



## **BASIC SMALL SCALE APPLICATION INSTRUCTIONS FOR GLASS PACKAGING & CONTAINERS**

### **Basic Resources Needed:**

- Pneumatic paint spray gun
- Protective outerwear, such as masks, safety goggles and clothing
- Air compressor
- Industrial oven or similar heating source
- Industrial mixer
- Need a relatively dust free environment with good ventilation.
- Thermo coupler or other temperature gauge

### **Preparation:**

- Product must be blended thoroughly with industrial mixer before applying.
- Glass container must be clean and free of any cold-end coating, such as lubricants or anything that might impair or affect the adhesion of the coating.
- Recommended protective outerwear, including dust mask, safety goggles, paint suit etc.
- Ideal air pressure as tested for air compressor is 50 – 55 psi.
- Drain all condensation from air compressor line prior to the application process.
- Apply in well ventilated area, properly protective barriers to catch overspray.

### **Application Process:**

- Begin by applying product through pneumatic paint spray gun on a spare piece of glass to gauge flow of product. ***Please note that each paint spray gun will differ and may require proper tuning for optimal results.***
- Start spraying product to glass container(s) evenly and uniformly in one continuous motion. If product begins to drip, coating has been applied too thick and spray volume should be reduced by spraying individual bottles faster.
- Do not touch the containers after being sprayed as it can alter the appearance of the coating.

### **Curing:**

- Carefully place all coated glass containers into heating source without altering the coating, which can be done by inserting a tool into the top of container and transporting it that way.
- Recommended curing temperature minimum of 375° Fahrenheit (190.55° Celsius) for a period of 2 minutes. ***Please note that each heating sources' thermal capabilities will vary and proper curing temperatures must be evaluated by the surface temperature of the glass rather than by the heating devices' temperature.***
- After glass containers have reached 375° Fahrenheit (190.55° Celsius) for 2 minutes, allow them to cool to room temperature slowly before removing.