POXYLUBE® #800
HEAT CURING
PTFE MODIFIED COATING
SERIES E883

GENERAL DESCRIPTION

Sandstrom POXYLUBE® #800 Dry Film Lubricant is a single component epoxy formulated with PTFE to provide excellent lubrication, fluid resistance, and corrosion protection. This Heat Cured material prevents corrosion, galling, seizing and fretting.

Excellent Corrosion Protection and ease of application are its outstanding characteristics. SANDSTROM POXYLUBE® #800 CONTAINS NO GRAPHITE.

Once Sandstrom POXYLUBE® #800 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® #800 can be applied to all metallic and nonmetallic surfaces by spray or dip application.

Complete application instructions are on the reverse of this sheet.

FEATURES/BENEFITS

• Provides excellent lubrication
• Provides heavy duty service as an exterior protective coating for all metals including magnesium
• Offers resistance to chemical corrosion, solvents, abrasion, impact
• Exhibits good thermal stability

COMPOSITION AND PHYSICAL PROPERTIES

<table>
<thead>
<tr>
<th>NET WEIGHT PER GALLON</th>
<th>8.0 ± .4 lbs</th>
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<tbody>
<tr>
<td>SOLIDS CONTENT</td>
<td>24.0 - 32.0%</td>
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<tr>
<td>(By Weight)</td>
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<tr>
<td>VISCOSITY</td>
<td>30 - 40 seconds</td>
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<tr>
<td>(#1 Zahn @ 77°F)</td>
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<tr>
<td>OPERATING TEMP. RANGE</td>
<td>-320°F to +400°F</td>
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<tr>
<td>CORROSION PROTECTION</td>
<td>500 hrs.</td>
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<tr>
<td>(5% salt fog @ .0005&quot; film thickness over zinc phosphated steel)</td>
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<tr>
<td>COLORS</td>
<td>Clear, Black, Tile Red and Green</td>
</tr>
<tr>
<td>SHELF LIFE</td>
<td>1 year from date of shipment</td>
</tr>
<tr>
<td>VEHICLE TYPE</td>
<td>100% Epoxy</td>
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<tr>
<td>LUBRICATIVE PIGMENT</td>
<td>PTFE</td>
</tr>
<tr>
<td>VOC (Theoretical)</td>
<td>5.74 - 5.85 lbs/gal</td>
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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
For maximum service, the APPLICATION INSTRUCTIONS MUST BE CLOSELY FOLLOWED. The lubricant is flammable and the safety precautions usually followed when using flammable materials must be observed.

COVERAGE
One gallon of this material will theoretically cover 575 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; zinc phosphatize (1100-1400 milligrams per sq. ft.).

STAINLESS 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; passivate.

ALUMINUM - Degrease using naphtha meeting the requirements of FED spec TT-N-95; anodize (hot water or nickel acetate seal only) or hard coat and seal.

TITANIUM - Solvent wash (non-chlorinated) and alkaline anodize; only) or hard coat and seal.

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)

IMPORANT! AVOID TOUCHING THE SURFACES TO BE COATED WITH THE FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING. Whenever possible treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING
IMPORTANT! THIS LUBRICANT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND CONTINUOUSLY DURING APPLICATION

THINNING
Conventional spraying: Reduce sparingly with MEK.
Dipping: Not necessary, but can be reduced sparingly with PMA.

APPLICATION
Sandstrom POXYLUBE® #800 should be sprayed or dipped to the desired film thickness (usually .0003 to .0007 inches).

CURING
Allow parts to flash off at least 30 minutes before baking.
POXYLUBE® #800 can be cured according to the following schedule:
   60 minutes @ 300°F or
   25 minutes @ 350°F or
   20 minutes @ 375°F or
   15 minutes @ 400°F.

Note: Start time when parts reach temperature.
Important to keep container of POXYLUBE® #800 closed when not in use to keep loss of solvents at minimum and avoid change in volume solids.

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

REMOVAL OF SANDSTROM POXYLUBE® #800
In the event it is necessary to remove POXYLUBE® #800, physical removal is best (such as grit blasting, sanding or grinding).

POXYLUBE® #800 PTFE Modified Coating passes the fluid resistance tests specified in MIL-PRF-46147C.

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

POXYLUBE® #800 PTFE

WARNINGS: Constant stirring is imperative for best results.
Caution: Flammable. Keep away from heat, sparks, and open flame. Use with adequate ventilation.
Avoid prolonged breathing of vapors.
If swallowed, DO NOT INDUCE VOMITING—call physician immediately.
Contains METHYL ETHYL KETONE

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 IT’S USE OR THAT OUR PRODUCT SHALL BE MERCHANTABILITY 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.
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