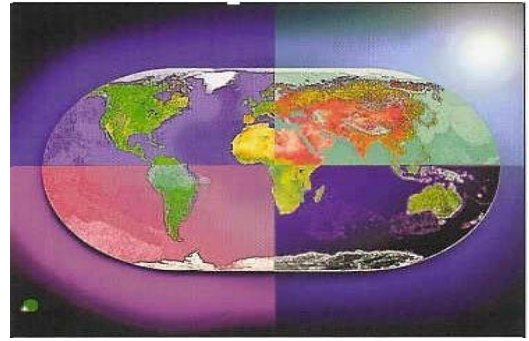


KLEENMOLD BASE 10 & CATALYST

TECHNICAL DATA SHEET

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DESCRIPTION

Kleenmold Base 10 & Catalyst is an epoxy resin/graphite mixture which is painted onto delivery equipment to facilitate the loading of a gob into a blank. Kleenmold Base 10 & Catalyst provides a low coefficient of friction surface allowing the gob to be easily and uniformly transported to the blank. Kleenmold Base 10 & Catalyst is a two component product. The 2 components are mixed together when ready for use and the mixture is painted onto the delivery equipment.

ADVANTAGES

DURABLE, LONG LASTING AND LUBRICIOUS COATING
IMPROVES CONTROL OF GOB DELIVERY TIMING
AIR CURES WITHOUT HEAT AT 20°C [68°F] IN 12 TO 24 HOURS
OVEN CURE AT 66°C [151°F] FOR 45 MINUTES
SIMPLE BRUSH ON APPLICATION AND TOUCH-UP

TYPICAL PROPERTIES

	Kleenmold Base 10	Catalyst
Appearance	Black, smooth semi-paste	Pale yellow, free flowing heavy liquid
Odor	Bland	Strong amine odor
Composition	Graphite suspended in an unreacted epoxy resin	Epoxy reactant amine catalyst
Density [25°C] [77°F]	11.7 #s per gallon	8.4
Flash Point	93°C [200°F]	G.T. 160 [320°F]

HANDLING & PRECAUTIONS

Refer to Material Safety Data Sheet for Kleenmold Base 10 & Catalyst

STORAGE LIFE

12 months in a sealed container at room temperature

APPLICATION PROCEDURE

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 sandblasted and degreased prior to application. Avoid finger marks and further contamination of cleaned surfaces before coating.

MIXING

Thoroughly mix epoxy resin and then epoxy resin/catalyst mixture

The Kleenmold Base 10 & Catalyst [epoxy resin component] should be thoroughly mixed to a uniform paste to suspend any settled material. To the thoroughly mixed Base 10 component, add the Catalyst while stirring until a uniform, smooth mixture is obtained. This may require stirring for two to four minutes.

APPLICATION PROCEDURE

Use a 2 inch (5 cm) paint brush to apply smooth, even coating

Apply within 20 to 30 minutes after mixing

Wipe off tacky residue with damp cloth after curing at room temperature

After mixing, the Kleenmold Base 10 & Catalyst mixture is ready for application and should be applied within a 20 to 30 minute period. Curing begins with mixing, with an exothermic reaction (gives off heat), and the mixture will thicken and harden after 30 minutes. The Kleenmold Base 10 & Catalyst mixture has a consistency to allow brush coating. Experience indicates that a two inch paint brush with the bristles length cut in half can be used to evenly paint the mixture onto the delivery system components. It is not necessary to brush out the coating excessively since brush marks and slight variations in thickness are acceptable. Apply the coating as thick as possible without causing it to sag or run.

IMPORTANT! After hardening or curing at room temperature, it will be noticed that the cured coating is tacky to the touch. This surface tackiness should be removed by a water rinse and sponging down of the surface leaving a hard, dull black film. When using the oven cure method, the coating does not require this water rinse.

COATING

Pass through the lehr and then sandblast

The Kleenmold Base 10 & Catalyst coating can be removed as required by passing the delivery system components through the lehr or other heating device. This will deteriorate the coating so that steel wool or glass bead blasting will readily remove it.

CLEAN-UP

Organic Cleaning Solvent

The application paint brush can be readily cleaned immediately after use and before curing by washing in an organic cleaning solvent; for example, N Methyl -2-Pyrrolidone. Hands can be washed clean with abrasive soap and warm water.

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