

## MOLYKOTE® 3402 C ANTI-FRICTION COATING

### Air-curing dry lubricant

#### FEATURES

- ◆ Excellent corrosion protection
- ◆ Excellent lubricity
- ◆ Air-curing
- ◆ Strong pressure and wear resistance

#### COMPOSITION

- ◆ Solid lubricants
- ◆ Organic binder
- ◆ Corrosion inhibitor
- ◆ Solvent

#### APPLICATIONS

- ◆ Excellent combination of corrosion protection and lubrication.
- ◆ Used on main axle threads of drill hammers, spindles.

#### 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		Grey
	<b>Physical properties</b>		
DIN 53211/3	Viscosity at 20°C (DIN3 cup)	s	47
DIN 53217/2	Density at 20°C	g/ml	1.02
CTM 0242 I	Non-volatile content	%	30
	Storage life	years	5
	<b>Temperature</b>		
	Drying time at 20°C	minutes	15
	Curing time	minutes/°C	120/20
	Service temperature range	°C	-200 to +310
	<b>Load-carrying capacity, wear protection, service life</b>		
ASTM-D2625	Falex load-carrying capacity <sup>1</sup>	N	s=10700
ASTM-D2714	LFW-1, rotating <sup>1</sup> F=2860 N, n=72 min <sup>-1</sup> , v=7.9 m/minutes no. of revolutions x1000 to μ=0.1		s=45
ASTM-D2714	LFW-1, oscillating <sup>1</sup> F=900N, frequency=89.5osc./minutes no. of oscillations to μ=0.08		s=25
	<b>Resistance</b>		
	Radiation resistance	rad	10 <sup>8</sup>

1. Surface pretreatment: 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 3402 C 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

120 minutes at 20°C.

## Solubility

Thinning can be carried out using MOLYKOTE® L13 Thinner.

## HANDLING PRECAUTIONS

Product Safety Data Sheets 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 at or below 20°C in the original unopened containers MOLYKOTE 3402 C Anti-friction Coating has a usable life of 60 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:

Dow Corning Europe  
HERA Department  
Rue Général de Gaulle, 62  
B-1310 La Hulpe  
Belgium  
TEL:  
Int +32 (0)2 655 2523  
Int +32 (0)2 655 2304  
FAX:  
Int +32 (0)2 655 2013

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**UNITED KINGDOM, NORDIC COUNTRIES, BENELUX, SOUTH AFRICA, EIRE & MIDDLE EAST**  
Dow Corning  
UNITED KINGDOM  
Tel: INT + 44 (0)1 676 52 80 00  
Fax: INT + 44 (0)1 676 52 80 01

**POLAND**  
Dow Corning Polska Sp. z o.o.  
Tel: INT + 48 (0)22 645 14 45  
Fax: INT + 48 (0)22 645 14 40

**AUSTRIA, GERMANY, SWITZERLAND & EASTERN EUROPE**  
Dow Corning GmbH  
GERMANY  
Tel: INT + 49 (0)611 - 23 71  
Fax: INT + 49 (0)611 - 237 610

**SPAIN & PORTUGAL**  
Dow Corning Ibérica S.A.  
SPAIN  
Tel: INT + 34 (0)93 - 405 12 15  
Fax: INT + 34 (0)93 - 405 38 94

**ITALY & EASTERN MEDITERRANEAN COUNTRIES**  
Dow Corning S.p.A.  
ITALY  
Tel: INT + 39 039 - 60 711  
Fax: INT + 39 039 - 68 99 660

**FRANCE & NORTH AFRICA**  
Dow Corning France S.A.  
FRANCE  
Tel: INT + 33 (0)4 72 84 13 60  
Fax: INT + 33 (0)4 72 84 13 79

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