

# BONDERITE L-FM 51SC ACHESON

Known as Glasdag 51 SC  
June 2016

## PRODUCT DESCRIPTION

BONDERITE L-FM 51SC ACHESON provides the following product characteristics:

<b>Technology</b>	Lubricant
<b>Product Type</b>	Glass mould swab lubricant
<b>Application</b>	Glass manufacturing

BONDERITE L-FM 51SC ACHESON Start-up coating is a solvent based coating for mould equipment used in the manufacture of glass containers.

Pretreatment of moulds with BONDERITE L-FM 51SC ACHESON produces a long lasting, bonded coating with excellent lubrication and release properties.

This eliminates the need for frequent swabbing during the start-up period following a mould change.

The coating assists gob loading, mould filling and improves glass distribution. It eliminates the rejects caused by excessive swabbing and reduces lubricant consumption.

The advantages of BONDERITE L-FM 51SC ACHESON treatment extend beyond the start-up stage.

The bonded coating supplements the swab lubricant over a prolonged period.

Less lubricant is required and better quality glassware is produced.

The treatment is recommended for blank moulds, neck rings, bottom plates, baffles and funnels. It is also beneficial to treat locating areas such as dovetails and all outer surfaces of neck rings.

### Special features

#### - Improved production efficiency

Fewer rejects due to excessive swabbing during start-up.  
Fewer rejects due to loading defects.

#### - Less damage to mould

Better filling reduces jamming which damages mould equipment and delays production.

#### - Better quality glassware

Improved glass distribution increases strength.

#### - Time saving

Operator has more time for duties other than mould swabbing.

### Application Areas

BONDERITE L-FM 51SC ACHESON is used for glass mould lubrication by means of a semi-permanent coating.

## DIRECTION OF USE

### Preliminary Statement

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

### Preparation

BONDERITE L-FM 51SC ACHESON is supplied ready-for-use but should first be thoroughly shaken or stirred. The coating procedure is relatively simple but the following directions must be applied to obtain optimal results.

### Pretreatment

The surfaces to be coated must be cleaned down to bare metal by either a wet or dry abrasive blasting process and thoroughly degreased.

Do not touch the cleaned surfaces prior to application of the coating or adhesion may be affected.

### Application

For coating blank mould cavities a spray gun adjusted to give a fan pattern and having a 1.5 to 2 mm nozzle is required. It is important to use an air pressure of exactly 1.4 bar (20 psi). Normal paint spray equipment may be suitable if adjusted to produce a very fine spray. The recommended coating thickness is 0.06 mm (.002. inch). Heavier coatings may peel off when the components are heated.

1. Adjust the gun setting to give a horizontal fan pattern. For spraying neck rings and other small components a conical pattern gun setting is more suitable.
2. Reduce liquid throughput to a low level with air pressure set to 1.4 bar (20 psi).
3. Apply the first spray pass along the centre line of the cavity keeping the spray distance about 18 cm. Apply a further spray pass to the left and then to the right of the centre line to achieve a uniform coating over the whole cavity. When coating narrow cavities two spray passes may be sufficient to achieve even coverage.
4. To avoid settling during spraying shake the contents of the spray cup at halfhourly intervals.

**Important:** The coating should have a smooth wet appearance immediately after spraying. This helps to achieve a bright surface on the glassware.

Allow the coating to air dry for at least 15 minutes then bake the components for at least 1 hour at 300°C or 30 minutes at 400°C. Timing should commence after the components have reached oven temperature.

### Shelf-Life

- 12 months from date of qualification under original seal.

**Classification**

Please refer to the corresponding **Material Safety Data**

**Sheets** for details on:

- Hazards identification**
- Transport information**
- Regulatory information**

**ADDITIONAL INFORMATION****Disclaimer****Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.0