
TECHNICAL DATA BULLETIN

Appearance: Milky white dispersion

Description: Bright Dyes® TF-60 PTFE forms a unique, long-lasting PTFE coating on metal surfaces where high lubricity is required. It is environmentally safe to use, easy to maintain and operate, and meets MIL-A-62576 Type I and AMS 2482A.

Performance: Bright Dyes TF-60 will provide a coefficient of lubricity ($m = 0.1$).

Prior to Use: Mix/shake container gently

Parts should be clean and free of any oil, grease, or dirt. They should be dry and at room temperature before being dipped or sprayed with TF-60 solution.

Dyed parts should be sealed and at room temperature prior to using TF-60 solution.

Long parts should be racked in a vertical position to facilitate draining.

Application: Bright Dyes TF-60 may be applied by dipping, spraying or wiping on the anodized part. The anodic coating provides a natural bonding pocket for the PTFE.

Operating Parameters

Tank:	Polypropylene, plastic, or stainless steel
Water type:	Deionized or reverse osmosis preferred
Concentration:	25% by volume
pH:	9.0 – 10.0 (Raise with ammonium hydroxide, lower with sulfuric acid)
Temperature:	Ambient
Immersion Time:	30 – 90 seconds
Curing (Heated):	Allow parts to air dry, then place in oven at 170 - 200° F for 25 – 30 minutes.
Curing (Air):	Allow Bright Dyes TF-60 solution to completely evaporate in ambient air leaving only the PTFE coating. Complete air drying may take up to 24 hours.

Storage and Safety

- Store in a cool, dry location, preferably in original container
- Keep solution temperature between 50 - 90° F. **Do not allow to freeze.**
- May cause irritation if allowed to contact skin. The use of gloves and goggles is recommended when handling this product. Consult the MSDS for more information.

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