

KLEENMOLD 202

TECHNICAL DATA SHEET



Kleenmold 202 is a swabbing compound containing graphite, sulfur and proprietary additives. Kleenmold 202 is designed for high temperature, high speed applications using the NNPB process. It is recommended for amber, flint and green glass bottles. Kleenmold 202 is designed to provide long swab cycles. Recommend using a very dry swab application due to the heat and speed of IS Machine. Kleenmold 202 can be used on all process areas on the IS Machine including the Blank, Neck Ring, Mold, Bottom Plate, etc.

Advantages

- High temperature stability
- Long swab cycles
- Easy gob loading
- Excellent parison release
- Minimum transfer of graphite
- Clean, shiny ware
- Extended life of blank and mold equipment

Typical Properties

Appearance	Black, viscous liquid
Density [25°C] [77°F]	0,96 g/cm ³
Viscosity [25°C] [77°F] Brookfield CPS, #4 LV Spindle, 30 sec.	7200 - 8000
Flash Point	>160°C (320°F)

Components (%)

Graphite	4,5 - 5,5
Sulfur	3,0 - 4,0

Handling & Precautions

Refer to Material Safety Data Sheet for Kleenmold 202

Shelf Life

18 months in a sealed container at room temperature



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APPLICATION PROCEDURE

SWAB PREPARATION

We recommend presoaking swabs in mineral oil.

This improves the efficiency of swabbing.

Presoak enough swabs for one shift.

Presoaking the swabs in mineral oil enables the graphite in Kleenmold to easily penetrate into the swab.

USE TWO SWABS PER MACHINE FOR 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 Kleenmold to efficiently penetrate into the swab.

ALWAYS HANG SWABS UP AFTER USE

This practice avoids swabs laying in the dope tray and getting saturated with oil. This helps keep swabs properly loaded with lubricant.

SWAB FROM TOP TO BOTTOM

Provides a smooth, even film of graphite each time you swab.

Swabbing up and down, or in a random fashion, will yield an inconsistent film and reduce performance.

GOLDEN RULE OF SWABBING

Dry Swab more often; better than wet swab less often.

Using a dry swab will keep your machine running smoothly and trouble-free.

It will extend blank life and produce defect-free bottles.



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