DAUBERT VCI® NOX-RUST® LIQUID
5400
(Oil With Petroleum Additives)

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

1. Use on coiled stock as a combination corrosion preventive and pre-lube.
2. Use in blankers (auto-shear) as a wash which leaves behind a lubricant and corrosion preventive film.
3. Use 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

Lubrication
Customer experience has rated Nox-Rust 5400 "excellent" to "very good" when used as a lubricant forming exterior body parts, on light to moderate on specific requirements; yet it has been found that a .4 mil application thickness will provide maximum corrosion protection and lubrication with no problems of dripping.

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 HCl atmosphere.
- 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 Nox-Rust 5400 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.

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.

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