



# 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

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

<b>CS-17 Taber Abrasion</b> <i>ASTM D4060</i>	97 mg/1000 cycles	<b>Crosscut Adhesion:</b> <i>ASTM D3359 Test Method A</i>	<i>Aluminum</i>	5A
			<i>CRS</i>	5A
			<i>Stainless Steel</i>	5A
<b>Chemical/Fluid Resistance:</b> <i>MIL-PRF-46147 Table I Immersion Fluids</i> <i>MIL-L-23398 Table III Immersion Fluids</i> <i>Skydrol</i>			<i>Phosphated Steel</i>	2H
<i>ASTM D2510A</i>	Pass	<b>Hardness</b> <i>ASTM D3363</i>	<i>CRS</i>	HB
<i>ASTM D2510C</i>	Pass			
<b>Corrosion Protection:</b>		<b>Operating Temperature Range</b>	-320°F to +400°F	
<i>ASTM B117: Iron Phosphate</i>	168 hours	<b>Coefficient of Friction</b> <i>ISO 16047</i>	Black - 0.07, C of F for 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 0.0002 to 0.0003 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/m<sup>2</sup>), 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 0.0003 to 0.0007 inches).

**BAKING**

Allow parts to flash off at least 30 minutes before baking or force dry for 15 minutes @ 150°F. Poxylube® #887 should 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.\*\*\*

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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 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