

**SARA SAE ENGINEERING SPECIFICATION****Section: SES 26 – 788****Issue: "A"****Rev No.: "0"****Eff. Date: 15/05/2015****Page: 1 of 3****MATERIAL SPECIFICATION FOR**
XYLAN 1424/D6580 (RED) #181

Rev	Reason of Change	Date	Made By	Reviewed By	Approved By	Status
"0"	--	15/04/2015	HARSH KUMAR SHARMA	PANKAJ KUMAR	K.C. RATURI	RELEASED

Handwritten signature of Harsh Kumar Sharma.

Handwritten signature of Pankaj Kumar.

Handwritten signature of K.C. Raturi.



SARA SAE ENGINEERING SPECIFICATION

Section: SES 26 – 788

Issue: "A"

Rev No.: "0"

Eff. Date: 15/05/2015

Page: 2 of 3

MATERIAL SPECIFICATION FOR XYLAN 1424/D6580 (RED) #181

1.) SCOPE

The primary end use of this coating is industrial dry film lubricant . This product is designed for spray application.

2.0 OPERATION

BAKE SCHEDULE : 15-10 minutes at 400⁰F-450⁰ f (204⁰C – 232⁰C)

2.1 CONCENTRATION:-

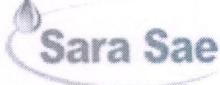
If necessary adjust viscosity with whitford solvent 54 or Water . Add thinner in 2% increment until the desired application characteristics are obtained .

Application viscosity : 30-45 sec. Zahn #2 (s90) cup at 77⁰ f (25⁰ c)

TOP COAT : whitford xylan 1424 (red) , at 0.6 to 1.0 mil (15-25 microns)

3.0 PHYSICAL PROPERTIES

1 . – COLOUR AND APPEREANCE	: Red
2 . – CARRIER	: Water Based
3 . – DENSITY	: 4.34 +/- 0.2 Kg/Gal(1.14 +/- 0.02 Kg/Liter)
4 . – FLASH POINT	: 118.4 ⁰ F (48 ⁰ C)
5 . – VOLATILE ORGANIC COMPOUND	: 2.92 Lb./Gal (350.40 Gms/Liter)
6 . – SOLIDS (BY WEIGHT)	: 48.63 +/- 2.0 % By Wt. , 37.76 +/- 2.0 % By Vol.
7 . – COVERAGE THEORITICAL	: 139.58 Ft ² / Kg @ 1 Mil, 13.14 M ² /Kg @ 25 Microns 609.79 Ft ² /Gal @ 1 Mil
8 . – VISCOSITY, AS SHIPPED	: 20 to 30 sec. zahn #3 (S90) cup at 77 ⁰ F (25 ⁰ C)

	SARA SAE ENGINEERING SPECIFICATION	
	Section: SES 26 – 788	
	Issue: “A”	Rev No.: “0”
	Eff. Date: 15/05/2015	Page: 3 of 3

4.0 STORAGE AND HANDLING PRECAUTION

4.1- Store in cool & dry place (preferably within 4-35°C (40⁰ to 95⁰ F) under closed condition to avoid any contaminations). Keep away from acids and organic compounds. Loosen cover cautiously when opening.

4.2- Additional information : Store above frizzing temperature.

4.3- SHELF LIFE : 12 MONTHS

5.0 DOCUMENTATION REQUIRED

Each shipment shall be accompanied by material certifications for each lot of material, certifications must be positively relatable to the lot of material represented.