

SIPIOL® WL 1620-21 G COATING

Technical Data Sheet

Sipiol® WL 1620-21 G coating is an aqueous, single-component, transparent glossy anti-friction coating used for in-line application during production of colored elastomers, such as o-rings. It is composed of a designed solids system in an aqueous polyurethane dispersion.

Features and Benefits

Abrasion Resistant: provides excellent abrasion resistance with a thin dry film thickness [10-20 micron (0.4-0.8 mil)]; provides good abrasion resistance against rotating textile.

Chemically Resistant: provides excellent resistance to cleaning fluids.

Low Coefficient of Friction: provides a low coefficient of friction coating.

Fast Drying: dries quickly at 140°C (284°F) substrate temperature; suitable for spraying on to small parts inside a rotary drum.

Weathering Resistant: provides excellent resistance to weathering; no yellowing in appearance from humid and dry sun exposure.

Application

Surface Preparation: Remove contaminants from surface. For some difficult-to-bond or dense extrusions, prime substrate with either Sipiol WP 8556 or Cuvertin® X 8536 primer. Alternative surface preparation, such as plasma treatment, is recommended for improved adhesion to non-polar substrates.

Mixing: Thoroughly stir Sipiol WL 1620-21 G coating prior to application using an electric stirrer at low speed. If a lower viscosity is required, dilute coating with deionized water, up to 30 parts of water to 100 parts of coating. Before use, filter coating using a sieve with pore size of 125-200 µm.

If coating is spray applied, equip spray container with built-in stirrer to prevent sedimentation.

Applying: Apply Sipiol WL 1620-21 G coating by brush or HVLP spray methods at temperatures above 10°C (50°F). Coating can be applied up to a maximum substrate temperature of 130°C (266°F).

For optimum performance, dry film thickness of Sipiol WL 1620-21 G coating should be 10-20 micron (0.4-0.8 mil).

Drying/Curing: Cure coating at 130-200°C (266-392°F), with dwell time depending on line speed and oven length. Typically, 1-2 minutes at 180°C (356°F) surface temperature is sufficient.

Cleanup: Use water to clean up equipment.

Shelf Life/Storage

Shelf life is one year from date of manufacture when stored properly by the recipient between 5°C and 30°C (41°F and 86°F) in original, unopened container. Temperature control measures are not required during transportation if freezing of the product is prevented. Keep container tightly sealed when not in use to prevent skinning. Do not store near direct heat sources.

Typical Properties*

Appearance	Milky White Liquid
Viscosity, mPa·s / cps @ 25°C (77°F) Brookfield LVT Spindle 1, 30 rpm	50 - 250
Solids Content by Weight, % 2.5 gram dried 30 minutes @ 130°C (266°F)	36.0 - 40.0
Gloss 60° white light	≥10

*Data is typical and not to be used for specification purposes.

Cautionary Information

Before using this or any Parker Lord product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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