26AV-10

EPOXY COATING: AIR DRY

SERIES E936

FLUID RESISTANCE, CORROSION PROTECTION, CONFORMAL

SANDSTROM PRODUCTS COMPANY

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DESCRIPTION

Sandstrom 26AV-10 is a single component, solvent borne epoxy coating formulated to provide an air dry option in applications where fluid resistance and corrosion protection are desired. This product may be applied by dip or spray application.

What sets Sandstrom 26AV-10 apart is its proven resin system, which matches the original military specified air dry Sandstrom 26A, used for decades in the defense and industrial markets worldwide. The product has been adopted within the electronics industry as a protective coating in circuit boards.

OUTSTANDING FEATURES/BENEFITS

- Allows for application to areas or substrates where heat curing is not practical or possible
- May be applied to most metallic or non-metallic surfaces
- Very Good Dielectric Strength

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet and Technical Data Sheet. The properties listed on this sheet are not intended for use as a specification. Please contact our Technical Service Team.

Refer to our website for answers to common questions:
https://www.sandstromproducts.com/resources/FAQs/

LIMITATIONS

- Not intended for use as a lubricant or to improve load carry or wear life of a component.
- Use a heat cure coating such as Sandstrom 9AV-35 Mod 1, whenever possible for higher performance properties.
- Not approved for use on surfaces that may come into contact with food.

COMPOSITION AND PHYSICAL PROPERTIES

Net Weight per gallon^ *ASTM D1475*	7.5 ± 0.5 lbs./gallon	**Vehicle**	Epoxy
Weight Solids^ *ASTM D2369*	12.5 ± 2.5%	**Lubricating Pigment**	Not applicable
Volume Solids	6.0 - 9.0% (Theoretical)	**Color**	Black or Clear
VOC	6.5 ± 0.2 lbs./gallon (Theoretical)	**Finish**	Matte
Odor	Strong Solvent	**Coverage Rate***	120 sq. ft./gallon @ 0.5 mil DFT
Viscosity^ *ASTM D4212*	35 ± 5 seconds @ 77°F #1 EZ Zahn	**Recommended Coats**	1
Shelf Life	12 Months from Date of Shipment	**Dry Film Thickness** *ASTM D7091*	0.3 to 0.7 mils
Storage Conditions	40°F to 100°F		
Freeze/Thaw Stability	Stable		
Flash Point	40°F (Theoretical)		

*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.
^ Property tested with each production batch.

PERFORMANCE AND FUNCTIONAL PROPERTIES

Chemical/Fluid Resistance:	
MIL-PRF-46147 Table I Fluids ASTM D2510 A&C	Pass
Corrosion Protection:	
ASTM B117: Steel Grit Blasted Cold Rolled Steel	168+ hours @ 0.5 mil
ASTM B117: Steel MIL-DTL-16232 Type M Class 3	400+ hours @ 0.5 mil
Operating Temperature Range	-320°F to +300°F
DIELECTRIC SRENGTH ANALYSIS *ASTM D3755-14*	1180 volts/mil

^ Property tested with each production batch.

GENERAL
Sandstrom 26AV-10 is an air dry, single component coating in a thermosetting resin system thinned with appropriate solvents. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

FILM THICKNESS & ENGINEERING TOLERANCE
As supplied, this product will yield a film thickness of about 0.0004 to 0.002 inches per spray application. Usually engineering tolerances will permit necessary minimum film buildup of 0.0002 to 0.0003 inches without interference. Whenever possible, the proper tolerances should be designed into the part.

COVERAGE
One gallon of this material will cover 120 sq. ft. with a dry film thickness of 0.0005 inches. Coverage depends upon methods of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION
Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed or if surface type is not listed.

Application on steel. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Remove grit blast debris from surface. Phosphate according to MIL-DTL-16232 Type M Class 3 or Type Z Class 3.

Application on stainless steel. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Remove grit blast debris from surface. Passivate surface.

Application on aluminum. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Sulfuric acid anodize IAW MIL-A-8625 and seal surface with hot deionized water (>180°F for 30 minutes).

Application on titanium. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum) and alkaline anodize.

Application on copper alloys. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Pretreat using one of the following methods (in order of preference):
a) Black oxide treat (according to MIL-F-495).
b) Bright dip or grit blast (25-50 RMS optimum).

IMPORTANT! ***DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.*** Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING
IMPORTANT! THIS COATING CONTAINS HEAVY PIGMENTS WHICH SETTLE RAPIDLY. THEREFORE, IT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND **CONTINUOUSLY** DURING APPLICATION.

THINNING (RECOMMENDED RATIOS)
No thinning is required. Use as supplied.

APPLICATION
For spraying – Use as supplied. If thinning is necessary reduce sparingly with 1:1 Blend of MEK and PM.
For dipping – Use as supplied. Thinning not recommended.

CURING
Allow product to air dry for at least 30 to 60 minutes before doing any light assembly work. Allow product to air dry for 18 hours at 77°F ± 5°F and ≤ 70% relative humidity to attain full cure and performance. Accelerated cure may be achieved by moving hot air or using infrared bulbs.

Curing time may also be accelerated by baking when the substrate will not be negatively affected by the temperature. Flash off parts for 30 minutes at 77°F ± 5°F and ≤ 70% relative humidity, then bake for 30 minutes at 250°F.

IMPORTANT! The time starts when **the part** reaches temperature, not when placed in a Class A oven.

CLEANUP
Use 1:1 Blend of MEK and PM for cleaning tools.

REMOVAL
In the event it is necessary to remove product, physical removal is best (such as grit blasting, sanding or grinding). Also, select epoxy cold strippers will remove applied product.

WARNINGS: Constant stirring is imperative for best results.

DANGER! USE WITH ADEQUATE VENTILATION.

Strict compliance to the instructions given in Surface Preparation, Stirring and Baking is very essential for obtaining optimum results.