

***Molykote*[®] G-n Metal Assembly Paste and *Molykote*[®] G-n Metal Assembly Spray**

FEATURES

- Excellent protection against fretting wear and corrosion
- Extends service life
- Low friction
- Lubricate beyond the yield point of most metals in boundary applications, reducing wear and helping to prevent seizing, galling and excessive friction
- Aid run-in and reduce frictional force and surface damage
- Low coefficient of friction allows for effective conversion of torquing force into holding force; reduces the force required for disassembly of threaded fasteners

COMPOSITION

- Solid lubricants in mineral oil (with non-chlorofluorohydrocarbon propellant in aerosol)

Extreme-pressure lubricant for assembly, press fitting, threaded connections, running-in and maintenance

APPLICATIONS

Molykote[®] G-n Metal Assembly Paste lubricates surfaces subjected to extreme pressures. Specific applications include:

- Running-in lubricant – for new or rebuilt equipment, such as gears, splines, journal bearings, cams and ways
- Metalworking – helps prevent galling, welding and metal pickup on tools and dies in machining, stamping, and drawing operations, tube bending, thread rolling, cold heading, swaging and forging
- Assembly lubricant – reduces torque in tightening threaded fasteners and tension variation from bolt to bolt; eases disassembly and reduces chance of damage
- Helps prevent fretting wear and corrosion, and cold welding of bearing shafts, bushings and splines
- Press-fitting lubricant – allows press fitting without chatter or stick-slip in most cases; reduces the force required for interference fitting and minimizes distortion

Molykote[®] G-n Metal Assembly Spray is primarily designed as a running-in lubricant for plain bearings, splines, gears, cams and ways, and because of its low coefficient of friction, as a lubricant for movable screws, threaded spindles and lead screws. It can also be used wherever protection against friction and high load conditions is needed, where burnishing is impractical, or where a paste in aerosol form is desired. It is suitable for airframe and aircraft engine applications.

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Method	Test	Unit	Result
CTM ¹ 0300	Appearance		Buttery, grainy
	Color		Gray-black
	Consistency, penetration, unworked	mm/10	300
	Specific Gravity		1.33
	Approximate Service Temperature Range, Solid Lubricant	°F (°C)	0 to 750 (-18 to 399)
CTM 0394	Base Oil	°F (°C)	0 to 250 (-18 to 121)
	Coefficient of Friction ²		0.08
CTM 0351	Four Ball Wear Scar	mm	0.76

CONTINUED TYPICAL PROPERTIES TABLE

Method	Test	Unit	Result
CTM 0172	(80 kg, 1 hour, 1200 rpm, steel vs. steel)		
	Four-Ball Weld Load	kg (lb)	499 (1100)
	Effect on Copper Strip, after 2 hours at 212°F (100°C)		#1, No discoloration

¹CTMs (Corporate Test Methods) correspond to standard ASTM tests in most instances. Copies of CTMs are available upon request.

²LFW-4 Press-Fit Test: steel vs. steel; velocity 0.6 in/min, 10,000 psi, room temperature.

Specification Writers: Please obtain a copy of the Dow Corning Sales Specification for these products and use them as a basis for your specifications. They may be obtained from any Dow Corning Sales Office, or from Dow Corning Customer Service in Midland, MI. Call (989) 496-6000.

DESCRIPTION

Molykote G-n Metal Assembly Paste is a multi-purpose, heavy duty lubricating paste containing a blend of molybdenum disulfide and white solid lubricants in a mineral oil. It helps prevent galling during run-in, helps extend the service life of moving parts, and helps protect against fretting wear and corrosion as well as welding of static joints.

Molykote G-n Metal Assembly Spray is a high-performance paste in aerosol form. It is particularly effective as a running-in lubricant. This product features a low coefficient of friction immediately upon application, without burnishing.

HOW TO USE

Molykote G-n Metal Assembly Paste can be applied in a thin film to clean surfaces by either of the following methods:

- Burnishing – Rub on with a clean, lint-free cloth.
- Brushing – Brush on, preferably using a brush with short, stiff bristles.

Molykote G-n Metal Assembly Spray should be applied in a sweeping motion to obtain a thin, uniform coating. Avoid over-application. No burnishing is required, and although best results are obtained on clean, dry surfaces, *Molykote G-n Metal Assembly Spray* can also be applied on oily surfaces. The lubricant's solvent evaporates within 30 minutes.

USABLE LIFE AND STORAGE

When stored at or below 77°F (25°C), *Molykote G-n Metal Assembly Paste* has a useable life of 60 months from date of manufacture. An oil layer may form on the product surface during storage but may be readily mixed back in by stirring.

When stored at or below 77°F (25°C), *Molykote G-n Metal Assembly Spray* has a useable life of 60 months from date of manufacture. Because it is an aerosol, punctures should be avoided, and containers should be kept away from heat, sparks and open flame.

PACKAGING INFORMATION

Molykote G-n Metal Assembly Paste is available in 2.8-oz (79.3-g), 1-pt (500-g), and 10-, 50- and 165-lb (4.5-, 22.6- and 74.8-kg) containers. *Molykote G-n Metal Assembly Spray* is supplied in 16-fl oz (0.47-L) size aerosol cans containing 11 oz (312 g). All weights net.

LIMITATIONS

When used on threaded fasteners, mineral oil torquing specifications should be reduced by one-third to avoid over tightening. *Molykote G-n Metal Assembly Paste* is not recommended for use in pressure lines and grease guns. This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

SHIPPING LIMITATIONS

Molykote G-n Metal Assembly Paste – None.

Molykote G-n Metal Assembly Spray – DOT Classification: Extremely flammable.

HEALTH AND ENVIRONMENTAL INFORMATION

To support Customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our website, dowcorning.com or consult your local Dow Corning representative.

SAFE HANDLING INFORMATION

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE FROM YOUR DOW CORNING REPRESENTATIVE, OR DISTRIBUTOR, OR BY WRITING TO DOW CORNING

CUSTOMER SERVICE, OR BY
CALLING (989) 496-6000.

**LIMITED WARRANTY
INFORMATION –
PLEASE READ
CAREFULLY**

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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