



# POXYLUBE® #890

SOLID FILM LUBRICANT: HEAT CURE

SERIES E890

FEP MODIFIED RELEASE COATING



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## DESCRIPTION

Sandstrom Poxylube #890 Dry Film Lubricant is a single component epoxy formulated with FEP to provide lubrication, fluid resistance and release properties.

Once Poxylube #890 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 #890 can be applied to all metallic and nonmetallic surfaces by spray.

## OUTSTANDING FEATURES/BENEFITS

- Hardness, slip and release
- Offers resistance to solvents, abrasion and impact
- Exhibits good thermal stability

## LIMITATIONS

- Store at temperatures below 100°F.

## Typical Uses

- Mold release coating

## NOTICE

**Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet and Technical Data Sheet. The properties listed on this sheet are not intended for use as a specification. Please contact our Technical Service Team.**

\*\*Refer to our website for answers to common questions:\*\*

<https://www.sandstromproducts.com/resources/FAQs/>

## COMPOSITION AND PHYSICAL PROPERTIES

<b>Net Weight per gallon</b> <i>ASTM D1475</i>	8.0 ± 1.0 lbs./gallon (Theoretical)	<b>Vehicle</b>	Epoxy
<b>Weight Solids<sup>^</sup></b>	43.0 ± 2.0%	<b>Lubricating Pigment</b>	FEP
<b>Volume Solids</b>	30.0 ± 2.0% (Theoretical)	<b>Color</b>	Black
<b>VOC + water</b>	5.0 ± 0.5 lbs./gallon (Theoretical)	<b>Shelf Life</b>	4 Months from Date of Manufacture
<b>Odor</b>	Strong Solvent	<b>Storage Conditions</b>	40°F to 100°F
<b>pH</b>	Not Applicable	<b>Freeze/Thaw Stability</b>	Stable
<b>Viscosity<sup>^</sup></b>	200 – 600 cps @ 77°F #3 at 50 rpm, Brookfield Viscometer	<b>Flash Point</b>	21°F (Theoretical)
<b>Coverage Rate<sup>*</sup></b>	1050 sq. ft./gallon @ 0.5 mil DFT		
<b>Recommended Coats</b>	1		
<b>Dry Film Thickness</b>	0.3 – 0.7mils		

\*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.  
<sup>^</sup> Property tested with each production batch.

### 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. This product is flammable and the safety precautions followed when using any flammable material must be observed. See product Safety Data Sheet.

**FILM THICKNESS & ENGINEERING TOLERANCE**

As supplied, this product will yield a film thickness of about 0.0005 inches per applied coat. Usually engineering tolerances will permit necessary minimum film buildup of 0.0003 to 0.0007 inches without interference. Whenever possible, the proper tolerances should be designed into the part.

**COVERAGE**

One gallon of this material will cover 1050 sq. ft. with a dry film thickness of 0.0005 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**

Please contact Sandstrom Products Company for substrates not listed or 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**

**IMPORTANT! THIS COATING CONTAINS HEAVY PIGMENTS WHICH SETTLE RAPIDLY. THEREFORE, IT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND CONTINUOUSLY DURING APPLICATION.**

**THINNING (RECOMMENDED RATIOS)**

For fast dry reduce up to 2 parts coating to 1 part PM Acetate.

**APPLICATION**

**For spraying** – Product should be sprayed (not dipped) to the desired film thickness (usually 0.0003 to 0.0007 in.).

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.

**BAKING**

Product must be heat cured. Allow parts to flash off for at least 30 minutes at 77°F ± 5°F and ≤70% relative humidity, then bake for 60 minutes at 250°F.

**IMPORTANT!** The time starts when **the part** reaches temperature, not when placed in a Class A oven.

**CLEANUP**

Use the same solvent recommended for thinning or MEK.

**REMOVAL**

In the event it is necessary to remove product, physical removal is best (such as grit blasting, sanding or grinding).

**WARNINGS:** Frequent stirring is imperative for best results.

**DANGER! USE WITH ADEQUATE VENTILATION.**

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