MOLYKOTE® 3400A Anti-Friction Coating, LF

Heat-cure dry lubricant for metal/metal combinations involving slow to medium-fast movements and medium to heavy loads

Features & benefits

- Excellent lubrication
- Excellent corrosion protection
- Good solvent resistance
- High load-carrying capacity
- Excellent adhesion to metal
- Low coefficient of friction
- High resistance to oil and fuels

Applications

Used for sliding contact of metal/metal combinations with slow to moderately fast movements and high loads. Used successfully in automotive applications such as pins, springs and bearings surfaces in brakes; body hinges and linkages; moving parts in locks, switches, ventilation controls and servo mechanisms; under-the-hood linkages exposed to dust, moisture, fuels, oils and other contaminants; hinge pins, sleeve bearings and cams; servo mechanism and instrument bearing; threaded connections and fasteners.

How to use

Carefully degrease friction surfaces with solvent and allow solvent to evaporate completely. Stir MOLYKOTE® 3400A Anti-Friction Coating, LF thoroughly and apply by spraying, dipping, painting or centrifuging (Recommended thinner: MOLYKOTE® L13 Thinner). The friction surfaces should be coated as evenly and thinly as possible. Average recommended coating thickness for typical applications is 10-15 μm. Typical curing conditions are 30 minutes at 200°C (392°F).

Handling precautions

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION.

Typical properties

Specification writers: These values are not intended for use in preparing specifications. Please contact your local MOLYKOTE® sales representative prior to writing specifications on this product.

Standard[1]	Test	Unit	Result
	Color		Gray
ISO 2811	Density at 20°C (68°F)	g/ml	1.2
	Temperature resistance After 3 hr at 260°C (500°F) After 24 hr at 43°C (110°F)		 No adhesion loss No adhesion loss
Load-carrying capacity			
ASTM D2714	LFW-1, rotating, load 2,860 N, n=72 rpm, v=7.9 m/min., no. of revolutions to μ=0.1		P ≥48,000[2]
ASTM D2714	LFW-1, oscillating, load 900 N, frequency=89.5 osc./min., no. of oscillations to μ=0.08		P ≥50,000[2]
ASTM D2625	Falex, procedure B, pressure resistance	N	P ≥16,000[2]
ASTM D2625	Falex, procedure A, endurance life average	min	P ≥500[2]
Resistance			
ASTM B117, DIN 50021	Corrosion resistance without red rust (spraying/dipping application)	hr	P ≥500[2]
ASTM B117, DIN 50021	Corrosion resistance without red rust (dip-spinning application)	hr	P ≥240[2]
SAE AS 5272 Type II	Resistant to fluids		No adhesion loss

[1]ISO: International Standardization Organization. ASTM: American Society for Testing and Materials. DIN: Deutsche Industrie Norm.
[2]Surface: P = phosphate.

Usable life and storage

When stored at or below 20°C (68°F) in the original unopened containers, this product has a usable life of 24 months from the date of production.

Packaging

This product is available in different standard container sizes. Detailed container size information should be obtained from your nearest MOLYKOTE® sales office or MOLYKOTE® distributor.

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