Sipiol® WL 1025-21 coating is an aqueous, single-component, anti-friction coating designed for in-line application during production of automotive sealing systems. Sipiol WL 1025-21 coating is a high abrasion-resistant coating with a structured surface.

Features and Benefits:

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

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

**Low Coefficient of Friction** – provides a low coefficient of friction coating with improved glass drag properties and non-stick to glass.

**Versatile** – when used in combination with thickener, suitable for off-line application.

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

Application:

**Surface Preparation** – Remove contaminants from surface. Prime substrate with 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 1025-21 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. If a higher viscosity is required, add up to 2% Sipiol TH1 additive. Before use, filter coating using a sieve with pore size of 250-400 µm.

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

**Applying** – Apply Sipiol WL 1025-21 coating by 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 1025-21 coating should be 10-30 micron (0.4-1.2 mil).

**Drying/Curing** – Cure coating at 130-200°C (266-392°F), with dwell time depending on line speed and oven length. Typically, 1-2 minutes at 180°C (356°F) surface temperature is sufficient.

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

Shelf Life/Storage:

Shelf life is one year from date of manufacture when stored properly by the recipient between 5°C and 30°C (41°F and 86°F) in original, unopened container. Temperature control measures are not required during transportation if freezing of product is prevented. Keep container tightly sealed when not in use to prevent skimming.

### Typical Properties*

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Black Liquid</td>
</tr>
<tr>
<td>Viscosity, mPa·s/cps @ 25°C (77°F)</td>
<td>40 - 100</td>
</tr>
<tr>
<td>Brookfield LVT</td>
<td></td>
</tr>
<tr>
<td>Spindle 1, 30 rpm</td>
<td></td>
</tr>
<tr>
<td>Solids Content by Weight, %</td>
<td>36.5 - 40.5</td>
</tr>
<tr>
<td>2.5 gram dried 30 minutes @ 130°C (266°F)</td>
<td></td>
</tr>
</tbody>
</table>

*Data is typical and not to be used for specification purposes.
Cautionary Information:

Before using this or any Parker 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.