


**ePaper 17.10**

# Which P-80® Lubricant Is Right for My Assembly?

**P-80® is a line of temporary rubber assembly lubricants designed to decrease the force needed to install rubber parts, enabling them to slide easily into place.**

P-80 lubricants are water-based and do not contain alcohol or petroleum distillates, so they will not cause rubber to swell, dry out or harden. P-80 does not contain silicon or other persistent ingredients, so once dry the slipping action goes away and parts stay in place.

P-80 lubricants do not contain any hazardous ingredients, making them safe for workers and the environment. Most P-80 products are biodegradable.

## Emulsion? THIX? Grip-It? RediLube? ...What's the Difference?

All P-80 products provide temporary lubrication needed to reduce friction during rubber assembly to make it easier to install parts. Since each assembly application is unique, IPC has developed different P-80 formulas so workers can choose the product that will work best for their particular application.

## Which P-80 is right for my application?

Each P-80 formula has unique properties designed to meet the needs of specific types of rubber and soft plastic assembly applications. Consider these factors to figure out which P-80 product will work best for your application:

- Amount of lubricity required
- Method of application
- PVT testing or other dry-time requirements
- Type of rubber or plastic being used
- User preference

## P-80 Formula Specifications

	Industrial Lubricants				Incidental Food Contact Lubricants	
	P-80® Emulsion	P-80® THIX	P-80® Grip-it	P-80® RediLube	P-80® Emulsion (IFC)	P-80® THIX (IFC)
<b>Viscosity Index, cps @25°C</b>	150	12,000	20	20	150	15,000
<b>Biodegradable</b>	Yes	Yes	No	Yes	Yes	Yes
<b>Reduction of Friction</b>	~70%	~70%	~40%	~55%	~70%	~70%
<b>Estimated minimum dry time</b>	1 hour	2 hours	20 minutes	20 minutes	1 hour	2 hours
<b>pH</b>	8.4	8.5	10.8	8.7	8.7	8.5
<b>Appearance</b>	Milky white to beige	White to beige gel	Clear, colorless	Milky white to light yellow	Milky white to beige	White to beige gel

For some assemblies, only one P-80 formula may resolve the assembly challenge. In many instances, more than one P-80 formula might work well. The choice is often based on user preference.

## P-80® Temporary Rubber Assembly Lubricants

### P-80® Emulsion

P-80 Emulsion is a biodegradable blend of synthetic esters and water. P-80 Emulsion provides a thin film of lubrication to significantly reduce friction when assembling rubber or soft plastic parts. The estimated minimum dry time is one hour.

### P-80® THIX

P-80 THIX is a biodegradable, non-drip thixotropic gel that remains where it is applied without dripping. P-80 THIX is especially useful in overhead and vertical assembly applications, and when prolonged drying times are desired. The estimated minimum dry time is approximately 2 hours.

### P-80® RediLube

P-80 RediLube is a biodegradable, low residue formula. P-80 RediLube dries quickly and completely, making it ideal for use on parts with low surrounding air flow and on non-porous and coated rubber and soft plastic parts. P-80 RediLube is thinner than P-80 Emulsion. Regardless of your application technique, P-80 RediLube's low viscosity ensures a thin film that evaporates quickly. The estimated minimum dry time is approximately 20 minutes.

### P-80® Grip-It

P-80 Grip-it provides lubricity to ease rubber assembly operations and then dries quickly to allow the natural tight fit of rubber to return. P-80 Grip-it leaves a tacky finish to help assembled parts stay in place. Excellent for use on pressure-tested hoses. The estimated minimum dry time is approximately 20 minutes.

### P-80® Emulsion IFC

P-80 Emulsion IFC has the same lubricating properties as P-80 Emulsion but it is specially formulated for use in incidental food contact applications. Typical applications include assembly of appliances, pumps, and food-processing equipment. P-80 Emulsion IFC is registered with NSF for use in USDA H1 applications and meet FDA regulation 21 CFR 178.3570, which controls lubricants used for incidental food contact applications. The estimated minimum dry time is approximately 1 hour.

### P-80® THIX IFC

P-80 THIX IFC has similar properties to P-80 THIX but is formulated for use in incidental food contact applications. P-80 THIX IFC is a thixotropic gel that remains where it is applied without dripping, making it especially useful in overhead and vertical applications. P-80 THIX IFC is registered with NSF for use in USDA H1 applications and meet FDA regulation 21 CFR 178.3570, which controls lubricants used for incidental food contact applications. The estimated minimum dry time is approximately 2 hours.

Want more information about temporary rubber assembly lubricants, including how to use them and assistance in determining which P-80 formula will best serve your needs?

Visit our website [ipcol.com](http://ipcol.com) or contact our technical team.



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