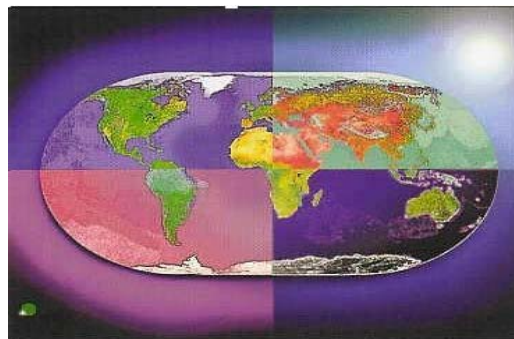


GLASS LUBE DS

TECHNICAL DATA SHEET

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DESCRIPTION

Glass Lube DS is a semi-permanent coating to be used as a preplate for blanks, molds, rings and related equipment in the glass container industry. Glass Lube DS is a water-based product composed of graphite and high temperature binders. Glass Lube DS has excellent adhesion to the mold surface providing a highly polished, durable coating. Glass Lube DS must be applied to heated mold equipment using a Binks [or equivalent] type spray gun. *Application info on reverse side.*

ADVANTAGES

WATER-BASED
START-UPS / JOB CHANGES: WITHOUT SWABBING
SMOOTH UNIFORM COATING PRODUCES SHINY WARE
CAUTION: CORROSIVE LIQUID. WEAR PROTECTIVE EQUIPMENT DURING APPLICATION.

TYPICAL PROPERTIES

Appearance	Black viscous liquid
Odor	Chemical Odor
pH	1.0 to 2.0
Density [25°C] [77°F] #s per gallon	9.72
Flash Point ASTM D-93 PMCC	None
Free Fatty Acid [%]	1.0 maximum
Net weight	480 grams

HANDLING & PRECAUTIONS

Refer to Material Safety Data Sheet for Glass Lube DS

STORAGE LIFE

At least 12 months in a sealed container at room temperature

OPERATING YOUR SHEAR SPRAY SYSTEM

SURFACE PREPARATION

Clean and degrease the surface

Oil, rust, grease, loose particles or other materials should be thoroughly removed from all surfaces to be coated. It is recommended that the surface be degreased and - or - sandblasted prior to application. Avoid finger marks and further contamination of cleaned surfaces before coating.

MIXING

Thoroughly agitate to provide uniform product

The contents of the product may settle over time to the bottom of the jar.

APPLICATION PROCEDURE

Apply in ventilated spray booth

Wear protective clothing

Mold equipment must be heated to between 40° and 80°C [104° and 176°F]

Spray both seams, then the center of the blank cavity

Apply a smooth, even coating

The mold equipment should be heated to between 40° and 80°C [104° and 176°F]. We recommend the use of a Bink's Spray Gun Model #2001SS Spray Gun with a combination of 565N Needle, 66SS Fluid Nozzle and 66SS Air Nozzle. Air pressure should be maintained between 25 to 30 PSI maximum. Blanks should be sprayed with the neck down. This will ensure that the loading zone of the blank is well coated. The product should be sprayed from top to bottom. Hold spray gun 25 to 30cm (10-12 inches) from area to be coated. Apply a thin layer of coating, allow to dry, and repeat process until light does not reflect off coated area. Coating should be 1 to 2 mils or .001 to .002 of an inch thick. **BLANK MOLDS:** Spray both seams of the blank mold first, then spray the center of the blank cavity. Spraying of the blank is completed when surface is fuzzy gray in color and will not reflect light. It is not necessary to wipe the coating down when dry. **NECK RINGS:** Remove guide ring and open neck ring so threads are exposed. Spray light coating on threads of the neck ring. Spray tops of the neck ring with the same thickness as the blanks. **BOTTOM PLATES AND BAFFLES:** Spray the same as the blanks. **FINISH MOLDS:** Spray tops of molds same as blanks. Spray a light coat on the cavity of the mold and wipe off well. Coating on the molds serves as a release agent more than a lubricant.

CURING

CURE AT 300C (572F) FOR AT LEAST 60 MINUTES BEFORE INSTALLING ON MACHINE.

CAUTION!

CORROSIVE LIQUID, N.O.S.; PHOSPHORIC ACID; UN 1760

DANGER: Avoid contact with eyes and skin. Eye or skin contact will cause burns. Wear protective goggles, gloves and clothing. Avoid breathing vapors and mist. Use with adequate ventilation.

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