



ISO 9001:2008  
Certified Company

Zahabiya SEAM DOPE SD-04 is a gummy dope possessing excellent film forming properties, which on perfect drying will provide an airtight double seam of the container's ends. Basically formulated by vinyl resins & other polymers, it is a thick viscous gum, almost transparent on perfect drying. The dried film is non-brittle and non-sticky to touch, Non-toxic, Non-poisonous and Non-rusting to tin plate (tin plate of standard tin coating); provided as supplied and as per advised application procedure.

ZSD-04 is being reliably used as an economical film former sealant during the fabrication of tin cans to prevent any possible leakages of the contents to be filled in. Suitable for rectangular, oblong or round can body ends for a very wide range of products. It is available in two different grades according to the nature of the contents to be packed in:

GRADE	CONTENTS TO BE FILLED
SD-042 (Super)	lube oil, edible oil, ghee, grease, paints, varnishes, lacquer, petroleum solvent cans.
SD-043 (Special)	In addition to above, suitable for cans made to fill water based products, food products, syrups, thinner, solvents, pesticides / insecticides and other medium corrosive products.

These grades are formulated only from raw materials that comply with the USA Food and Drug Administration (FDA) regulations, CFR Title 21 part 175.300 (b) (xxxi) Resinous and Polymeric Coatings; Can End Cements (Sealing Compounds).

COLOUR:	Bluish / Milky white in liquid state. Transparent in thin dried layers.
ODOUR:	Resinous smell in liquid state. No remarkable smell after drying/curing.
DENSITY:	SD-042: 1.15 kg/litre. [ASTM D1475] SD-043: 1.20 kg/litre.
NON-VOLATILE:	SD-042: 27% w/w. [ASTM D2369] SD-043: 30% w/w.
DRYING:	Air Drying - thin film dries up within 15 minutes in normal ambient conditions.
SERVICE TEMPERATURE:	Can be used between 6°C to 85°C (substrate surface temperature).
BEHAVIOUR:	The properly cured film is soft, flexible, non-cracking, fuel, oil, grease, solvents & other hydrocarbons resistant etc. The resistance properties of SD-043 is far better than that of SD-042.
APPLICATIONS:	Seam Dope is used during can manufacturing on the previously flanged body before seaming operation in a simple way. Before the top/bottom seaming operation, it is applied to the flanged edges, by <u>surface application or by stamp transferred method</u> .  Seam Dope is poured on to a felt/ polyurethane or rubber foam of about 6mm thick, placed in a wooden, plastic or stainless steel tray of size slightly bigger than that of the flanged can body, so that the foam fits the tray completely and is adequately soaked in the compound. The flang of the can body is then firmly placed on to the foam so that the dope is transferred evenly. The doped flange is then positioned on the previously lined & curled top/bottom and the seaming operation is carried out. Repeat the same process for can's other end.  Ensure that the previously applied lining compound on top/bottom curled area is completely dried (cured) before these ends come in contact with Seam Dope applied edges. Do not use galvanised metal, tin plate or iron sheet tray to store the Seam Dope. Use wooden, plastic/P.V.C. or stainless steel tray for satisfactory results. Use dry and clean tray for to achieve the best performance of the product.
DILUENT:	Avoid Dilution. If necessary, dilute it with previously boiled hot potable water only, not more than 3% by weight.
SAFETY:	Non-Flammable, Safe in Handling, Non-Rusting, Non-Toxic and perfectly Safe for edible products. A "Human Friendly/ Environmentally Acceptable Product".
STORAGE/ SHELF-LIFE:	To be stored in air tight, secured capped containers, at well ventilated place; away from heat & sun, preferably between 25°C to 30°C. Use within <u>one year</u> from the supply date to ensure best results.

IMPORTANT NOTICE:

The Information & Data contained herein are correct to the best of our knowledge, tests and experience. These are presented in good faith to the users. The recommendations and suggestions mentioned are made without guarantees or representations as to the results. The Consumer should satisfy himself as to the suitability of the product for the intended purpose and use. WE ASSUME; NO LIABILITY for damages of any kind and the user accepts the product 'as is' and without any other warranties, expressed or implied. Our warranty is limited to the replacement of so proved defective Zahabiya original product only, provided used within shelf life as supplied originally.