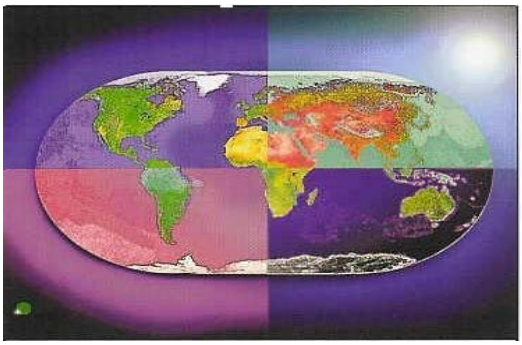
DAMCHEX 40

TECHNICAL DATA SHEET

Total Lubricants USA, Inc. – Glass Products Division
5 North Stiles Street ● Linden, New Jersey 07036-0001 USA
Tel: (908) 862-7344 ● Fax: (908) 862-5374



DESCRIPTION

Damchex 40 is a rubber-like chemical compound particularly effective for the prevention of checks on hot glassware in the finish mold. The material is supplied in block form and can be cut into pieces of appropriate size. It can also be purchased in precut pieces which are firmly secured to a sixteen-inch wooden stick. These are called Damchex Sticks. Damchex is usually applied in the finishing part of the glass forming operation, such as the blow mold or on engravings. Damchex is recommended for use on all types of bottles and in all types of forming processes.

ADVANTAGES

NON-GRAPHITED, TOUCH-UP COMPOUND
PROVIDES RELEASE AND BURNS OFF CLEANLY
EXCELLENT INSULATION CHARACTERISTICS
SUPERIOR ANTI-CHECKING PROPERTIES
IMPROVES EFFICIENCY OF THE FORMING OPERATION
COATING GRADUALLY DECOMPOSES & VANISHES

TYPICAL PROPERTIES

Appearance	Rubber-like solid
Color	Amber
Odor	Sulfur
Density [25°C] [77°F]	N/A

HANDLING & PRECAUTIONS

Refer to Material Safety Data Sheet for Damchex 40

STORAGE LIFE

At least 12 months in a sealed container at room temperature

S W A B B I N G P R O C E D U R E

APPLICATION

Damchex 40 should be applied by rubbing the interior of the mold cavity, causing it to melt and to leave a coating, which gradually decomposes and vanishes. The application is quick and is made without interruption to the glass forming process. One application to each mold cavity provides effective parting of the glass and iron without checks for a period of 15 to 20 minutes (depending on the operation), after which the application is repeated.

Damchex 40 is applied in the finishing part of the glass forming operation; such as in the blow mold of the I.S. machine or in the press mold of a press machine. It is not generally applied to a loading or performing part like a blank mold. However, this material does limited application for neck rings to help reduce checks.

ON THE MOLD SIDE

Lubricate the top of the mold so there will be no mold checks underneath the finish
Lubricate the seams of the mold so there will not be any seam checks
Lubricate by rubbing the engravings of the blow mold
Lubricate around the bottom plate and mold match to eliminate heel checks

ON THE BLANK SIDE

Lubricate the baffles - top lips of the blank and shoulder areas
Lubricate areas of the blank which correspond to defects on the bottle

IN PRESS OPERATIONS

Lubricate around the plunger
Lubricate the joints of the mold
Lubricate the ring seat of the mold
Lubricate between the plunger and the ring

Total Lubricants USA, Inc.
Glass Products Division
5 North Stiles Street
P.O. Box 1063
Linden, New Jersey 07036-0001 USA
Tel: (908) 862-7344
Fax: (908) 862-5374
www.kleenmold.com

TOTAL