

# Sipiol® WL 1025-21 Coating

OBSOLETE

## Technical Data Sheet

Sipiol® WL 1025-21 coating is an aqueous, single-component, anti-friction coating designed for in-line application during production of automotive sealing systems. Sipiol WL 1025-21 coating is a high abrasion-resistant coating with a structured surface.

### Features and Benefits:

**Abrasion Resistant** – provides excellent abrasion resistance against rotating textile and jeans test.

**Durable** – provides excellent chemical resistance and high elasticity.

**Low Coefficient of Friction** – provides a low coefficient of friction coating with improved glass drag properties and non-stick to glass.

**Versatile** – when used in combination with thickener, suitable for off-line application.

**Noise Reduction** – reduces noise generated when surface is in contact with coated metals and glass.

### Application:

**Surface Preparation** – Remove contaminants from surface. Prime substrate with Sipiol WP 8556 or Cuvertin® X 8536 primer. Alternative surface preparation, such as plasma treatment, is recommended for improved adhesion to low polarity substrates.

**Mixing** – Thoroughly stir Sipiol WL 1025-21 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. If a higher viscosity is required, add up to 2% Sipiol TH 2 additive. Before use, filter coating using a sieve with pore size of 250-400 µm.

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

**Applying** – Apply Sipiol WL 1025-21 coating by HVLP spray methods at temperatures above 10°C (50°F). Coating can be applied up to a maximum substrate temperature of 120°C (248°F).

For optimum performance, dry film thickness of Sipiol WL 1025-21 coating should be 10-30 micron (0.4-1.2 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 product is prevented. Keep container tightly sealed when not in use to prevent skinning.

### Typical Properties\*

|                                                                             |              |
|-----------------------------------------------------------------------------|--------------|
| Appearance                                                                  | Black Liquid |
| Viscosity, mPa·s / cps @ 25°C (77°F)<br>Brookfield LVT<br>Spindle 1, 30 rpm | 40 - 100     |
| Solids Content by Weight, %<br>2.5 gram dried 30 minutes @ 130°C (266°F)    | 36.5 - 40.5  |
| Gloss<br>60°                                                                | 1.0 - 4.0    |

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

Cautionary Information:

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Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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