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SURF-KOTE® LOB-1800-G

HIGH TEMPERATURE DRY FILM LUBRICANT

SL-147/03

1. SCOPE

Surf-Kote LOB-1800-G is an inorganic heat-cured dry film lubricant containing graphite and other high temperature lubricating additives blended with a modified silicate binder.

Surf-Kote LOB-1800-G is a water-based product. The cured film has superior lubricating properties in the temperature range of 700-1400°F., where other dry film lubricants containing molybdenum disulfide and/or Teflon are not acceptable.

2. CLASSIFICATION

- A-Spray consistency
- B-Brush or dip consistency

3. PROPERTIES

	Class A	Class B
Weight	9.18-10.8 lbs./gal.min	10.4-12.1 lbs/gal. min.
Viscosity @ 75°F. #2 Zahn Cup	16 ± 2 sec.	25 ± 10 sec.
Solids content (by weight)	30% min.	42% min.
Flash Point	None	None
Coverage	Approx. 700 sq. ft. per gal. .0005 inch thick	Approx 700 sq. ft. per gal. .0005 inch thick
Shelf Life from date of shipment	12 months min. at 75°F.	12 months min. at 75°F

Packaged in 1-quart, 1-gallon, 5-gallon, and 55-gallon containers.

4. FILM ADHESION

The adhesion of LOB-1800-G as determined by acceptable tape methods is good. A uniform deposit of powdery material

on the tape is acceptable, but presence of large flakes or exposure of bare metal is an indication of poor substrate preparation or application.

5. CORROSION RESISTANCE

Surf-Kote LOB-1800-G is recommended for use primarily on corrosion-resistant base metals as the corrosion properties of the coating are minimal.

6. SURFACE PREPARATION

For maximum performance, all parts to be coated should be degreased and glass bead blasted to produce a surface finish of approximately 6-100 RMS. Care should be taken to insure that all residual blasting media is removed from the parts to be coated prior to application of the LOB-1800-G.

If blasting facilities are not available, cleaning with emery paper or wire brushing may be substituted.

7. APPLICATION PROCEDURE

Application of Surf-Kote LOB-1800-G should be performed as soon after surface preparation as practical. Surfaces to be coated should not be touched with bare hands or contaminated in any way. Surf-Kote LOB-1800-G should be thoroughly stirred prior to application as the lubricating pigments will settle during storage.

If possible, preheat the parts to be coated to 200-250°F. Application of Surf-Kote LOB-1800-G to a warm substrate expedites the flash-off of the water solvent.

Surf-Kote LOB-1800-G should be applied to a thickness of .0005-.001 inch by spraying, dipping, or brushing, with spraying being the preferred method.

Normal paint spray equipment can be used. Air pressure of 20-40 psi is recommended.

Spray equipment should be thoroughly cleaned with water and dried after use.



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8. CURING CYCLE

Surf-Kote LOB-1800-G should be air dried for 15 to 30 minutes or until the water solvent is flashed off followed by heat curing at 275 to 300°F for 1 to 1 ¼ hours.

For maximum resistance to moisture absorption, a cure cycle of 15 to 30 minutes air dry and 2 to 2 ½ hours cure at 180 to 200°F. plus 3 to 3 ½ hours cure at 275 to 300°F. is recommended.

9. HANDLING

There are no unusual hazards encountered when using Surf-Kote LOB-1800-G. The material is water-based and should be protected from freezing during storage.

10. WARRANTY

Hohman Plating & Mfg., Inc. makes no warranty or guaranty, express or implied, of merchantability or fitness for particular purpose of the product. In the event of defect, in no case will Hohman be liable for more than the price paid for this product. Acceptance of merchandise constitutes acknowledgement of this warranty disclaimer.