MOLYKOTE® 3402-C LF Anti-Friction Coating

Air-curing dry-film lubricant

Features

- Excellent lubricity
- Excellent corrosion protection
- Air-curing
- High pressure and wear resistance

Composition

- Solid lubricants
- Organic binder
- Organic solvent

Applications

Excellent combination of lubrication and corrosion protection.

How to use

Surface preparation

Carefully clean and degrease surfaces to be coated with MOLYKOTE® 3402-C LF Anti-Friction Coating.

Recommended pretreatments: blasting or phosphating. Both pretreatments increase the adhesion and service life of MOLYKOTE® 3402-C LF Anti-Friction Coating.

How to apply

Stir MOLYKOTE® 3402-C LF Anti-Friction Coating thoroughly before and during use, apply by spraying, dipping, centrifuging or brushing. Surfaces should be coated as evenly as possible. Recommended dry-film thickness: 5 to 20 µm.

Coverage

When applied at 10 µm dry-film thickness, MOLYKOTE® 3402-C LF Anti-Friction Coating has a coverage of approximately 12 m^2/kg (this value does not take into account the losses generated during the application process).

Thinner

Recommended thinner is MOLYKOTE® L13 Thinner.

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
	Service temperature range	°C	-200 to 310
		°F	-328 to 590
Physical properties			
EN ISO DIN 2431	Viscosity, cup #4 at 23°C (73°F)	s	32
ASTM D1475	Density at 23°C (73°F)	g/ml	1.06
ASTM D56	Flash point	°C	15
		°F	59
Load-carrying capacity, wear protection, service life[2]			
ASTM D2625	Falex, procedure B, load-carrying capacity	N N N	s=12,200 m=11,100 z=8,900
ASTM D2625	Falex, procedure A, endurance life at 4,450 N load	min	s=193 m=225
ASTM D2714	LFW-1, rotating, load=2,860 N @ 72 rpm, v=7.9 m/min, no. of revolutions to µ=0.1	min	s=74,800 m=108,800
ASTM D2714	LFW-1, oscillating, load=900 N @ 89.5 osc/min, no. of oscillations to µ=0.08		s=63,400 m=227,600 z=33,800

[1]ASTM: American Society for Testing and Materials. DIN: Deutsche Industrie Norm.

[2]Surface pretreatment: s=sandblasted; m=Mn-phosphated; z=Zn-phosphated.

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Typical properties (continued)

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Standard[1]	Test	Unit	Result
	Resistance[2]		
ASTM B117, DIN 50021	Corrosion resistance without red rust (steel substrate, spraying application, film thickness = 10 µm)[3]	h	z=120

[1]ASTM: American Society for Testing and Materials. DIN: Deutsche Industrie Norm.

[2]Surface pretreatment: s=sandblasted; m=Mn-phosphated; z=Zn-phosphated.

[3]As the performance in corrosion protection is affected by the geometry of the parts, by the pretreatment of the surface, by the application method and by the thickness of the applied dry film, DuPont recommends customers run trials on original parts before setting specifications.

Curing

Typical curing conditions:

- Touch-dry after 5 minutes at 20°C (68°F)
- Fully cured after 120 minutes at 20°C (68°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.

Usable life and storage

When stored at temperatures between 0°C (32°F) and 23°C (73°F) in the original unopened containers, MOLYKOTE® 3402-C LF Anti-Friction Coating has a usable life of 36 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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