
**PRODUCT
INFORMATION****NOX-RUST® R-461-90****Description**

NOX-RUST® R-461-90 is a petroleum based sheet metal processing lubricant and preservative designed for use on coiled stock as a combination rust preventive and pre-lube, in blankers and high speed auto-shear as a wash designed to leave behind both a lubrication and rust inhibiting film. NOX-RUST® R-461-90 is also used in press line lubricant applicators and blank

washers as a wash, stamping lubricant to protect against rust after forming, and as a rust preventive spray on formed parts. NOX-RUST® R-461-90 is acceptable as a preservative and lubricant on sheet and coil, and is non-interfering with Body and Assemble sealers, adhesives and pre-conditioning systems.

Physical Properties**Typical Values**

Film Character	Oily, non-drying
Flash Point	250 °F (min.)
Application	Spray, dip, brush or roller coat
Viscosity CST @40°C	11 CST
Specific Gravity	0.90
Removal	Solvent, alkaline cleaners
Odor	Oily
Pour Point °F	<5

Lubrication

NOX-RUST® R-461-90 is a multi-purpose draw lubricant, blank cleaner, flex roll lubricant, and rust preventive for cold rolled sheet and galvanized coated steel.

The material is applied, as received, for forming automotive parts by dip, spray or roll coat application.

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. BJ-7-7.

Removability and Compatibility with Phosphating Systems

Material is easily removed during phosphate wash operations and will have no adverse effect on subsequent priming, painting or welding operations.

Surface Preparation

The maximum performance of NOX-RUST® R-461-90 can be achieved only when the metal surfaces to be protected are clean, dry and free of rust, oil and mill scale. Daubert Chemical Company recommends that the metal substrate temperature be 50-95°F (10-35°C) at the time of product application.

Application

NOX-RUST® R-461-90 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 Daubert Chemical Company. DO NOT THIN NOX-RUST® R-461-90. Incorrect thinning will affect film build, dry time and product performance. Daubert Chemical Company recommends that the ambient and product temperature be 50 - 95°F (10 - 35°C) at time of application. NOX-RUST® R-461-90 can be spray or dip applied.

Removal

NOX-RUST® R-461-90 can be removed with a solvent borne thinner, vapor degreasing, hot alkaline wash, or low-pressure steam. NOX-RUST® R-461-90 can be removed from fabrics by normal dry cleaning procedures. Avoid the use of chlorinated or highly aromatic solvents when removing from painted surfaces, as these solvents may adversely affect paint.

Storage

Store NOX-RUST® R-461-90 at temperatures between 50-95°F (10-35°C). Mild agitation is recommended prior to use.

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 Daubert's 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 Daubert Chemical Company's recommended product is required, written authorization must be obtained from Daubert Chemical Company.

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CAUTION: The data, statements and recommendations set forth in this product information sheet are based on testing, research and other development work which has been carefully conducted by us, and we believe such data, statements and recommendations will serve as reliable guidelines. However, this product is subject to numerable uses under varying conditions over which we have no control, and accordingly, we do NOT warrant that this product is suitable for any particular use. Users are advised to test the product in advance to make certain it is suitable for their particular production conditions and particular use or uses.

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REFER TO MATERIAL SAFETY DATA SHEET FOR HEALTH AND SAFETY INFORMATION.

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