

## TECHNICAL DATA SHEET

### AC F-27

#### Antifriction Coating / Dry Film Lubricant

#### Description

AC F-27 is a water-based, low-viscosity, translucent dispersion that utilises polysiloxane-polyurethane technology. Upon application, it air-dries and then cures (cross-links) over time to form a clear, glossy, non-migrating, water-resistant continuous coating. A popular, multi-purpose product that tends to be tolerant of handled, even silicone-treated, surfaces. Free of N-methylpyrrolidone, F-27 is also available formulated with a UV tracer.

#### Applications

Excellent as a clear coating for plastic-on-plastic or where TPO, soft plastic, vinyl (PVC) or leather presses against lacquered (coated) metal, ABS or ABS-PC - Apply to the hard surface in those examples. Please refer to the LIP Product Selection Guide.

#### Properties

Property	Typical Value	Conditions
Product Form	Liquid dispersion	
Solids	27%	
Apparent Viscosity	5cP	25°C and 30 sec <sup>-1</sup>
Appearance before application	Milky white	
Density (20°C)	1.04g/ml	ASTM D-1217
Time to Air Dry, thin film	5-20mins*	25°C
Time to Full Cure, thin film	24-48hrs*	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 F-27 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 5-20 minutes. Drying can be accelerated by gentle application of heat lamps or air dryers (take care to prevent bubbling). However, performance is maximised if allowed to air-dry under ambient conditions. Important that any performance testing is not conducted until 48 hours after application if possible. The user should experiment with different LIP products and film thicknesses - only around 5-10 µ m 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