Gleitpan JF 147

High Performance Bonded Lubricant Coating for High Demands

Klüber Lubrication North America L.P.
32 Industrial Drive
Londonderry, NH 03053
Tel: (603) 647-4104
Fax: (603) 647-4106

Description:

- Gleitpan JF 147 is a special resin-bonded dry film lubricating coating, which was developed for use on automotive and industrial applications.
- The formulation includes a composition of dry lubricants, organic resin binder, and solvents.
- One component, ready-for-use.

Characteristics:

Color	Wet:	Grey/Black	
	Cured:	Grey/Green	
Density (g/ml)		approx. 0.90	
Flash Point (°C)		approx. 9.5	
Pencil Hardness		6H	ASTM D3363-92
Cross-Hatch Adhesion			ASTM D3359-95
Steel Panel		2B	
Aluminum Panel		2B	
Taber Abrasion and Weight Loss			ASTM D4060-95
Steel Panel Weight Loss (g)		approx. 0.017	
Aluminum Panel Weight Loss (g)		approx. 0.008	
Coefficient of Friction			ASTM D1894-95
Steel Panel,	Static	0.177 (approx.)	
	Kinetic	0.125 (approx.)	
Aluminum Panel,	Static	0.176 (approx.)	
	Kinetic	0.123 (approx.)	

Storage:

- Store in a cool, dry, well ventilated area. Keep storage temperatures below 25°C (77°F)
- Keep containers upright and tightly closed when not in use.
- Storage time: 6 months (unopened)

Package Size:

20 Liter Pail

Note:

The data contained on this and the following sheet represents typical performance and processing properties and should not be used as a basis for specification before contacting and review by the Engineering Department of Kluber Lubrication, N.A.

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Coating Process:

- Pretreatment:

  Substrate must be dry and free of all contaminate. Optimum adhesion, performance and wear resistance is achieved through either mechanical grit-blast or chemical conversion of substrate.

- Mixing:

  The product is supplied ready-for-use with no dilution required. It is important to thoroughly mix and stir the product at low speed to assure proper solids dispersion. Low speed roll-mixing of container and/or propeller-type stirring is preferred. Avoid high-speed vortex or violent agitation. Ideal viscosity using a #2 Zahn-Type Dip Viscosity Cup is 38 Zahn-Seconds (ASTM D 816, ASTM D 1084, ASTM D 4212) .

- Application:

  The product should be applied by conventional air spray technique or HVLP external atomization. The coating thickness is dependent on specification and part tolerance and can range from 0.0005 inch to 0.003 inch (12.7 to 76.2 ☯m). The product has both high-build properties as well as offering superior inter-coat adhesion characteristics when re-applied onto itself.

- Curing:

  The product can be cured by either convection oven or infrared process. It is important that the solvents be removed gradually by way of preheating the substrate to a minimum of 150°F (PMT*) before initial coat. Product should then be applied and flash-cured at 210°F for 25 minutes, then increased to 285°F for 40 minutes, with a final cure at 435°F for 5 to 7 minutes.

  The cure schedule is time/temperature related and is essential in order to achieve the proper fully-cured integrity of the coating. It is imperative to avoid solvent entrapment which will result in blistering of the coating.

Suggested Cure Schedule

	Min. Temperature (°F)	Time (min)
Pre-Heat (PMT*)	150	-
Flash Cure	210	25
Inter Cure	285	40
Final Cure	435	5 - 7

- Coverage:

  Theoretical coverage, based on film thickness of 0.001 inch (25.4 ☯m) in a cured form:
  2.4 square meters/liter
  25.8 square feet/liter

- Precautions:

  Product is flammable. Avoid all sources of ignition and refer to Material Safety Data Sheet (MSDS) before use and to fully comply with local, state and federal regulations.

* PMT = Part Metal Temperature