



POXYLUBE® #835

SOLID FILM LUBRICANT: AIR DRY

SERIES A500

WATERBORNE, PTFE



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DESCRIPTION

Sandstrom Poxylube® #835 is an environmentally safe coating to apply when VOC restrictions, part size or substrate composition prohibit the use of Sandstrom solvent-borne and/or heat-cured Poxylube® PTFE products.

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.

OUTSTANDING FEATURES/BENEFITS

- Provides excellent surface slip lubrication
- Easy clean up with soap and water
- Environmentally safe
- Exhibits good thermal stability

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon	9.3 - 9.8 lbs.	Vehicle	100% Acrylic
Weight Solids	44 - 48%	Lubricating Pigment	PTFE
Volume Solids	38.5% (Theoretical)	Color	Black
VOC	1.89 lbs./gallon (Theoretical) (227 g/L)	Cleanup	See CLEANUP
Odor	Ammonia	Thinner	See THINNING
pH	8.5 – 9.5	Drying Time:	See CURING
Viscosity	85 – 95 KU @ 77°F	Coverage Rate*	600 sq. ft./gal @ 1 mil DFT
Shelf Life	1 year from date of shipment	Recommended Coats	1
Storage Conditions	50°F – 100°F	Dry Film Thickness	1 – 2 mils
Freeze/Thaw Stability	KEEP FROM FREEZING		
Flash Point	n/a		

*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

Corrosion Protection: **Operating Temperature Range** Up to 350°F

<i>ASTM B117: Steel</i>	100 hrs. (at 0.5 mil)
<i>MIL-DTL-16232 Type Z Class 3</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 MERCHANTABILITY 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

Revision Date: 05-29-14

GENERAL

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

COVERAGE

One gallon of this material will cover 600 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

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.

Application on steel. Pre-clean the steel surface with naphtha meeting the requirements of FED Spec TT-N-95. Grit blast the surfaces (25 -50 RMS, optimum). Remove grit blast debris from the surface. Phosphate IAW MIL-DTL-16232 (weight should be 1100-1400 mg/ft²), type Z, class 3.

Application on stainless steels. Pre-clean the steel surface with naphtha meeting the requirements of FED Spec TT-N-95. Grit blast the surfaces (25 -50 RMS, optimum). Remove grit blast debris from the surface. Passivate the surfaces with ASTM A967, types nitric 1, nitric 2 or nitric 3, as applicable.

Application on aluminum and aluminum alloys. Pre-clean the aluminum surface with naphtha meeting the requirements of FED Spec TT-N-95. Anodize (hot water or nickel acetate seal only) or hard coat and seal.

Application on titanium. Pre-clean the surface by a solvent wash (non-chlorinated). Alkaline anodize (Tiodize Type I or II).

Application on copper and copper alloys. Pre-clean the copper surface with naphtha meeting the requirements of FED Spec TT-N-95. Pretreat using one of the following methods (in order of preference):

- a) Black oxide treat (IAW MIL-F-495)
- b) Bright dip or grit blast (25-50 RMS, optimum)

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 SHOULD BE STIRRED THOROUGHLY BEFORE USE AND **PERIODICALLY** DURING APPLICATION.

THINNING

For spraying. Reduce with deionized water: 7 parts Poxylube® #835 to 1 part deionized water.

APPLICATION

Poxylube® #835 should be sprayed to the desired film thickness (usually 0.001 to 0.002 inches).

CURING

Allow the coated parts to dry for 24 hours at 77°F ± 5°F and <70% relative humidity before using. The parts will be tack free in approximately 30 minutes. NOTE: Cure may be accelerated by air drying for 30 minutes and then oven baking for 30 minutes at 250°F.

IMPORTANT! The time begins when the part has reached temperature, NOT when it is placed in the oven.

CLEANUP

Use soap and water.

REMOVAL OF POXYLUBE® #835

In the event it is necessary to remove Poxylube® #835, physical removal is best (such as grit blasting, sanding, or grinding). Select epoxy cold strippers can also be used.

DANGER! USE WITH ADEQUATE VENTILATION.

Strict compliance to the instructions given in Surface Preparation and Stirring is very essential for obtaining optimum results.

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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 MERCHANTABILITY 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