

Molykote[®] 3402-C LF Anti-Friction Coating

FEATURES

- Excellent lubricity
- Excellent corrosion protection
- Air-curing
- High pressure and wear resistance

COMPOSITION

- Solid lubricants
- Organic binder
- Organic solvent

Air-curing dry film lubricant

APPLICATIONS

- Excellent combination of lubrication and corrosion protection.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test	Property	Unit	Result
	Color		Grey
	Service temperature range	°C	-200 to +310
		°F	-328 to +590
	Physical properties		
EN ISO DIN 2431	Viscosity, cup # 4 at 23°C (73°F)	s	32
ASTM-D 1475	Density at 23°C (73°F)	g/ml	1.06
ASTM-D 56	Flash point	°C	15
		°F	59
	Load-carrying capacity, wear protection, service life		
ASTM-D 2625	Falex, procedure B, load carrying capacity	N	s=12200 ₍₁₎
		lbf	s=2750 ₍₁₎
		N	p=11100 ₍₂₎
		lbf	p=2500 ₍₂₎
		N	p=8900 ₍₃₎
		lbf	p=2000 ₍₃₎
ASTM-D 2625	Falex, procedure A, endurance life at 4450 N load	min	s=193 ₍₁₎
ASTM-D 2714	LFW-1, rotating, load 2860 N, n=72 rpm, v=7.9 m/min, no. of revolutions to μ=0.1	min	p=225 ₍₂₎ s=74800 ₍₁₎
ASTM-D 2714	LFW-1, oscillating, load 900 N, frequency=89.5 osc/min, no. of oscillations to μ=0.08		p=108800 ₍₂₎ s=63400 ₍₁₎
			p=227600 ₍₂₎ p=33800 ₍₃₎
	Resistances		
ASTM-B 117 DIN 50021	Corrosion resistance without red rust (steel substrate, spraying application, film thickness = 10 μm) ₍₄₎	h	p=120 ₍₃₎

(1) = surface pretreatment: s= sandblasted

(2) = surface pretreatment: p = Mn-phosphated

(3) = surface pretreatment: p = Zn-phosphated

(4) = as the performance in corrosion protection is affected by the geometry of the parts, by the pretreatment of the surface, by the application method and by the thickness of the applied dry film

Dow Corning recommends customers to run trials on original parts before setting specifications

ASTM: American Society for Testing and materials.

DIN: Deutsche Industrie Norm.

HOW TO USE

Surface preparation

Carefully clean and degrease surfaces to be coated with the Anti-Friction Coating.

Recommended pretreatments: blasting or phosphating. Both pretreatments increase the adhesion and service life of the Anti-Friction Coating.

How to apply

Stir the Anti-Friction Coating thoroughly before and during use, apply by spraying, dipping, centrifuging or brushing. Surfaces should be coated as evenly as possible. Recommended dry film thickness: 5 to 20 µm.

Coverage

When applied at 10 µm dry film thickness *Molykote*[®] 3402-C LF Anti-Friction Coating has a coverage of approx. 12 m²/kg (this value does not take into account the losses generated during the application process)

Thinner

Recommended thinner is *Molykote*[®] L13

Curing

Typical curing conditions:

Touch dry after 5 minutes at 20°C (68°F)

Fully cured after 120 minutes at 20°C (68°F)

HANDLING

PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE FROM YOUR LOCAL

DOW CORNING SALES REPRESENTATIVE.

USABLE LIFE AND STORAGE

When stored at temperatures between 0°C (32°F) and 23°C (73°F) in the original unopened containers *Molykote* 3402-C LF Anti-Friction Coating has a usable life of 36 months from the date of production.

PACKAGING INFORMATION

This product is available in different standard container sizes. Detailed container size information should be obtained from your nearest Dow Corning sales office or Dow Corning distributor.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support Customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our website, dowcorning.com or consult your local Dow Corning representative.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and

fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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