

# Sipiol® WL 2010-23/WV 21 Coating

## Description

LORD Sipiol® WL 2010-23/WV 21 coating is a smooth, aqueous, two-component, anti-friction coating designed specifically for off-line application during production of automotive sealing systems.

## Features and Benefits

**Abrasion Resistant** – provides excellent abrasion resistance against rotating textile.

**Durable** – provides excellent chemical resistance and high elasticity.

**Low Coefficient of Friction** – provides a low coefficient of friction.

**Noise Reduction** – reduces noise generated when surface is in contact with coated metals.

Abrasion Resistant	Chemically Resistant	Low Coefficient of Friction	Noise Vibration	Weathering
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## Application

**Surface Preparation** – Remove contaminants from surface. Prime substrate with either Sipiol WP 8555 or Cuvertin® X 8536 primer. Alternative surface preparation, such as plasma treatment, is recommended for improved adhesion to low polarity substrates.

**Mixing** – Thoroughly stir Sipiol WL 2010-23 coating prior to application using an electric stirrer at low speed. If a lower viscosity is required, dilute coating with deionized water, up to 30 parts of water to 100 parts of coating.

While continuously stirring the coating, slowly add Sipiol WV 21 curative at a ratio of 100 parts coating to 3 parts curative, by weight. Before use, filter coating using a sieve with pore size of 200-400 µm.

If coating is spray applied, equip spray container with built-in stirrer to prevent sedimentation.

**Applying** – Apply Sipiol WL 2010-23/WV 21 coating by brush or HVLP spray methods at temperatures above 10°C (50°F). Coating can be applied up to a maximum substrate temperature of 120°C (248°F).

For optimum performance, dry film thickness of Sipiol WL 2010-23/WV 21 coating should be 10-20 micron (0.4-0.8 mil).

## Typical Properties\*

	WL 2010-23 Coating	WV 21 Curative	Mixed**
Appearance	Black Liquid	Clear Liquid	Black Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT	400-600 Spindle 2, 30 rpm	950-1750 Spindle 3, 30 rpm	~410-640 Spindle 2, 30 rpm
Density @ 20°C (68°F) g/cm <sup>3</sup> (lb/gal)	1.00-1.10 (8.3-9.2)	1.12-1.15 (9.3-9.6)	1.00-1.10 (8.3-9.2)
Solids Content by Weight, % 2.5 gram dried 30 min @ 130°C (266 °F)	31-36	>98	33-36
Working Life, hr @ 25°C (77°F)	–	–	8

\*Data is typical and not to be used for specification purposes.

\*\*Mix ratio 3% Sipiol WV 21 curative.

# LORD TECHNICAL DATA

**Drying/Curing** – Cure coating at 90-200°C (194-392°F), with dwell time depending on line speed and oven length. Typically, 15 minutes at 130°C (266°F) is sufficient.

**Cleanup** – Use water to clean up equipment.

## Shelf Life/Storage

Shelf life is one year for Sipiol WL 2010-23 coating and six months for Sipiol WV 21 curative from date of manufacture when stored in a well ventilated area below 20°C (68°F) in original, unopened container. Do not store near direct heat sources. Keep container tightly sealed when not in use to prevent skinning. Do not freeze product.

## Cautionary Information

Before using this or any LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

*For industrial/commercial use only.* Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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