



POXYLUBE® #845
 (FORMERLY EXPERIMENTAL PRODUCT: X127)
ACRYLIC PTFE BAKING ENAMEL: HEAT CURE
SERIES A845
SATIN FINISH

SANDSTROM
PRODUCTS COMPANY
 PORT BYRON, IL 61275 • 1-309-523-2121
 1-800-747-1084 • FAX: 1-309-523-3912
www.sandstromproducts.com

DESCRIPTION

Poxylube® #845 Acrylic PTFE Baking Enamel provides a durable satin finish with excellent UV light resistance. This versatile solventborne single component coating is optimized for spray application.

OUTSTANDING FEATURES/BENEFITS

- Excellent UV weatherability and gloss retention
- Fast cure response
- Lubricity through PTFE reduces friction in applications with surface contact.

TYPICAL USES

- On coating fasteners
- As UV protective finish
- As light reflective finish

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

- Do not use where temperatures regularly exceed 400°F.
- Product not suitable for food contact or food processing equipment.

COMPOSITION AND PHYSICAL PROPERTIES			
Net Weight per gallon	8.0 - 12.0 lbs./gallon (Theoretical)	Vehicle	Acrylic
Weight Solids	55 - 70% (Theoretical) <i>Varies by color</i>	Lubricating Pigment	PTFE
Volume Solids	45 - 50% (Theoretical)	Color	Black (Custom Colors Available)
VOC	2.5 - 3.5 lbs./gallon	Finish	Smooth and Satin
Odor	Strong solvent	Gloss	25 - 35 gloss units at 60°
Viscosity	60 - 70 KU @ 77°F	Pot Life	N/A
Shelf Life	12 months from date of manufacture	Coverage Rate*	1400-1600 sq. ft./gallon @ .5 mil DFT
Storage Conditions	32°F to 100°F	Recommended Coats	1
Freeze/Thaw Stability	Stable	Dry Film Thickness	.5 - .75 mils

*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				
Chemical Resistance 24 hours @ R.T.	Brake Fluid	No Effect	CS-17 Taber Abrasion ASTM D4060	126 mg/1,000 cycles
	Penetrating Oil	No Effect	Adhesion ASTM D3359	5B over cold rolled steel
	WD-40	No Effect	Hardness	F pencil
	Anti-Seize Compound	No Effect	Operating Temperature Range	-300°F to 400°F

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

This product is a heat curing acrylic baking enamel, optimized for spraying and dip spin application. 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 .0005 to .0075 inches per spray application.

COVERAGE

One gallon of this material will cover 1400 - 1600 sq. ft. with a dry film thickness of 0.005 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

It is recommended that the surface be thoroughly de-greased with a suitable solvent and grit blasted and/or zinc, iron, or manganese phosphate pre-treatment be applied for best results. Minimum preparation requires the surface be dry and free of dust and greases or oils.

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 spray application it is recommended to thin the coating 2:1 based on volume with D159-C01. Optimal thinning must be determined for each individual dip spin assembly.

APPLICATION

For spraying – Thin as described above and spray as any conventional paint. Note: if air assisted airless spray equipment is used, ensure the spray tip orifice is greater than 0.001 cm.

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 400°F for 20 minutes or 300°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.