

# **SURF-KOTE® H-205**

## **HIGH TEMPERATURE**

## **DRY FILM LUBRICANT**

### **SL-143/02**

#### SCOPE:

This specification covers the application of Surf-Kote H-205 dry-film lubricant.

#### MATERIAL:

Surf-Kote H-205 is a mixture of lubricates and bonding materials in a suitable solvent. The solid materials settle during storage, consequently, thorough mixing prior to and during application is required.

The material is supplied in concentrate form. Materials received in concentrate form are to be reduced to spray, dip or brushing consistency by addition of one parts of solvent to one part concentrate.

Shelf life of Surf-Kote dry-film lubricant is one year and the expiration date is stamped on the container. Materials should be discarded after this date.

Surf-Kote materials are to be stored in a cool dry place and should not be exposed to extreme temperatures, particularly freezing temperature.

The solvent, either Toluene or Toluol, used in Surf-Kote are flammable and the material should not be used or stored near an open flame.

#### CLEANING:

Surface to which Surf-Kote is to be applied must be free from scale, dirt or contamination. Surfaces should be cleaned by a method suitable for the

particular material and care should be exercised in cleaning surfaces machined close to tolerances.

After cleaning the article to be coated should be pretreated as indicated.

In order to provide a slightly roughened or adherent surface on parts to be coated, the surfaces shall be either chemically or electrochemically etched, grit blasted, liquid blasted or given a conversion coating that provides good adhesion. Reference Table I.

#### APPLICATION:

Application of Surf-Kote dry-film lubricants require care and strict adherence to specific procedure. Articles should be coated as soon after pretreatment as is practical. Surfaces to be coated are not to be touched with bare hands as grease from fingerprints may cause the coating to flake or peel.

Application of the coating is by spray method, spray gun technique similar to that used in the application of fine finishes, utilizing minimum atomizing air pressure, will assure uniform film deposit.

After coating, the article should air dry for several minutes before curing.

Surf-Kote lubricants should be applied in uniform coatings from .0002 inch to .0005 inch. No gain in performance is to be expected from coatings having a thickness in excess of .0007 inch.



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#### CURING:

The coated article should be cured “at temperature” and for the length to time shown. 1 hour at 650° to 700°F.

#### INSPECTION:

Surf-Kote lubricant coatings should be of a uniform dark gray to dark blue color, or a slight dusty surface.

Adherence of the coatings may be determined by application of a suitable pressure-sensitive tape to the coated surface and removed with a quick abrupt motion. Traces of fine powdery material adhering to the tape are acceptable, but presence of large flakes is cause for rejection.

Thickness measurements may be made by suitable instrument methods such as by micrometers,

magnetic or eddy-current methods, or by microscope methods.

#### WARRANTY:

Hohman Plating & Mfg., Inc. makes no warranty or guaranty, express or implied, of merchantability or fitness for particular purpose of the product. In the event of defect, in no case will Hohman be liable for more than the price paid for this product. Acceptance of merchandise constitutes acknowledgement of this warranty disclaimer.



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TABLE I

MATERIAL	PRETREATMENT	SPECIFICATION NO.
Steel	Phosphate or Vapor Blast	MIL-P-16232 Type M
Stainless Steel Corrosion or Heat Resistant	Vapor Blast	
Aluminum and Aluminum Alloys	Anodized not Sealed	MIL-A-8625 Type II
Magnesium and Magnesium Alloys	Hydrofluoric Acid Etch or Anodize As Applicable	
Brass and Copper Alloys	Chemical Etch (Ferric Chloride) or Vapor Blast	
Titanium and Alloys	Anodize	
Cadmium Zinc or Tin Plated	Phosphate or Conversion Coat	
Nickel, Chromium Rhodium or Silver Plated	Oxidize or Vapor Blast	