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 frottage 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°CDry Heat:1000 hours at 400°C
Components:	Single Part Product. May be thinned for application using IP985- Reducer or IP9151

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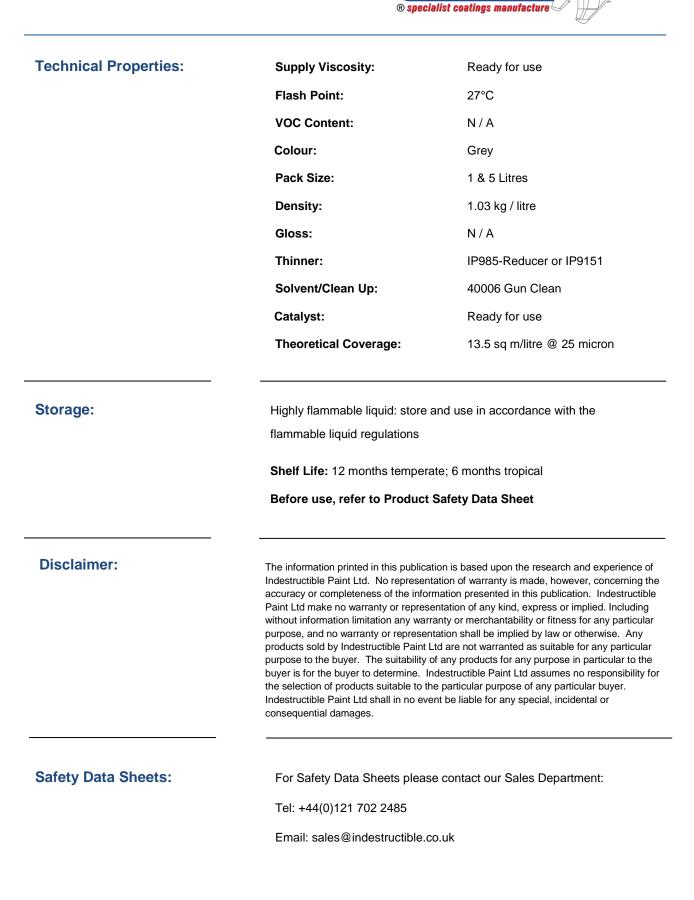


Application:

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. Not 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:	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. Part cure procedure – where components require coating on multiple faces and/or multiple masking procedures, IP9136-R3 may be part cured to allow handling.
	For this process a baking schedule of 30-40 minutes @ $150 + - 8^{\circ}C$ may be used.
	The low bake allows parts to be handleable only. Full curing of the coating is only achieved after the full baking cycle.
	Refer to RPS 661 / 10 for additional client specific details.
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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