

POXYLUBE® #800

HEAT CURING
PTFE MODIFIED COATING
SERIES E883



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GENERAL DESCRIPTION

Sandstrom **POXYLUBE® #800** Dry Film Lubricant is a single component epoxy formulated with PTFE to provide excellent lubrication, fluid resistance, and corrosion protection. This **Heat Cured** material prevents corrosion, galling, seizing and fretting.

Excellent **Corrosion Protection** and ease of application are its outstanding characteristics. **SANDSTROM POXYLUBE® #800 CONTAINS NO GRAPHITE.**

Once Sandstrom **POXYLUBE® #800** has been applied to a properly prepared surface and allowed to cure, it is virtually unaffected by atmospheric and fretting corrosion, solvents, acids, oils and degreasers. **POXYLUBE® #800** can be applied to all metallic and nonmetallic surfaces by spray or dip application.

Complete application instructions are on the reverse of this sheet.

FEATURES/BENEFITS

- Provides excellent lubrication
- Provides heavy duty service as an exterior protective coating for all metals including magnesium
 - Offers resistance to chemical corrosion, solvents, abrasion, impact
 - Exhibits good thermal stability

COMPOSITION AND PHYSICAL PROPERTIES

NET WEIGHT PER GALLON	8.0 ± .4 lbs	COLORS	Clear, Black, Tile Red and Green
SOLIDS CONTENT (By Weight)	24.0 - 32.0%	SHELF LIFE	1 year from date of shipment
VISCOSITY (#1 Zahn @ 77°F)	30 - 40 seconds	VEHICLE TYPE	100% Epoxy
OPERATING TEMP. RANGE	-320°F to +400°F	LUBRICATIVE PIGMENT	PTFE
CORROSION PROTECTION (5% salt fog @ .0005" film thickness over zinc phosphated steel)	500 hrs.	VOC (Theoretical)	5.74 - 5.85 lbs/gal

NOTICE

Before using this product, read all warnings and safety information printed on the label, the Material Safety Data Sheet, and the Technical Info-Guide

GENERAL

For maximum service, the **APPLICATION INSTRUCTIONS MUST BE CLOSELY FOLLOWED**. The lubricant is flammable and the safety precautions usually followed when using flammable materials must be observed.

COVERAGE

One gallon of this material will theoretically cover 575 sq.ft. with a dry film thickness of .0005 inches. Coverage depends upon methods of application and other variables, such as, overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION

The following surface preparations are recommended for the individual metals listed to develop maximum adhesion, wear life, and corrosion protection. Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

STEEL - Degrease using naphtha meeting the requirements of FED spec TT-N-95; grit blast (25-50 rms optimum); remove grit blast debris from surface; zinc phosphatize (1100-1400 milligrams per sq. ft.).

STAINLESS STEEL - Degrease using naphtha meeting the requirements of FED spec TT-N-95; grit blast (25-50 rms optimum); remove grit blast debris from surface; passivate.

ALUMINUM - Degrease using naphtha meeting the requirements of FED spec TT-N-95 ; anodize (hot water or nickel acetate seal only) or hard coat and seal.

TITANIUM - Solvent wash (non-chlorinated) and alkaline anodize; (Tiodize Type I or II).

COPPER ALLOYS - Degrease using naphtha meeting the requirements of FED spec TT-N-95; then pretreat using one of the following methods (in order of preference).

- a) Black oxide treat (according to MIL. Spec. MIL-F495C)
- b) Bright dip, or grit blast (25-50 rms optimum)

IMPORTANT! AVOID TOUCHING THE SURFACES TO BE COATED WITH THE FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING. Whenever possible treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING

IMPORTANT! THIS LUBRICANT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND **CONTINUOUSLY** DURING APPLICATION

THINNING

Conventional spraying: Reduce sparingly with MEK.
Dipping: Not necessary, but can be reduced sparingly with PMA.

APPLICATION

Sandstrom **POXYLUBE® #800** should be sprayed or dipped to the desired film thickness (usually .0003 to .0007 inches).

CURING

Allow parts to flash off **at least** 30 minutes before baking. **POXYLUBE® #800** can be cured according to the following schedule:

- 60 minutes @ 300°F or
- 25 minutes @ 350°F or
- 20 minutes @ 375°F or
- 15 minutes @ 400°F.

Note: Start time when parts reach temperature. **Important to keep container of POXYLUBE® #800 closed when not in use to keep loss of solvents at minimum and avoid change in volume solids.**

CLEANUP

Use the same solvents for cleaning tools as are recommended for thinning or use MEK.

REMOVAL OF SANDSTROM POXYLUBE® #800

In the event it is necessary to remove **POXYLUBE® #800** , physical removal is best (such as grit blasting, sanding or grinding).

*Strict compliance to the instructions given in Surface Preparation and Stirring and Curing is essential to obtain optimum results.

POXYLUBE® #800 PTFE Modified Coating passes the fluid resistance tests specified in MIL-PRF-46147C.

WARNINGS: Constant stirring is imperative for best results.
Caution: Flammable. Keep away from heat, sparks, and open flame. Use with adequate ventilation.
Avoid prolonged breathing of vapors.
If swallowed, DO NOT INDUCE VOMITING--call physician immediately.
Contains METHYL ETHYL KETONE

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY

We warrant our products to be free of manufacturing defects, and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and is accurate to the best of our knowledge. They are based on technical data which we believe to be reliable, and are intended for use by persons having skill and "know-how," at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. **NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED, OR THE RESULTS OBTAINED FROM IT'S USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT.** Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders or other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. © 2/198 SANDSTROM PRODUCTS COMPANY 7/30/02