HIPAK® Glass Release Coating

HIPAK glass release coating is a durable solid film lubricant used on the glass-contacting surfaces of forming machine tooling. It is sprayed on rings, blanks, baffles, moulds, bottom plates, plungers, thimbles, and funnels before installation on the glass-forming machine.

This <u>waterbase</u> material consists of special binders and high temperature release agents. The resultant solid coating is smooth and abrasion resistant. *Molten glass does not adhere to the coating, resulting in a container that has an excellent, contamination free finish.*An improvement in the percent pack can often be realized as a result of a reduction in ware loss due to less frequent swabbing.

There are also benefits in cycle life of the forming machine tooling; since less swabbing compound is applied, tooling can be used for a longer period of time before replacement.

Economic Benefits

- Improves percent pack.
- · Longer tool life.
- · Reduces tooling turnover.
- · Reduces swab material.
- Tools are easier to clean.
- Improves wall uniformity.
- Swab cycle up to 10 times longer.

- Improves mould temperature distribution.
- Eliminates tool polishing.
- Higher internal bottle pressures.
- Not an acid. Does not attack tooling or equipment as some pre-coats do.

Additional Benefits

- Less than 30 minutes to apply, cure and install on I.S. machine.
- Inhibits rusting during storage.
- 1-year shelf life for coated tooling and coating chemical.
- Can be used on tools cleaned by electroetch caustic solution or shot peening.
- Permits operator to perform other functions besides swabbing.

Safety and Health Benefits

- Less operator inhalation of smoke and oil fumes.
- Less operator exposure to moving machinery, noise and heat.
- Waterbase coating system, not acid or silicone.
- Less in-plant pollution.

HIPAK® Glass Release Coating (cont'd)

- 1 ltr , 1 qt. amber beer, Alcoa top
- 32 oz. soft drink, Alcoa top
- Glass capsules and perfume flasks
- 4/5 & Quart liquor bottle
- Pint wide-mouth jar
- Quart wide-mouth jar
- One gallon wine bottle

- Schweppes bottle
- 'Mae West' type bottle
- One liter fruit juice bottle
- Two liter fruit juice bottle
- 750ml & liter wine bottle

Experiences of a One Year Study

10,12,& 16 oz.

N.R. soft drink,

crown top

- Average pack increase of 2% on variety of containers.
- Mould, baffles, bottom plates and funnel life, 3-5 days with no swabbing.
- Ring life of 3-5 days: Crown finish swabbed on 60-120 minute cycles
- Alcoa finish swabbed on 30-60 minute cycles.
- Blank life of 3-5 days swabbed on 1-4 hour cycles.

Ease of Use

Before coating, the forming machine tooling is sandblasted or glass peened, but need not be polished. The coating is applied on room temperature tooling with a conventional spray gun. Application should only be done in a spray booth. After coating, the parts may be air dried at room temperature or during the normal pre-heating of the tooling. For best results, the coated parts should be heated to above 150°C for 20 to 30 minutes. The desired coating thickness is 0.0005 to 0.002 inches (.013 to .051 mm).

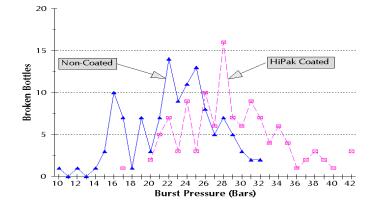
HIPAK remains effective for approximately 24 hours without swabbing. Coating life can be extended 3 to 5 days by periodic, light swabbing with most nonsmoking or oil based swabbing compounds. Although HIPAK bonds firmly in normal use, a misapplied or damaged coating may be removed with water and re-applied.

After coating the tooling avoid contact with water, such as that from shear spray or delivery chutes.

Bonus: Burst Pressure Increased with HIPAK Coated Moulds

Somec Containers

3551 W 1ST Street Sanford, FL 32771 Phone 407-831-7766 Fax 407-831-7303 SomecContainers.com



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