

TECHNICAL INFORMATION GUIDE

9AV-35 Mod 1

HEATCURING
SERIES E900

SANDSTROM
PRODUCTS COMPANY

PORT BYRON, IL 61275 • (309) 523-2121
1-800-747-1084 FAX# 1-309-523-3912

DESCRIPTION

9AV-35 Mod 1 is a heat curing single component epoxy coating formulated to provide excellent fluid resistance and corrosion protection. This product shares the same resin system as **Sandstrom 9A Solid Film Lubricant** (Formerly MIL-L-46010D), a material which has obtained a proven track record through years of aerospace, military and OEM applications around the world.

TYPICAL USES

Sandstrom 9AV-35 Mod 1 can be applied to most metallic and nonmetallic surfaces by spray or dip application wherever parts require corrosion protection and fluid resistance.

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight (Uncut)	8.1 ± .2 lbs./gallon	Corrosion Protection	OVER ZINC PHOSPHATE per DoD-P-16232 Type M Class 3 or Type Z Class 3 Over 1000 Hrs.* (5% Salt Spray @ .0005" DFT) *Had not failed when test stopped
Non Volatiles	35.0 - 42.0% minimum by weight	Fluid Resistance	Meets the requirements of: MIL-L-46010, AS5272 and MIL-L-23398
Viscosity	24 seconds ± 5 seconds (#2 Zahn cup @ 77°F)	Method of Application	Conventional spray or dipping
Flash Point	30°F ± 2°F SETAFLASH	Thinner	Spraying or Dipping: PM solvent
Operating Temperature Range	-320°F ± 500°F	Clean Up	Use same solvents for cleaning tools as are recommended for thinning.
Vehicle Type	Epoxy		
Colors	Amber or Black		
Shelf Life	1 year from date of shipment		
Storage Conditions	40°F to 90°F		

IMPORTANT!

Additional information on reverse side including
Surface Preparation and Application Instructions

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

Sandstrom 9AV-35 Mod 1 is a heat-cure single component coating in a thermosetting resin system thinned with appropriate solvents. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY. This coating is flammable and safety precautions usually followed when using flammable materials must be observed.

COVERAGE

One gallon of this material will cover approximately 600 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, phosphate according to DoD-P-16232 Type M Class 3 or Type Z Class 3.

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

ALUMINUM - Degrease using naphtha meeting the requirements of FED spec TT-N-95, anodize according to MIL-A-8625 Type I, II or III, Class 1.

TITANIUM - Solvent wash (nonchlorinated) 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-F-495C)
- b) Bright dip or grit blast (25-50 rms optimum)

IMPORTANT! AVOID TOUCHING THE SURFACES TO BE COATED WITH FINGERS--OIL FROM HANDS WILL INTERFERE WITH PROPER COATING.
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

For spraying or for dipping use PM.

APPLICATION

Sandstrom 9AV-35 Mod 1 should be sprayed or dipped to the desired film thickness (usually .0003 to .0007 inches). Allow parts to flash off **at least** 30 minutes before baking.

BAKING

Baking at 400°F for one hour will yield optimum corrosion protection and wear life. **IMPORTANT!** The hour begins when the part has reached 400°F, NOT when it is placed in the oven. In cases of very thick metals, an extra hour may be required to bring the part up to the proper temperature. Thermocouples may be used to determine the true temperature of the metal. However, if the metallurgical properties are adversely affected by baking at this temperature (i.e., ALUMINUM, in some cases), contact Sandstrom Products Company for alternative procedures.

CLEANUP

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

REMOVAL OF SANDSTROM 9AV-35 Mod 1

In the event it is necessary to remove **Sandstrom 9AV-35 Mod 1**, physical removal is best (such as grit blasting, sanding or grinding). Also, selected epoxy cold strippers will remove **9AV-35 Mod 1**.

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

WARNINGS: Constant stirring is imperative for best results.
Caution: Flammable. Keep away from sparks and open flame.
Use with adequate ventilation. Avoid prolonged breathing of vapors. If swallowed--DO NOT INDUCE VOMITING.
Contains MEK, Toluene and Epoxy & Phenolic Resins.
Call physician immediately.

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 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 or other documents state terms that vary from this warranty. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. © 2/1/98 SANDSTROM PRODUCTS COMPANY 7/29/02