	<b>SARA SAE ENGINEERING SPECIFICATION</b>	
	<b>Section: SES 26 – 788</b>	
	<b>Issue: “A”</b>	<b>Rev No.: “0”</b>
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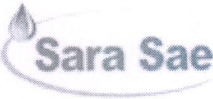
**MATERIAL SPECIFICATION FOR**  
**XYLAN 1424/D6580 ( RED ) #181**

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

*Harsh*

*Pankaj Kumar*

*K.C. Raturi*

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## **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 400<sup>0</sup>F-450<sup>0</sup> f (204<sup>0</sup>C – 232<sup>0</sup>C)

#### **2.1 CONCENTRATION:-**

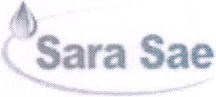
If necessary adjust viscosity with whitford solvent 54 or Water . Add thinner in 2% increment until the desired application characterstics are obtained .

Application viscosity : 30-45 sec. Zahn #2 (s90) cup at 77<sup>0</sup> f (25<sup>0</sup> 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<sup>0</sup> F ( 48<sup>0</sup> 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<sup>2</sup> / Kg @ 1 Mil, 13.14 M<sup>2</sup> /Kg @ 25 Microns  
609.79 Ft<sup>2</sup> /Gal @ 1 Mil
- 8 . – **VISCOSITY, AS SHIPPED** : 20 to 30 sec. zahn #3 ( S90 ) cup at 77<sup>0</sup> F ( 25<sup>0</sup> C )

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#### **4.0 STORAGE AND HANDLING PRECAUTION**

4.1- Store in cool & dry place (preferably within 4-35°C ( 40<sup>0</sup> to 95<sup>0</sup> 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.