



POXYLUBE® #320

SOLID FILM LUBRICANT: HEAT CURE

SERIES S320

HEAT RESISTANT PTFE COATING



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DESCRIPTION

Poxylube® #320 is a blend of heat resistant resins & PTFE with excellent hardness cures at 500°F in 1 hour and can be used at up to 600°F intermittently with continuous use at 500°F.

OUTSTANDING FEATURES/BENEFITS

- High temperature resistance
- Excellent lubricity
- Excellent release properties in mold release applications.

TYPICAL USES

- Mold Release
- High Temperature Dry Film Lubrication

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.

LIMITATIONS

- Not for use on substrates affected by the 500° F cure temperature.

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon	7.50-9.00 lbs./gallon	Vehicle	Silicone
Weight Solids	40.0-50.0 %	Lubricating Pigment	PTFE
Volume Solids	32.00 % (Theoretical)	Color	Black, Custom Colors upon Request
VOC	4.82 lbs./gallon	Color Stability	Excellent
Odor	Solvent	Finish	Satin
Viscosity	50-70 K.U. @ 77°F	Gloss	30-50 gloss units at 60°
Shelf Life	12 Months from Date of Shipment	Coverage Rate*	500 sq. ft./gallon @ 1 mil DFT
Storage Conditions	Store below 100 °F	Recommended Coats	1
Freeze/Thaw Stability	Stable	Dry Film Thickness	1 Mil
Flash Point	21°F		

*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

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 or 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

Poxylube® #320 consists of lubricative pigments dispersed in a high temperature resistant thermosetting resin system thinned with appropriate solvents. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

FILM THICKNESS & ENGINEERING TOLERANCE

As supplied, this product will yield a film thickness of about 0.0005 to 0.001 inches per spray application. If being used as a solid film lubricant, 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 cover 500 sq. ft. with a dry film thickness of 0.001 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

Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Abrasive Blast the surfaces with 180-220 grit aluminum oxide.

Mold Recoating – Abrasive blast any coating to bare substrate prior to recoating.

IMPORTANT! DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.

STIRRING

IMPORTANT! STIR THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING APPLICATION.

THINNING

Use as supplied for spray applications

APPLICATION

For spraying – Use as supplied for spray applications

BAKING / CURING

After application and prior to being placed in an oven, it is recommended that parts flash off for 20 minutes @ 77°F ± 5°F and ≤70% relative humidity. Once the parts are dry, bake at 500°F for 60 minutes to reach full cure and attain full mechanical characteristics.

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

CLEANUP

Wet product may be wiped away with a rag. If product is dry but not cured, a solvent such as MEK or acetone may be used.

REMOVAL

It is recommended that the cured film be removed by abrasive blasting or sanding.

WARNINGS: Intermittent stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.

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