Loc-Lube #5, Powder

Metal Lubricant, Anti-Friction Coating

Loc-Lube #5 is a lubricant (diluted in hot water) which reacts with zinc phosphate coatings on steel to provide a superior lubricant. Reduces tool costs. Provides improved gram weight control on finished parts. Used over steel, aluminum, stainless, and other metals for heavy extreme metal forming operations.

The Loc-Lube #5 coating allows for severe drawing, extruding, and cold forming of metal, and dry lube on finished parts. Provides highest quality lube and anti-friction coatings on springs, latch's, hinge, and other parts. Notice: The use of Poly Film 2555 as the rinse inhibitor after phosphate coating is best.

Loc-Lube #5 is a superior product that is highly stable and provides highest quality low cost productivity to users.

Meets Ford Spec: *ESB-M99C108-A*

Features & Benefits

- Long life bath.
- Resistant to iron and other contaminants.
- Stable chemistry.
- Provides long lasting metal to metal anti-friction.
- Acceptable coating weights have a typical range of:
    - Lubrication range: (updated 8-2016) Light: = 250 mg/ft² (2.5g/m²), Up to heavy 600 mg/ft² (6.5g/m²).
- Light and heavy lubricant films provide superior lubrication on metal-to-metal surfaces.
- Provides lubricant melt point of 270 deg. C. typical.
- Consistent, predictable coatings for high production confidence.
- Lowest use cost of available products.

Physical Data

pH	9.9
Product Type	Powder
Spec. Gravity	0.00
lbs./gal.	0.00
Foam, 0 = Low, 9 = High	9

Shelf-Life Years	10 years
Freeze Information	Not damaged by freezing.

Typical Processing

1. Clean, Acid Pickle, derust-descale, etc.
2. Rinse two times.
3. Zinc Phosphate, TCJ, or Micron MC 500, Lubrication Grade Coating
4. Rinse two times. Neutralizer or anti rust (Poly Film 2555 or 2010).
5. Loc-Lube #5, 2-8 oz/gallon, 180 deg. F., 4 Minutes approximately.
6. Air Dry.
7. To final use area, packaging, draw bench or heading machine.

Special note: Parts must be dry to touch and free of any type of oil, wax, pararfn, silicone, or other surface treatments that interfere with bonding.

Packaging

Container Type	Fiber Drum
Net Units	250
Tare Wt.	15 lb.
Gross Wt.	265
DOT_Name	Not regulated.
DOT Hazard	Not regulated
Tarriff ID	3401.20

Use Parameters

Concentration Range	Approx. 2-8 oz./gal.
Temperature Range	175 – 195 deg. F.
Time Range	2 – 10 minutes.
Agitation	Overflow circulation preferred.

Waste Disposal

Gels upon cooling. Test for contaminants of metals.

Holding Tank Materials of Construction

Steel, stainless, or poly.

Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

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Our People. Your Problem Solvers.

For more information on this process,
please call us at 203.756.5521 or email: techservice@hubbardhall.com

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