



POXYLUBE® #887

DRY FILM LUBRICANT: HEAT CURE

SERIES E887

PTFE MODIFIED COATING



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DESCRIPTION

Poxylube® #887 Dry Film Lubricant is a single component epoxy formulated with PTFE to provide lubrication, fluid resistance and corrosion protection. This heat cured material prevents corrosion, galling, seizing and fretting.

Once Poxylube® #887 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® #887 can be applied to all metallic and nonmetallic surfaces by spray or dip application.

POXYLUBE® #887 CONTAINS NO GRAPHITE.

NOTICE

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

OUTSTANDING FEATURES/BENEFITS

- Hardness, slip, and corrosion protection
- Offers resistance to chemical corrosion (including Skydrol), solvents, abrasion, and impact
- Exhibits good thermal stability
- Solvent-borne with accelerated flash-off for quick handling
- Visually appealing, smooth finish with a distinctive satin texture in handling

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon <i>ASTM D1475</i>	8.25 ± 0.25 lbs.	Vehicle	Epoxy
Weight Solids	40.0 - 45.0%	Lubricating Pigment	PTFE
Volume Solids	30.0 – 35.0% (Theoretical)	Color	Black, Silver Custom Colors upon Request
VOC	4.5 - 5.0 lbs./gallon (Theoretical)	Color Stability	Not for exterior use
Odor	Strong Solvent	Finish	Satin
pH	N/A	Cleanup	See CLEANUP
Viscosity	60 - 70 KUs @ 77°F	Thinner	See THINNING
Shelf Life	1 year from Date of Shipment	Coverage Rate*	1068 sq. ft./gallon @ 0.5 mil DFT
Storage Conditions	< 100°F	Recommended Coats	1
Freeze/Thaw Stability	Yes	Dry Film Thickness	0.0005 in. – 0.001 in.
Flash Point	< -5°C / 23°F		

*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

CS-17 Taber Abrasion <i>ASTM D4060</i>	97 mg/1000 cycles	Crosscut Adhesion: <i>ASTM D3359 Test Method A</i>	<i>Aluminum</i>	5A
Chemical/Fluid Resistance: <i>MIL-PRF-46147 Table I Immersion Fluids</i> <i>MIL-L-23398 Table III Immersion Fluids</i> <i>Skydrol</i>	<i>ASTM D2510A</i> Pass		<i>CRS</i>	5A
			<i>ASTM D2510C</i> Pass	<i>Stainless Steel</i>
		Hardness <i>ASTM D3363</i>	<i>Phosphated Steel</i>	2H
			<i>CRS</i>	HB
Corrosion Protection:		Operating Temperature Range	-320°F to +400°F	
<i>ASTM B117: Iron Phosphate</i>	168 hours	Coefficient of Friction <i>ISO 16047</i>	Black: 0.07 Other colors may vary	
<i>ASTM B117: Steel</i> <i>MIL-DTL-16232 Type Z Class 3</i>	>1000 hours			

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.

FILM THICKNESS & ENGINEERING TOLERANCE

When thinned as directed, Poxylube® #887 will yield a film thickness of about 0.0005 inches per applied coat. Usually engineering tolerances will permit necessary minimum film buildup of 0.0005 to 0.001 inches without interference. Whenever possible, the proper tolerances should be designed into the part.

COVERAGE

One gallon of this material will theoretically cover 1068 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

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 surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast the surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Phosphate IAW MIL-DTL-16232 (weight should be 11-22 g/m²), type M, class 3 or type Z, class 3.

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

Application on aluminum and aluminum alloys. Pre-clean the 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). Sulfuric acid anodize IAW MIL-A-8625 and seal surface.

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

Application on copper and copper alloys. Pre-clean the surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast the surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Form a black oxide finish on the 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! STIR THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING APPLICATION.

THINNING

For conventional spraying - For a fast dry, reduce up to 2 parts coating to 1 part Sandstrom D152-C01 Thinner Blend. For ultra-fast dry, reduce up to 2 parts coating to 1 part Sandstrom D169 Thinner Blend.

APPLICATION

Poxylube® #887 should be sprayed to the desired film thickness (usually 0.0005 to 0.001 inches).

BAKING

Allow parts to flash off at least 30 minutes before baking or force dry for 15 minutes @ 150°F. Poxylube® #887 should then be cured for 20 minutes @ 300°F.

It is important to **keep container of Poxylube® #887 closed when not in use** to keep loss of solvents at minimum and avoid change in volume solids.

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

CLEANUP

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

REMOVAL

In the event it is necessary to remove Poxylube® #887, physical removal is best (such as grit blasting, sanding or grinding).

WARNINGS: Frequent stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.

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

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