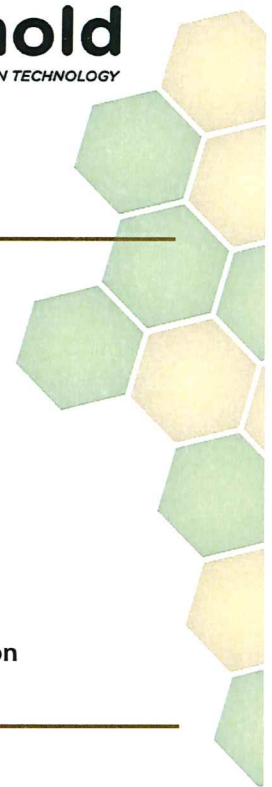


# KLEENMOLD

## Base 10 A & Catalyst

### TECHNICAL DATA SHEET



Kleenmold Base 10 A & Catalyst is an epoxy resin and graphite mixture which is painted onto delivery equipment to facilitate the loading of gobs into blanks on an IS machine. Kleenmold Base 10 A & Catalyst ensures that there is minimum friction between the gob and the delivery equipment allowing the gob to be easily and uniformly transported to the blank.

Kleenmold Base 10 A & Catalyst is a two-component product. The two components are mixed together and painted onto the delivery equipment.

#### Advantages

- Durable, Long Lasting and Lubricious Coating
- Improves Control of Gob Delivery Timing
- Simple Brush-on Application
- Air Cures at 20°C 24 Hours

#### Typical Properties

	Kleenmold Base 10 A	Catalyst
<b>Appearance</b>	Black, smooth semi-paste	Pale yellow liquid
<b>Composition</b>	Graphite suspended in unreacted epoxy resin	Epoxy reactant amine catalyst
<b>Density [25°C / 77°F]</b>	1,3 g/cm <sup>3</sup>	1,0 g/cm <sup>3</sup>
<b>Flash Point</b>	190 °C	160 °C

#### Handling & Precautions

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

#### Shelf Life

36 months in a sealed container at room temperature



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# APPLICATION PROCEDURE

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## 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 stir epoxy resin and then epoxy resin/catalyst mixture.

The Kleenmold Base 10 A & Catalyst (epoxy resin component) should be thoroughly stirred to a uniform paste to suspend any settled material. Add the Catalyst to the thoroughly stirred Base 10 A component and stir until a uniform, smooth mixture is obtained. This may require stirring for 2 to 4 minutes. We recommend using an electric stirrer. Mixing two parts result in an exothermic reaction that generates heat. So please do not close the lid of the jar that holds the two parts mixture. It can be dangerous if closing the lid after mixing the two parts.

## APPLICATION PROCEDURE

After mixing, the Kleenmold Base 10 A & Catalyst mixture is ready for application.

Curing begins with mixing, with an exothermic reaction (gives off heat), and the mixture will thicken and harden after 30 minutes: **the product should be applied within a 20 to 30 minute period after mixing.** Kleenmold Base 10 A & Catalyst mixture has a consistency to allow brush coating.

Experience indicates that a **2-inch (5 cm) 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 a smooth, even coating, as thick as possible without causing it to sag or run.**

**Application should be along loading direction.**

**Cure at room temperature for min 24 hours at 20°C (lower room temperatures need longer curing. We recommend oven curing during cold winter temperatures).**

## COATING REMOVAL

The Kleenmold Base 10 A & Catalyst coating can be removed by heating the delivery equipment to about 300 °C. This will deteriorate the coating so that steel wool or sand blasting can easily remove it.

