTIONS

Refer to Material Safety Data Sheet for Kleenmold Precoat 409

STORAGE LIFE

At least 12 months in a sealed container at room temperature
The application procedure of this product is extremely important as it has a direct impact on product performance. These application notes are for both the Binks gun and/or the aerosol can. The most important things to remember are that: 1. This is a water-based product so the surface to be coated has to be completely degreased and 2. A thin layer is better and will last longer than a heavy layer. If extending the time without swabbing is important, then 2 or 3 light layers can be applied.

The application procedure for the aerosol can or the ‘bulk’ plastic jars used with the Binks Gun is as follows:

**DEGREASE**
Degrease surface to be coated with a hydrocarbon or chlorinated solvent; or clean surface so that all traces of oil and grease are removed.

**MIX**
Mix product until uniform. *Aerosol*: shake can to make ball inside rattle. *Plastic Jar*: use a spatula and mix contents of jar until uniform.

**TEMPERATURE**
Apply to mold equipment at ambient or slightly elevated temperatures; 40° to 80°C (104° to 176°F). If mold equipment is warm, the drying time is reduced.

**SPRAY**
A light layer of product should be uniformly sprayed onto the mold equipment using the following techniques. When using the Binks Gun, the spray pattern and volume of product applied will need to be adjusted to fulfill the requirements below.
- keep the nozzle about 25 to 30 cm (10 to 12 inches) from the surface.
- apply a light layer of product; just enough to cover the surface.
- for a blank or mold cavity:
  • make one pass from top to bottom in the center of the cavity.
  • make another pass from top to bottom on left side of the cavity.
  • make a final pass from top to bottom on the right side of the cavity.
- for rings and other equipment, spray as possible to provide a uniform, light coating of product on the surface.

**DRY**
Allow 5 to 10 minutes for the product to “dry to the touch”. At this point the product is not cured, but is dry. You now have the following options:
- place mold equipment in a preheat oven and use as necessary.
- place equipment directly into service without preheating.
- place equipment into storage for future use.
- TO EXTEND TIME WITHOUT SWABBING: apply an additional layer of product as described above.

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