PRECISION FLUIDS

Technical Data Sheet

Solutions Through Innovative Technology

PRO-TEK 3711
RUST PREVENTATIVE

Description

Pro-Tek 3711 is a petroleum based sheet metal processing lubricant and preservative for use on coiled stock as a combination rust preventive and pre-lube; in blankers (auto-shear) as a wash which leaves behind a lubricant and rust preventive film; and as a rust preventive spray on steel and steel parts. Pro-Tek 3711 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.

Health & Safety

See the most recent MSDS which is available directly from Precision Fluids, your local salesman, or authorized distributor. Precision Fluids uses only raw materials not listed as carcinogenic by IRAC.

Storage:

Store Pro-Tek 3711 at temperatures between 50-95°F (10-35°C). Mild agitation is recommended prior to use.

Automotive Specifications:

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

Physical Data

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

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 with Pro-Tek 3711 to a coating thickness of 0.5 mil. Panels are then stacked and clamped to form a tight bundle. Bundles are then exposed to a 100% relative humidity at 100°F for 500 hours.

Removal:

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

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 Precision Fluids' 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 Precision Fluids recommended product is required, written authorization must be obtained from Precision Fluids, Inc.

Atmospheric Testing

Cold rolled steel panels, coated to a 0.5 mil film thickness with Pro-Tek 3711 hung in an industrial warehouse environment, showed no signs of corrosion, stain or varnish after 9 months. Experience in several stamping plants, using Pro-Tek 3711 as a forming lubricant, has shown that only the residual Pro-Tek 3711 protected formed parts for more than 3 months under high humidity storage conditions, without any signs of rust, stain, or varnishing.

Surface Preparation:

The maximum performance of Pro-Tek 3711 can be achieved only when the metal surfaces to be protected are clean, dry and free of rust, oil and mill scale. Precision Fluids recommends that the metal substrate temperature be 50-95°F (10-35°C) at the time of product application.

Application:

Pro-Tek 3711 is formulated to be used as supplied. Ensure uniform consistency prior to use. Continued stirring is generally not required. If the product thickens due to cold storage or loss of solvent during use, contact Precision Fluids DO NOT THIN Pro-Tek 3711. Incorrect thinning will affect film build, dry time and product performance. Precision Fluids recommends that the ambient and product temperature be 50 - 95° F (10 - 35°C) at time of application Pro-Tek 3711 can be airless spray applied.

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