

Technical Data Sheet



Product Name: Graphite Filled Skydrol Resistant Dry Film Lubricant

Product Number: IP9136-R3

Product Description: Spray applied, stoving cured, silicon resin modified dry film lubricant for use where high operating temperatures preclude the use of conventional oils and greases.

Suitable for application to steel, aluminium, magnesium and titanium alloys.

Used on, for example spherical bearing surfaces to protect against fretting corrosion and on bolts for torque and gives an exceptionally good rubbing wear resistance.

When used on bolts, it increases torque end loads. It is also used on turbine blade roots and fir trees where it reduces the likelihood of the disc splitting.

Approvals/Specifications:

- MSRR 9276
- OMat 4 / 44C
- CPW 27

Performance: Resistant to dry heat up to 400°C (750°F) in oxidizing atmospheres and 500°C (930°F) where oxygen is excluded, ester lubricants, Skydrol and corrosion.

Tri-n-Butyl-Phosphate: 3 hours @ 70°C

Dry Heat: 1000 hours at 400°C

Components: Single Part Product. May be thinned for application using IP985-Reducer or IP9151

Application:

Surface Preparation:	Ensure that surfaces are clean and free from dirt
Paint Preparation:	Stir well before use. All separated material must be re-incorporated into the bulk product. No time limits are specified for the mixing operation. The operator must be satisfied that the product including any thinning solvent is thoroughly mixed before use. Where mechanical mixing is employed care must be taken to not heat the product to above the maximum storage temperature. Mixing in open containers should be limited to <10 minute periods to ensure that solvent evaporation does not compromise the product. Shaking or rolling in closed containers is an acceptable mixing method for small volume products supplied ready for use.
Application Method:	<p>Spray a light coat and allow to dry for 10 - 20 minutes, stove for 2 – 2.5 hours at 190 +/- 8°C (375°F). Where spraying is not possible small areas may be coated by brush.</p> <p>Part cure procedure – where components require coating on multiple faces and/or multiple masking procedures, IP9136-R3 may be part cured to allow handling.</p> <p>For this process a baking schedule of 30-40 minutes @ 150 +/- 8°C may be used.</p> <p>The low bake allows parts to be handleable only. Full curing of the coating is only achieved after the full baking cycle.</p> <p>Refer to RPS 661 / 10 for additional client specific details.</p>
Drying Curing:	Air Dry for 10-20 minutes then stove for 2 – 2.5 hours at 190 +/- 8°C (375°F)

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Technical Properties:

Supply Viscosity:	Ready for use
Flash Point:	27°C
VOC Content:	N / A
Colour:	Grey
Pack Size:	1 & 5 Litres
Density:	1.03 kg / litre
Gloss:	N / A
Thinner:	IP985-Reducer or IP9151
Solvent/Clean Up:	40006 Gun Clean
Catalyst:	Ready for use
Theoretical Coverage:	13.5 sq m/litre @ 25 micron

Storage:

Highly flammable liquid: store and use in accordance with the flammable liquid regulations

Shelf Life: 12 months temperate; 6 months tropical

Before use, refer to Product Safety Data Sheet

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Safety Data Sheets:

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