



# Can Approval

## Evaluation of Conveyor Lube H1

This document outlines the evaluation of Conveyor Lube H1 (Tribolube) in-conjunction with Aquabase 105-152.007 and Aquabase 100-101.346 overprint varnishes.

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Report number 2P4-128

**Evaluation of Conveyor Lube H1 (Tribolube) in-conjunction with Aquabase 105-152.007 and Aquabase 100-101.346 overprint varnishes**

**Objective**

To evaluate the effect on Conveyor Lube H1, (Tribolube) on the applied film performance of both Aquabase 104-152.007 and Aquabase 100-101.346 overprint varnishes.

**Application**

Panel is cut from commercial cans (ex Rexham Wakefield) externally coated with either Aquabase 105-152.007 or Aquabase 100-101.346 were immersed in Conveyor Lube H1 for 7 days at room temperature.

After immersion the test panels were evaluated for film performance alongside their respective controls. (The control samples had not been subjected to any immersion tests).

**Conclusions:**

1. Cans coated with Aquabase 105-152.007 which have been immersed in Conveyor Lube H1 for 7 days have generally given excellent results. However, some loss of 60° gloss and a very slight reduction in the overstone cure tolerance was upon evaluation compared to the control. Despite these slight differences in film performance, the Aquabase 105-152.007 has good resistance to chemical attack under severe test conditions.
2. When Aquabase 105-152.007 is exposed ton Conveyor Lube H1 for 7 days; some softening of the applied varnish film is seen. This is seen in a reduction of the pencil hardness & IBO cure compared to the non immersed control. As with Aquabase 105-152.007 some loss of gloss is seen after immersion in the track lubricant.

**Comments**

A seven day time period for immersion of the two coatings was far in excess of the contact that would normally be made between the varnished o& Conveyor Lube H1. The results may therefore be slightly worse than what would be experienced under normal operating conditions.

**Actions**

Dave Collins to report results to Rexham Wakefield plant.

## Systems Evaluated

Conveyor Lube H1                      Tooling lubricant supplied to ICI packing

33cl aluminium cans commercially coated cans from Rexham Wakefield with either

- (a) Aquabase 105-152.007
- (b) Aquabase 100-101.346

### **Aquabase 105 (152.007) cans**

Label design    “Coca Cola World Partner”  
Date Code        2W43G26A

### **Aquabase 100 (101.346) cans**

Label design    “Dorada Pilsen”  
Date Code        2W42G27A

## Test Protocol

Test panels immersed in Conveyor Lube H1 for 7 days at room temperature. After 7 days removed from lubricant and evaluated alongside non immersed controls.

Test	Aquabase 105-152.007		Aquabase 101-101.346	
	Control	Immersed panel	Control	Immersed panel
Ink smudging	N/A	None	N/A	None
Ink colour taint of Conveyor Lube	N/A	None	N/A	None
Altek slip 2kg weight	0.05 – 0.06	0.05 – 0.06	0.05 – 0.06	0.05 – 0.06
MEK cure (DR)	100+	100+	100+	63 – 85
Adhesion (sidewall) Joy 95°C/30'	>7H	>7H	6H	6H
60° Gloss	0	0	0	0
MEK cure 220/10' overbake	100+	82 - 100	10 - 12	6 - 8