

Product Information

Specialty Lubricants

Dow Corning® 77 Part Assembly Paste

FEATURES

- Extreme pressure, antiseize lubricant
- Protects against fretting wear and high temperatures

COMPOSITION

- Molybdenum disulfide paste (lithium stearate in soap-thickened silicone fluid)

Extreme pressure, antiseize lubricant for assembly of new and rebuilt parts, press fits and threaded connections

USES

Dow Corning® 77 Part Assembly Paste lubricates surfaces subject to extreme pressures and wide temperature ranges. It is used to prevent galling during running-in, extend the wear life of moving parts and help protect against fretting and cold welding of moving joints.

Dow Corning 77 Part Assembly Paste is typically used as:

- A running-in lubricant for new or rebuilt equipment – gears, splines, journal bearings, cams and ways
- An assembly lubricant to reduce torque in tightening threads and bolts, minimize tension variation from bolt to bolt, and ease disassembly and reduce the chance of damage
- A press-fitting lubricant to allow press fitting without chatter or stick-slip (reduces the force required for interference fitting and minimizes distortion)
- A general-purpose lubricant for bearing shafts, bushings, splines, O-rings, packings and seals (except silicone rubber)

TYPICAL PROPERTIES

These values are not intended for use in preparing specifications.

Standard	Test	Unit	Result
	Color		Black
ASTM D 217	Consistency, penetration, unworked	mm/10	305
	Density at 77°F (25°C)	lb/gal	16.0
CTM ¹ 0394	Coefficient of Friction ²		0.12
ASTM D 2596	Four Ball Weld Load, lb		449
	Estimated Temperature Range	°F	-50 to 450
		°C	-45 to 230
	Solids	°F	To 750
		°C	To 400

¹Corporate Test Methods (CTMs) are based upon standard ASTM tests in most instances. Copies of CTMs are available upon request.

²Test conditions: Faville LeValley LFW-4 press fit test machine – steel/steel; velocity 0.6 in/min; 10,000 psi; room temperature.

Specification Writers: Please obtain a copy of the Dow Corning Sales Specification for this product and use it as a basis for your specifications. It may be obtained from any Dow Corning Sales Office, or from Dow Corning Customer Service in Midland, MI. Call (517) 496-6000.

DESCRIPTION

Dow Corning 77 Part Assembly Paste is a multipurpose, extreme pressure lubricating paste that can be used over a wide temperature range. It contains over 60 percent molybdenum disulfide lubricating solids in a soap-thickened silicone fluid.

The solid lubricants in *Dow Corning 77 Part Assembly Paste* provide boundary lubrication and low friction at pressures to 500,000 psi or to the yield point of the substrate.

Dow Corning 77 Part Assembly Paste also helps protect against fretting corrosion and resists oxidation.

Dow Corning 77 Part Assembly Paste has a wide service temperature range, estimated at -50 to 450°F (-45 to 230°C) in paste form (solids to 750°F (400°C)).

HOW TO USE

Dow Corning 77 Part Assembly Paste is typically applied to a cleaned surface in a thin film by either burnishing with a lint-free cloth or brushing with a short, stiff-bristled brush.

Because of the high solids content and specific gravity of *Dow Corning 77 Part Assembly Paste*, the silicone oil has a tendency to separate. However, the oil can be easily mixed back into the paste.

USE LIMITATIONS

Dow Corning 77 Part Assembly Paste is not recommended for use in

pressure lines nor should it remain in grease guns for extended periods of time.

Dow Corning 77 Part Assembly Paste should be thoroughly tested before using with plastics and rubbers.

This material is neither tested nor represented as suitable for medical or pharmaceutical uses.

SHIPPING LIMITATIONS

None.

STORAGE AND SHELF LIFE

When stored under normal warehouse conditions, *Dow Corning 77 Part Assembly Paste* has a shelf life of 60 months from date of manufacture. Refer to product packaging for "Use By" date.

PACKAGING

Dow Corning 77 Part Assembly Paste is supplied in 1-pint/2-lb (0.47-L/1-kg), 1-gal/15-lb (3.8-L/6.8-kg) and 4.5-gal/40-lb (17.0-L/18.1-kg) containers. All weights, net.

SAFE HANDLING INFORMATION

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE

FROM YOUR DOW CORNING REPRESENTATIVE, OR DISTRIBUTOR, OR BY WRITING TO DOW CORNING CUSTOMER SERVICE, OR BY CALLING (517) 496-6000.

WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that Dow Corning's products are safe, effective, and fully satisfactory for the intended end use.

Dow Corning's sole warranty is that the product will meet the Dow Corning sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. Dow Corning specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless Dow Corning provides you with a specific, duly signed endorsement of fitness for use, Dow Corning disclaims liability for any incidental or consequential damages. Suggestions of use shall not be taken as inducements to infringe any patent.