

SARA SAE ENGINEERING SPECIFICATION

Section: SES 26 – 789

Issue: "A"

Rev No.: "0"

Eff. Date: 15/05/2015

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MATERIAL SPECIFICATION FOR XYLAN 1424/F9459 (RED OXIDE)

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



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1.) SCOPE

XYLAN 1424/F9459 (RED) OXIDE is an aqueous based , resin bonded , dry film lubricant coating primarily formulated for use on fasteners to prevent corrosion .

2.0 OPERATION

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 .

FLASH-OFF CONDITION : 3-5 MIN. AT 25-50⁰C (80-120⁰F)

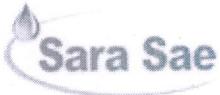
OPTIMUM CURE SCHEDULE : 20 MIN. AT 205⁰C (400⁰)

MINIMUM CURE TEMPERATURE : 15 MIN. AT 205⁰C (400⁰)

MAXIMUM CURE TEMPERATURE : 5 MIN. AT 275⁰C (525⁰)

3.0 PHYSICAL PROPERTIES

1 . – COLOUR AND APPEREANCE	: RED
2 . – CARRIER	: WATER BASED
3 . – DENSITY	: 23 ⁰ C (>= 1.06 g/cm ³), (<= 1.23 g/cm ³)
4 . – FLASH POINT	: > 26.7 ⁰ C
5 . – VISCOSITY , AS SHIPPED	: 23 ⁰ C (40-45 sec.) in a BS4 viscosity cup : 23 ⁰ C (27-31 sec.) in a DIN4 viscosity cup : 23 ⁰ C (30-40 sec.) in a FORD4 viscosity cup.
6 . – SOLIDS (BY WEIGHT)	: 45.29 +/- 2.5 % BY WT. , 35.36 +/- 2.5 % by vol.
7 . – OPERATING TEMP.	: -20 ⁰ C TO + 180 ⁰ C – CONT. , - 20 ⁰ TO +230 ⁰ C - intermittent
8 . – THEORITICAL COVERAGE @ 25 MICRONS	: 11.11 – 13.91 M ² / KG , 13.15 – 15.14M ² /LITERS
9 . – THEORITICAL COVERAGE(DRY FILM)	: 13.9 – 23.2 M ² / KG , 16.4 – 25.2 M ² /LITERS

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5.0 STORAGE AND HANDLING PRECAUTION

Store between the temperature : 5^0 to 30^0 C (41^0 to 86^0 F) . store in original container protected from direct sunlight in a dry , cool and well ventilated place .

Shelf life : 6 months

6.0 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.