GLASS MOULD LUBRICANTS

There are, currently, two primary methods of making a glass container — the *blow and blow* method and the *press and blow* method. In both cases a stream of molten glass, at its plastic temperature (1050°C-1200°C), is cut with a shearing blade to form a cylinder of glass, called a *gob*. Both processes start with the *gob* falling, by gravity, and guided, through troughs and chutes, into the blank moulds. In the blow and blow process, the glass is first blown from below, into the blank moulds, to create a *parison*, or pre-container. The*parison* is then flipped over into a final mould, where a *final blow* blows the glass out, in to the mould, to make the final container shape. In the case of *press and blow* process, the*parison* is formed with a metal plunger, which pushes the glass out, into the blank mould. The process then continues as before, with the *parison* being transferred to the mould, and the glass being blown out into the mould.

Oxeeco's grade "**Lubricote-X 9**" gives better mould lubrication of glass bottle moulds.

OIL BASE								
PRODUCT	**Lubricant**	**Viscosity (CPs at 25°C)**	**Particle size microns**	**Specif Gravity (gms/cc)**	**Diluent**	**Flash Point ºC**	**Application**	**Packing (kgs)**
LUBRICOTE-X 9	Graphite	4000-6000	1 - 3	0.90-1.00	Oil	130-150	As mould lubrication of glass bottle molds. Apply by swabbing.	25
LUBRICOTE-S 9	Graphite	850 – 900	3 - 5	1.15-0.95			Dry film coating on scoops / throughs deflectors for long life lubrication.	1