



PRODUCT NAME 66X7560 GREY GRAPHITE VARNISH

DESCRIPTION

Excellent coating for metal machine parts requiring corrosion resistance and dry lubrication up to 350 °F. Meets the requirements of PWA60 (Pratt & Whitney supply code).

PRODUCT DATA

TYPE:	Thermosetting Phenolic Resin
SOLIDS:	24% ± 1%
WEIGHT/GAL:	7.6 ± 0.1 lbs/gal
VISCOSITY:	250-300 cps (#3 @ 10rpm) @ 77° F.
COLOR:	69X0545 corrosion resistant varnish mixed with DAG #154 Graphite which contains 18-20% graphite in colloidal alcohol solution. Will dry grey in color.
APPLICATION:	Dip or Spray
SUBSTRATES:	Clean Metals preferably degreased with chlorinated solvents.
REDUCTION:	None required or may be reduced with 80X0169 Thinner or 79X0434 (AMS 3132 Thinner.)
REC'D FILM THICKNESS:	0.3 – 0.5 mils
CURING:	Air dry to top coat 15 minutes @ 77° F. After 15 minutes air dry; the film should be baked 20 minutes @ 335° F or 50 minutes @ 290° F.
FLASH POINT:	60° – 70° F (Tag Open Cup).
STABILITY:	Keep in tightly closed containers and store Between 40° - 90° F. Under these conditions, the product will remain stable up to 18 months from date of mfg.



REMOVABILITY:

Soak 1 hour in Methylene Chloride or films on panels, cured as above, shall be completely removed within 10 minutes when submerged in the cleaning solution described below, maintained @ 200° F \pm 5° F (93.3° C \pm 2.8°). A soft bristle brush may be used, if necessary, to facilitate removal. Cleaning solution shall be prepared by dissolving 8 oz. of the following mixture in 1 gallon of water, commercial grades of materials may be used.

Parts by weight

Sodium resinate	1
Sodium metasilicate	3
Trisodium phosphate	1
Sodium carbonate	2
Sodium hydroxide	4