

Product Data Sheet

Product: DAG 154

Catalog Number: 60795Q, 60795HG, 60795G, 60795-5G

Distributed By: Ladd Research
83 Holly Court
Williston, VT 05495
Tel: (802) 658-4961
Fax: (802) 660-8859
Email: sales@laddresearch.com

Fast Drying Graphite Dry Film Lubricant

Description: DAG 154, a specially processed graphite dry film lubricant, air dries rapidly at room temperature and adheres tenaciously to most substrates with minimum surface preparation. The thinness of the coating, coupled with high lubricity, provides clean, long-wearing lubrication without redesign of component dimensions. Coatings are easily applied during manufacture or assembly by standard spray, brush or dip techniques.

DAG 154 is an exceptionally stable compound of processed micro-graphite and thermoplastic resin in isopropyl alcohol. This material is also available in aerosol containers (Aerodag G, Catalog number 60782) for convenient on-the-job application. Specific advantages offered by DAG 154 include:

- Ultra-thin opaque film
- High lubricity
- Excellent adhesion to most substrates
- Supplied as a concentrate
- Easy to apply
- Fast room temperature cure
- Minimum pretreatment required

Please note: A version of DAG 154 with controlled electrical properties is also available (See Electrodag 154, Catalog Number 60790)

Typical Applications

- Internal combustion engine components (assembly and break-in).
- Business machines (mating surfaces).
- Mechanisms (vending machines, parking meters).
- Automotive and industrial gaskets.
- Rubber components (assembly and break-in).
- Thread lubricant (anti-seize).
- Opaque coating for film negatives.
- Aerosol lubricant additive.

Typical Properties (as supplied):

- Lubricant Colloidal graphite
- Binder Cellulosic resin
- Fluid component Isopropyl alcohol
- Diluents Commercial alcohols, esters, ketones
- Color Black
- Solids content 20%
- Consistency Gel
- Density 7.5 lbs/gal
- Flashpoint 11°C
- Coverage 450 ft²/gal @ 0.5 mil (12.7 microns)
- VOC 710 g/l

Physical Properties (as cured):

- Coefficient of friction 0.19 (static)
- Service temperature 204°C (the binding resin slowly decomposes above 93°C)
- Intermittent temperature 454°C

Method of Use:

- **Surface Preparation** – Substrates to be coated must be clean and dry. A solvent wipe and air dry is sufficient for most applications.
- **Mixing** – DAG 154 is supplied in concentrated form. This product is thixotropic in nature and will gel on standing. Preparation involves thorough agitation of the concentrate, then dilution with isopropanol or equivalent to the consistency required by the application method chosen.
- **Application** – Diluted DAG 154 can be applied by conventional spray, brush, dip or roller methods. Spraying provides the most uniform coverage of this product. Always agitate thoroughly just before using.
- **Curing:** The coating air dries to touch in five minutes under normal conditions of temperature and humidity. Full cure properties develop in approximately 2 hours depending on film thickness and drying conditions.

Precautions: Flammable. Harmful if swallowed, inhaled or absorbed through skin. May cause eye irritation. Keep away from heat, sparks and open flame. Use with adequate ventilation. Avoid breathing vapors.

NOTE: Dag, Aerodag and Electrodag are registered trademarks of Henkel Corporation.

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