

## TECHNICAL DATA SHEET

### AC 644-W

#### Antifriction Coating / Dry Film Lubricant

#### Description

AC 644W is a water based, fast-drying speciality dispersion. Upon application it air dries and then cures (cross-links) over time to form a hard, tough, low gloss, non-migrating, water resistant continuous coating. Also available formulated with a UV tracer and in a black coloured version.

#### Applications

Excellent as a hard, tough coating for high-pressure areas and functioning parts such as cup holders that need to glide smoothly, seat strikers or tonneau cover rollers, or folder mechanisms. Please refer to the LIP Product Selection Guide.

#### Properties

Property	Typical Value	Conditions
Product Form	Liquid dispersion	
Solids	34%	
Apparent Viscosity	60cP	25°C and 30 sec <sup>-1</sup>
Appearance before application	Milky white	
Density (20°C)	1.09g/ml	ASTM D-1217
Time to Air Dry, thin film	5-20mins*	25°C
Time to Full Cure, thin film	48hrs*	25°C
Cured Film Service Temp Range	-40 to 125°C	
Shelf Life from Date of Manufacture	1 year	Unopened, stored between 8 and 30°C

\* Drying times can vary depending on ambient temperature and humidity

#### How To Use

AC 644W should be shaken or stirred before use then thinly applied by brushing, spraying, wiping or rolling-on to create a thin film that air-dries within 5-10 minutes. Drying can be accelerated by gentle application of heat lamps or air dryers (take care to prevent bubbling). Do not assemble parts until coating has dried; perform final testing after 48 hours if possible. The user should experiment with different LIP products and film thicknesses – only 5-10 µm dry film thickness is usually required.

Note: This is a water-based product so avoid freezing temperatures (before product is applied) and do not apply to bare/unlacquered metal.

#### Packaging Options

- 40ml felt pen
- 1kg plastic container
- 5kg plastic container