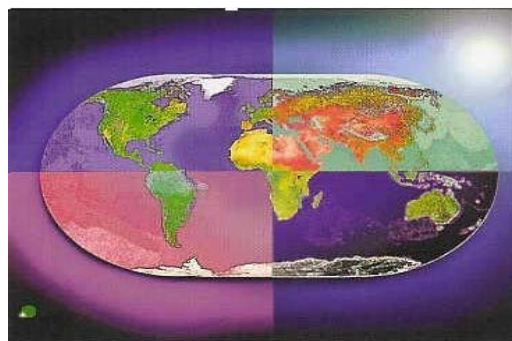


RING DOPE 46

TECHNICAL DATA SHEET

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DESCRIPTION

Ring Dope 46 is a petroleum oil and colloidal graphite based ring dope product specially designed to improve the cleanliness and to prolong the service life of the ring lubricant. This system has employed special graphite system, high temperature bonding, quick-drying carrier and glass-barrier chemicals which will promote parison to be released from mold. After being appropriately swabbed, Ring Dope 46 will dry quickly to form a uniform lubricant film. Ring Dope 46 is applied to mold by the same method as used for other ring dope products. The right way to apply, especially the degree of wet or dry of a swab, has a great impact on its performance. An appropriate swabbing approach could ensure a uniform and strong film forming in a specific time period and at a specific temperature level. Extra swabbing, too wet of a swab, will tend to produce foams and the film can not be dried in time, which can result in poor coating and extra dirty black dust. However, if a swab is too dry, it can not ensure an enough lubricant to be deposited on the mold. *Application information on reverse side.*

ADVANTAGES

EXCELLENT PENETRATION INTO RING SURFACES
NNPB, HIGH SPEED, HIGH TEMPERATURES MACHINES
PROVIDES RELEASE WITHOUT BUILD-UP
CLEAN, SHINY WARE
MINIMUM TRANSFER OF GRAPHITE
EXTENDED LIFE OF EQUIPMENT

TYPICAL PROPERTIES

Appearance	Black liquid
Odor	Sulfur & petroleum
Viscosity 40°C	132 – 282 Cst
Density [25°C] [77°F] #s per gallon	7.8
Flash Point	160°C [320°F] minimum
Components [%]	Graphite 0.5 to 1.5 Sulfur 3.0 to 5.0

HANDLING & PRECAUTIONS

Refer to Material Safety Data Sheet for Ring Dope 46

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

SWAB PREPARATION

Presoak swabs in mineral oil

Presoak enough swabs for 1 shift

Presoaking the swabs in mineral oil enables the graphite in Ring Dope 46 to easily penetrate into the swab.

This improves the efficiency of swabbing.

USE 2 SWABS PER MACHINE FOR THE BLANKS

Swab each half of the blank side of the machine with a different swab

Provides a more uniform, even distribution of product. Using only one swab usually results in some sections receiving too much dope and others too little.

LOAD SWAB IMMEDIATELY AFTER LUBRICATING CYCLE

Reload swab directly after swabbing while the swab is still hot

A hot swab makes it easier for Ring Dope 46 to efficiently penetrate into the center of the swab

ALWAYS HANG SWABS UP AFTER USE

This practice avoids swab laying in the dope tray and getting saturated with oil

Helps keep swabs properly loaded with lubricant

SWAB WITH A FAIRLY WET SWAB

Improves chance of lubricant getting into the ring

Lubricate the top of the ring to help reduce metal-to-metal friction as the blank opens over the ring

This is possible with a ring dope because the product is light and contains less graphite than a typical blank swabbing compound.

SWAB FROM THE BLANK SIDE OF THE MACHINE

Reduces possibility of contamination inside bottle

SWABBING THE RINGS

It is difficult to generalize more than above. Swabbing rings is very difficult. As machines get faster and bigger, getting the lubricant onto the rings is a challenge best left to the skill of the swabber.

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