DAUBERT CROMWELL
The Leading Name in Corrosion Prevention®

Technical Data

12701 S. Ridgeway Ave
Alsip, IL 60803
USA

Toll free: 800-535-3535
888-846-4299
Fax: 708-293-7765

Tel: 708-293-7750
E-mail: info@daubertcromwell.com

Nox-Rust® 5400

(Oil With Petroleum Additives)

Nox-Rust 5400 liquid is a petroleum-based sheet metal processing lubricant and preservative for use:

1. On coiled stock as a combination corrosion preventive and pre-lube.
2. In blankers (auto-shear) as a wash which leaves behind a lubricant and corrosion preventive film.
3. As a corrosion preventive spray on steel and steel parts.

Nox-Rust 5400 is approved as a preservative and lubricant on sheet and coiled steel for both Ford and General Motors, as it is non-interfering with body and assembly sealers, adhesives, and cleaning systems.

Physical Properties	**(Typical Values)**
Film Character:	Oily, non-drying
Flash Point (COC):	250°F minimum
Application:	Spray, dip, brush, or roller coat
Viscosity SUS @ 100°F:	81
Lbs/Gal:	7.4
Specific Gravity:	0.890
Removal:	Easily removed with conventional cleaning methods
Pour Point:	Less than 15°F

Performance and Protective Properties

Acid Atmosphere Test: Material will protect cold rolled steel from stain or corrosion for a minimum of 16 hours exposure to a 25 ppm HCI atmosphere. Test method: Ford Motor Company BJ7-6.

Condensing Humidity Test: Material will protect cold rolled steel from corrosion for a minimum of 72 hours exposure in the Cleveland Condensing Cabinet. Test Method: Ford Motor Co. BJ7-7.

Humidity Cabinet (100°F/100% RH) on:
Cold Rolled Body Steel, 500 hrs, no stain or corrosion
One Side Zincrometal, 500 hrs, no stain or corrosion
Galvanized, Two Side, 500 hrs, no stain or corrosion
Galvanized, One Side, 500 hrs, no stain or corrosion

Stack Tests:
Cold Rolled Body Steel, 500 hrs, no stain or corrosion
Galvanized Two Side, 500 hrs, no stain or corrosion
Zincrometal, 500 hrs, no deterioration of zincrometal

Procedure: Zincrometal unpolished cold rolled steel and galvanized panels are coated to a coating thickness of 0.5 mil. Panels are then stacked and clamped to form a tight bundle. Bundles are then exposed to 100% relative humidity at 100° F. for 500 hours.

Atmospheric Testing:

Cold rolled steel panels, coated to a 0.5 mil film thickness with Nox-Rust 5400, hung in an industrial warehouse environment, showed no signs of corrosion, stain or varnish after 9 months. Experience in several stamping plants, using Nox-Rust 5400 as a forming lubricant, has shown that only the residual Nox-Rust 5400 protected formed parts for more than 3 months under high humidity storage conditions, without any signs of rust, stain, or varnishing.

Automotive Specifications:

Approved, Gen. Motors 998-1833; Ford Motor Co. M4B90A.

Surface Preparation

Maximum performance of Nox-Rust 5400 can be achieved only when the metal surfaces to be protected are clean, dry and free of rust, oil and mill scale. Daubert Cromwell recommends that the metal substrate temperature be 50-95°F (10-35°C) at the time of product application.

Application

Nox-Rust 5400 is formulated to be used as supplied. Ensure uniform consistency prior to use. Continued stirring is generally not required. If product thickens due to cold storage or loss of solvent during use, contact Daubert Cromwell. DO NOT THIN. Incorrect thinning will affect film build, dry time and product performance. Recommended ambient and product temperature is 50-95°F (10-35°C) at time of application. Nox-Rust 5400 can be airless spray applied

Removal

Removability and compatibility with phosphating sytems: Material is easily removed during phosphate wash operations and has no adverse effect on subsequent priming, painting or welding operations.

Storage

Store at temperatures between 50-95°F (10-35°C). Mild agitation is recommended prior to use.

Caution

Adequate ventilation is required for cure and to ensure against formation of a combustible liquid. THE PARTIALLY CURED FILM SHOULD NOT BE EXPOSED TO IGNITION SOURCES SUCH AS FLARES, FLAMES, SPARKS, EXCESSIVE HEAT, OR TORCHES. Refer to Material Safety Data Sheet for additional handling and first aid information.

Note:

The addition of any product over or under this coating is not recommended. The use of additional coatings could result in chemical incompatibility, thus adversely affecting the performance of this coating as stated in the lab data section. If a product other than Daubert Cromwell's recommended product is required, written authorization must be obtained from Daubert Cromwell.

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The data, statements and recommendations in this product information sheet are based on testing, research and other development work, which has been carefully conducted by us, and we believe such data, statements and recommendations will serve as reliable guidelines. Physical properties shown above represent typical values and are not intended for use in writing specifications. However, this product is subject to numerous uses under varying conditions over which we have no control, and accordingly, we do NOT warrant that this product is suitable for any particular use. Users are advised to test the product in advance to make certain it is suitable for their particular production conditions and use.

WARRANTY – All products manufactured by us are warranted to be first class material and free from defects in material and workmanship.
Liability under this warranty is limited to the net purchase price of any such products proven defective or, at our option, to the repair or replacement of said products upon their return to us transportation prepaid. All claims on defective products must be made in writing within 30 days after the receipt of such products in your plant and prior to further processing or combining with other material and products.

WE MAKE NO WARRANTY, EXPRESS OR IMPLIED, AS TO THE SUITABILITY OF ANY OF OUR PRODUCTS FOR ANY PARTICULAR USE, AND WE SHALL NOT BE SUBJECT TO LIABILITY FROM ANY DAMAGES RESULTING FROM THEIR USE IN OPERATIONS NOT UNDER OUR DIRECT CONTROL.

THIS WARRANTY IS EXCLUSIVE OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, AND NO REPRESENTATIVE OF OURS OR ANY OTHER PERSON IS AUTHORIZED TO ASSUME FOR US ANY OTHER LIABILITY IN CONNECTION WITH THE SALE OF OUR PRODUCTS.

Daubert Cromwell, 12701 S. Ridgeway Ave., Alsip, IL 60803 USA 800- 535-3535 Tel::+1- 708-293-7750 Fax: +1- 708-293-7765 www. daubertcromwell.com