



# HYBRID EPOXY COATING

PTFE / EPOXY COATING: AMBIENT CURE

SERIES E355

TWO-COMPONENT



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## DESCRIPTION

Sandstrom's Hybrid Epoxy Coating, Series E355 is a low-gloss, two-component PTFE coating. This coating displays exceptional toughness, mar resistance, and enhanced lubricity for a wide range of applications requiring an ambient, or air dry, cure.

## OUTSTANDING FEATURES/BENEFITS

- Toughness
- Mar resistance
- Chemical resistance
- UV resistance
- Ambient cure for applications where baking is not practical
- Isocyanate-free

## LIMITATIONS

- Store at temperatures below 100°F.
- DO NOT FREEZE.
- Mixed product has limited pot life.

## NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS), and Technical Data Sheet.

## TYPICAL USES

- Internal and external components weapons coating
- Escalator baseboard coating
- Applications where benefits of a high performance heat cured epoxy or urethane coating are desired but where baking is not practical or available

## COMPOSITION AND PHYSICAL PROPERTIES (OF MIXED PRODUCT)

<b>Net Weight per gallon</b>	9.13 ± 0.2 lbs. (Theoretical)	<b>Lubricating Pigment</b>	PTFE
<b>Weight Solids</b>	58.76% (Theoretical)	<b>Color</b>	Matte Black
<b>VOC + water</b>	3.73 lbs./gallon (Theoretical)	<b>Gloss</b>	Low Gloss: ≤ 25 gloss units at 60° ± 5°
<b>Mix Ratio</b>	Component A:1 part Component B:1 part	<b>Pot Life</b>	6 hours
<b>Viscosity (A+B)</b>	80 ± 5 KU's Stormer Viscosity @ 77°F	<b>Cleanup</b>	MEK
<b>Shelf Life</b>	12 months from Date of Manufacture		
<b>Storage Conditions</b>	Between 40°F to 100°F		
<b>Coverage Rate *</b>	825 sq. ft./gal @ 1.0 mil		
<b>Dry Film Thickness</b>	1.0 - 2.0 mil		

\* Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

## PERFORMANCE AND FUNCTIONAL PROPERTIES

<b>Chemical/Fluid Resistance:</b>	<b>Corrosion Protection:</b>	
<i>MIL-PRF-46147 Table I Immersion Fluids, including Solvents, Hydraulic Fuel, Turbine Fuel, Lubricating Oils and Damping Fluid</i>	<i>ASTM B117: Steel B1000 P90 Panel</i>	500 hrs.
ASTM D2510A ASTM D2510C	Pass Pass	<b>Operating Temperature Range</b>
<i>Shooter's Choice MC#7 Bore Cleaner</i>	Pass – 24 hours	<b>Taber Abrasion</b>
		60.4 mg / 1000 cycles <i>Ambient cure – 7 days</i>

**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 are accurate to the best of our knowledge. They are based on technical data 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 ITS 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 of 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. SANDSTROM PRODUCTS COMPANY

**GENERAL**

For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

**COVERAGE**

One gallon of this material will theoretically cover 825 sq. ft. with a dry film thickness of 0.001 inches. Coverage depends upon method 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**

Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

**Application on steel.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Phosphate IAW MIL-DTL-16232 (weight should be 11-22 g/m<sup>2</sup>), type M, class 3 (optimal performance) or type Z, class 3.

**Application on stainless steels.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Passivate surface with ASTM A967, types nitric 1, nitric 2 or nitric 3, as applicable.

**Application on aluminum and aluminum alloys.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Sulfuric acid anodize IAW MIL-A-8625 and seal surface with hot deionized water (>180°F for 30 minutes).

**Application on titanium and titanium alloys.** Degrease surface to be coated with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum) and alkaline anodize.

**Application on copper and copper alloys.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Form a black oxide finish on surface.

**IMPORTANT! DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.** Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

**STIRRING**

Before mixing Components A and B, shake Component B vigorously until any sedimentation is re-suspended.

**THINNING**

**For conventional spray** – By volume, mix 6 parts coating to 1 part D117-C01 Thinner.

**APPLICATION**

Product should be sprayed (not dipped) to the desired film thickness (usually 0.001 to 0.002 inches). Allow the surface to dry **at least** 24 hours before doing light assembly work.

It is important to keep container closed when not in use to keep loss of solvents at a minimum and avoid a change in volume solids.

Note: All instructions are based on product and part temperatures of 77°F ± 5°F and <70% relative humidity. Should product need temperature adjustments, use a hot or cold water bath.

**DRYING/CURING**

Product should be air dried. Allow at least 24 hours @ 77°F ± 5°F and ≤70% relative humidity before putting into service.

**Product will reach full cure with full performance properties at 7 days.**

**WARNING: LOW HUMIDITY MAY CAUSE A DELAY IN ACHIEVING FULL CURE AND ADDITIONAL CURING TIME MAY BE NECESSARY.**

**CLEANUP**

Use MEK for cleaning tools.

**REMOVAL**

In the event it is necessary to remove product, use MEK.

**DANGER! USE WITH ADEQUATE VENTILATION.**

\*\*\*Strict compliance to the instructions given in Surface Preparation, Application and Curing is very essential for obtaining optimum results.\*\*\*