



***Molykote*[®] 3400A AERO**

Anti-Friction Coating

FEATURES & BENEFITS

- Excellent lubrication
- High load carrying capacity
- Excellent adhesion to metals
- Low coefficient of friction
- High resistance to oils and fuels
- Good corrosion protection

COMPOSITION

- Solid lubricants
- Organic binders
- Organic solvents

Heat curing dry film lubricant for metal/metal material pairings involving slow to medium-fast movements and medium to heavy loads.

APPLICATIONS

- Suitable for permanent lubrication, with simultaneous corrosion protection of friction contacts involving high loads and low speed.
- Used wherever oils or greases cannot be used for technical reasons or are undesirable because of the risk of soiling.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test*	Property	Unit	Result
	Color		Dark gray
	Service temperature range	°C	-200/+260
		°F	-328/+500
Physical Properties			
ASTM-D 1475	Density at 23°C (73°F)	g/ml	1.1
EN ISO DIN 2431	Viscosity, cup # 3 at 23°C (73°F)	s	38
ASTM-D 56	Flash point	°C	10
		°F	50
Load Carrying Capacity, Wear Protection, Service Life			
ASTM-D 2714	LFW-1, rotating, load 2860 N, n = 72 rpm, v = 7.9 m/min, no. of revolutions to $\mu = 0.1$		p = 158000 ¹
ASTM-D 2714	LFW-1, oscillating, load 900 N, frequency = 89.5 osc./min., no. of oscillations to $\mu = 0.08$		p = 140000 ¹
ASTM-D 2625	Falex, procedure B, load carrying capacity	N lbf	p = 20000 ¹ p = 4500 ¹
ASTM-D 2625	Falex, procedure A, endurance life average at 4450 N load	min.	p > 450 ¹

HOW TO USE

Surface Preparation

Carefully clean and degrease surfaces to be coated with the *Molykote*[®] 3400A AERO Anti-Friction Coating.

Recommended pre-treatments: blasting or phosphating. Both pretreatments increase the adhesion and service life of the *Molykote* 3400A AERO Anti-Friction Coating.

How to Apply

Stir the *Molykote* 3400A AERO Anti-Friction Coating thoroughly before and during use, apply by spraying, dipping, dip-spinning. Surfaces should be coated as evenly as possible. Recommended dry film thickness: 5 to 20 µm.

Coverage

When applied at 10 µm dry film thickness, *Molykote* 3400A AERO Anti-Friction Coating has a coverage of approx. 16 m²/kg (this value does not take into account the losses generated during the application process).

Thinner

Recommended thinner is *Molykote*[®] L 13 Anti-Friction Coating Thinner.

Curing

Typical curing conditions at object temperature: 30 min. at 200°C (392°F) or 60 min. at 150°C (302°F).

HANDLING

PRECAUTIONS

PRODUCT SAFETY

INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEBSITE AT DOWCORNING.COM, OR

TYPICAL PROPERTIES (continued)

Test*	Property	Unit	Result
Resistances			
ASTM-B 117 DIN 50021	Corrosion resistance without red rust (steel substrate, spraying application, film thickness = 10 µm)	h	p = min 100 ²
ASTM-D 2510	Fluid resistance against typical aviation fluids, Proc. C ³		no adhesion loss
ASTM-D 2510	Film adhesion, Proc A		no adhesion loss

*ASTM: American Society for Testing and Materials

*DIN: Deutsche Industrie Norm

¹p = surface pre-treatment = Mn-phosphating

²p = surface pre-treatment = Zn-phosphating

³List of tested aviation fluids is available upon request.

FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

your local Dow Corning representative.

USABLE LIFE AND STORAGE

When stored at temperatures between 0°C (32°F) and 23°C (73°F) in the original unopened containers, this product has a useable life of 24 months from date of manufacture.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

PACKAGING INFORMATION

This product is available in 1 kg can.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

LIMITATIONS

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

Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

HEALTH AND ENVIRONMENTAL INFORMATION

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

TO THE FULLEST EXTENT PERMITTED BY APPLICABLE LAW, DOW CORNING SPECIFICALLY DISCLAIMS ANY OTHER EXPRESS OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY.

For further information, please see our website, dowcorning.com or consult

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