MOLYKOTE® 7400 Anti-Friction Coating

Air-curing dry lubricant

Features & benefits

- Free from flammable solvents
- Water-based
- High load-carrying capacity
- Low coefficient of friction

Composition

- Solid lubricants
- Inhibitor
- Organic binder
- Water
- Stabilizers

Applications

Sliding coating of metal/metal combinations with slow to moderately fast movements and high loads. Suitable for improving the running-in of gearboxes, sliding bearings and sliding guides. Maintenance-free, permanent lubrication of highly stressed friction combinations with low speeds or oscillating operation in which the use of oil or grease, for design construction reasons, is not possible, or because of the unacceptable risk of soiling. For running-in car transmission shafts, for the maintenance-free, permanent, nonsoiling lubrication of threaded sleeves of car seat adjusting mechanisms, and for the cold working of steel.

How to use

Surface preparation

First, clean and degrease the surface that will be coated with MOLYKOTE® 7400 Anti-Friction Coating. Phosphatization or sandblasting (180 grit) increases the adhesion and service life.

How to apply

Stir the MOLYKOTE® 7400 Anti-Friction Coating thoroughly before applying by spraying, dipping, centrifuging or brushing. Recommended dry-film thickness: 5 to 20 µm.

Curing

40 minutes at 23°C, 10 minutes at 50°C, 5 minutes at 90°C (object temperature).

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		Dark gray
Physical properties			
DIN 53211/4	Viscosity at 20°C (DIN4 cup)	s	24
DIN 53217/2	Density at 20°C	g/ml	1.16
CTM 0242 I	Nonvolatile content	%	30
CTM 0007 A	pH at 20°C		8
	Storage life	months	12
Temperature			
	Drying time at 20°C	minutes	15
	Curing time	min/°C	40/23
	Curing time	min/°C	10/50
	Curing time	min/°C	5/90
	Service temperature range	°C	-70 to +200
Load-carrying capacity, wear protection, service life[2]			
ASTM D2625	Falex load-carrying capacity	N	p=11,300 s=7,900
ASTM D2714	LFW-1, rotating F=2,860 N, n=72 rpm, v=7.9 m/min, no. of revolutions x1,000 to µ=0.1		p=343
	LFW-1, oscillating F=900 N @ 89.5 osc/minute, no. of oscillations x1,000 to µ=0.08		p=76
	Fretting corrosion – Deyber test		$10x10^6$

[1]DIN: Deutsche Industrie Norm. CTM: Corporate Test Method; copies of CTMs are available on request. ASTM: American Society for Testing and Materials.

[2]Surface pretreatment: p = phosphate; s = sandblasted.

Solubility
Thinning can be carried out using distilled water or tap water.

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 between 1°C and 30°C in the original unopened containers, this product has a usable life of 12 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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