

Manufacturers of Precision Cleaners and P-80 Assembly Lubricants
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HOW LONG DOES IT TAKE FOR P-80® ASSEMBLY LUBRICANTS TO DRY?

What is the average dry time for each of the P-80 lubricants?	
P-80® Emulsion and P-80® Emulsion IFC	Both P-80 Emulsion formulas provide a thin film of lubrication to significantly reduce friction during rubber part assembly. The estimated minimum dry time is one hour.
P-80® THIX and P-80® THIX IFC	Both P-80 THIX and P-80 THIX IFC are gels. Their higher viscosity requires more time to dry. The estimated minimum dry time is approximately 2 hours.
P-80® RediLube	P-80 RediLube is thinner than P-80 Emulsion. It leaves negligible residue on the rubber. Regardless of your application technique, P-80 RediLube's low viscosity ensures a thin film that evaporates quickly. The estimated minimum dry time is approximately 20 minutes.
P-80® Grip-It	P-80 Grip-It has low viscosity. It is formulated to leave a fine tacky residue on the surface to provide cling to the assembled parts. The estimated minimum dry time is approximately 20 minutes.

The dry time of each of the P-80® formulas can fluctuate depending on the amount applied, part tolerance, material porosity, and temperature. In some cases it can take up to two days for P-80 to fully dry. The dry time of each P-80 lubricant can be altered by changing the variables listed below:

1. Volume of P-80® applied:

The more P-80 applied to the rubber part, the longer it takes to dry; the less P-80 applied, the shorter the dry time. The amount of P-80 applied can be controlled by the method of application.

- To increase the dry time, use more P-80:
 - Dip or bath: Some P-80 users dip their rubber parts into a container of P-80® before assembly. With this technique, the P-80 completely coats the rubber part.
- To decrease the dry time, less P-80 should be applied. Here are some ways to apply less:
 - Sponge: Place a sponge, which sits higher than the P-80, in the container and gently push down or drag the part across the sponge surface. This provides a negligible P-80 coating on the part, but still enough to lubricate effectively.
 - Hollow-Handle Dishwand: Fill the handle with P-80 and press the sponge top to the part. Bingo blotters can also be used.

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- Handheld Sprayers: Fill the reservoir with P-80® and spray it on the part to be assembled.
- Rubber and Cotton Gloves: Wear cotton gloves over rubber gloves. Dip fingers into P-80 and assemble the part. The rubber gloves prevent the P-80 from saturating the skin.

2. Tolerance of Fitted Parts:

Sometimes the assembled parts have sealed air pockets that trap P-80 inside. The water portion will eventually evaporate, but it takes longer without normal air circulation. Most of these assemblies have barbed ends which hoses must slide over. In this case, do not wet the barbed fitting with P-80. Rather, dip only the end of the hose into P-80. The P-80 will ease the hose over the barb, and the barb will squeegee the excess P-80 from the assembly, eliminating excess P-80 that would otherwise get trapped inside.

3. Porosity of Materials:

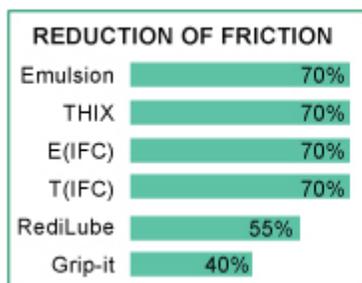
More porous rubbers will have a quicker dry time. For example, Buna-N and EPDM readily absorb any residue so these parts dry rather quickly. Silicones, Viton, and most plastics are less porous, so you may notice some residue and increased dry times.

4. Temperature:

Humid environments will require a greater dry time. Low humidity accelerates dry time. Fans may speed-up the drying process.

If you have tested the above variables and are still not satisfied with the dry time, you may consider trying a different P-80 formula:

- For a quicker dry time try P-80 RediLube or P-80 Grip-It
- For a longer dry time try P-80 THIX



For assistance in determining the best formula for your assembly application, contact International Products Corporation (www.ipcol.com) by email, parts@ipcol.com or by phone, 609-386-8770.