

MOLYKOTE® 7400

ANTI-FRICTION COATING

Air-curing dry lubricant

FEATURES

- ◆ Free from flammable solvents
- ◆ Water-based, environmentally friendly
- ◆ High load-carrying capacity
- ◆ Low coefficient of friction

COMPOSITION

- ◆ Solid lubricants
- ◆ Inhibitor
- ◆ Organic binder
- ◆ Water
- ◆ Stabilisers

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, non-soiling lubrication of threaded sleeves of car seat adjusting mechanisms, and for the cold working of steel.

TYPICAL PROPERTIES

Specifications writers: These values are not intended for use in preparing specifications. Please contact Dow Corning GmbH, Wiesbaden, Germany before writing specifications on this product.

Standard*	Test	Units	Result
	Colour		Dark grey
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			
ASTM-D2625	Falex load-carrying capacity ¹	N	p=11300 s=7900
ASTM-D2714	LFW-1, rotating ¹ F=2860 N, n=72 min ⁻¹ , v=7.9 m/minutes no. of revolutions x1000 to μ=0.1		p=343
	LFW-1, oscillating F=900N, frequency=89.5osc./minutes no. of oscillations to μ=0.08		p=76

TYPICAL PROPERTIES (continued)

Standard*	Test	Units	Result
	Fretting corrosion - Deyber tester		10x10 ⁶

1. Surface pretreatment: p=phosphated, s=sand blasted.
* CTM: Corporate Test Method, copies of CTMs are available on request.
ASTM: American Society for Testing and Materials.
DIN: Deutsche Industrie Norm

HOW TO USE

Surface preparation

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

How to apply

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

Curing

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

Solubility

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

HANDLING PRECAUTIONS

A Product Safety Data Sheet should be obtained from your nearest Dow Corning sales office prior to use.

ATTENTION: Before handling, read product information, Product Safety Data Sheets and container labels for safe use, and any physical and/or health hazard information.

USABLE LIFE AND STORAGE

When stored between -10°C and 40°C in the original unopened containers this product has a usable life of 12 months from the date of production.

Dow Corning will guarantee the usable life of this product until the date indicated on the packaging. This date is shown by the letters "EXP" (meaning Expiry) followed by 4 digits, which stand for the month (last day) and year. Example: "EXP 03/99" means use by 31 March 1999.

PACKAGING INFORMATION

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

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

Dow Corning's Health, Environment and Regulatory Affairs (HERA) Department is available to support customers for their product safety needs. For further information, you can contact this group at:

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