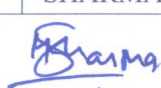
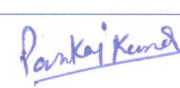

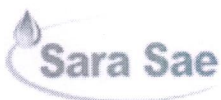
	SARA SAE ENGINEERING SPECIFICATION	
	Section: SES 26 – 789	
	Issue: “A”	Rev No.: “0”
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MATERIAL SPECIFICATION FOR
XYLAN 1424/F9459 (RED OXIDE)

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

	SARA SAE ENGINEERING SPECIFICATION	
	Section: SES 26 – 789	
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MATERIAL SPECIFICATION FOR XYLAN 1424/F9459 (RED OXIDE)

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

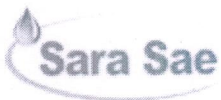
2.1 CONCENTRATION:-

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

FLASH-OFF CONDITION	: 3-5 MIN. AT 25-50 ⁰ C (80-120 ⁰ F)
OPTIMUM CURE SCHEDULE	: 20 MIN. AT 205 ⁰ C (400 ⁰)
MINIMUM CURE TEMPERATURE	: 15 MIN. AT 205 ⁰ C (400 ⁰)
MAXIMUM CURE TEMPERATURE	: 5 MIN. AT 275 ⁰ C (525 ⁰)

3.0 PHYSICAL PROPERTIES

- 1 . – **COLOUR AND APPEARANCE** : RED
- 2 . – **CARRIER** : WATER BASED
- 3 . – **DENSITY** : 23⁰ C ($\geq 1.06 \text{ g/cm}^3$) , ($\leq 1.23 \text{ g/cm}^3$)
- 4 . – **FLASH POINT** : > 26.7⁰ C
- 5 . – **VISCOSITY , AS SHIPPED** : 23⁰ C (40-45 sec.) in a BS4 viscosity cup
: 23⁰ C (27-31 sec.) in a DIN4 viscosity cup
: 23⁰ 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.** : -20⁰ C TO + 180⁰ C – CONT. , - 20⁰ TO +230⁰ C - intermittent
- 8 . – **THEORITICAL COVERAGE** : 11.11 – 13.91 M²/ KG , 13.15 – 15.14M²/LITERS
@ 25 MICRONS
- 9 . – **THEORITICAL COVERAGE(DRY FILM)** : 13.9 – 23.2 M²/ KG , 16.4 – 25.2 M²/LITERS

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5.0 STORAGE AND HANDLING PRECAUTION

Store between the temperature : 5⁰ to 30⁰ C (41⁰ to 86⁰ 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.