METRIC

DOD-L-85645A(AS)
AMENDMENT 2
02 March 2000
SUPERSEDING
AMENDMENT 1
18 January 1994

MILITARY SPECIFICATION

LUBRICANT, DRY FILM, MOLECULAR BONDED

Inactive for new design after 15 September 1999.

This amendment forms a part of DOD-L-85645A, dated 15 October 1988, and is approved for use by the Naval Air Systems Command, Department of the Navy, and is available for use by all Departments and Agencies of the Department of Defense.

PAGE 2

2.1.2: Delete title of FED-STD-313 and substitute "Material Safety Data, Transportation, and Disposal Data for Hazardous Material Furnished to Government Activities."

PAGE 10

APPENDIX, delete in its entirety and substitute:

"APPENDIX

* INSTRUCTIONS FOR APPLYING LUBRICANT, DRY FILM, MOLECULAR BONDED

10. SCOPE

10.1 Scope. This appendix covers the application of the dry film lubricant when it is applied over various metal surfaces. This appendix is not a mandatory part of the specification. The information contained herein is intended for guidance only.

DISTRIBUTION STATEMENT A. Approved for public release; distribution is unlimited.

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20. APPLICABLE DOCUMENTS

20.1 Government documents. The following documents form a part of this Appendix to the extent specified herein.
SPECIFICATIONS

FEDERAL

*

TT-N-95 - Naphtha, Aliphatic

(Copies of specifications, standards, drawings and publications required by manufacturers in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

30. REQUIREMENTS

30.1 Inspection. All parts, prior to being degreased, shall be free of all foreign matter. Assemblies with plastic or other non-metallic components shall be degreased only when authorized by the contract or applicable drawing. Parts that are excessively soiled or contaminated shall undergo a preliminary cleaning in a steam bath, or soak in a detergent type cleaner providing such treatment is authorized by the contract or applicable drawing.

* 30.2 Cleaning. Oils, greases, waxes and other foreign matter shall be cleaned from test specimens and parts by solvent wiping with a bleached cotton cheesecloth soaked with aliphatic naphtha conforming to TT-N-95. The surface shall be air blasted with a suitable mesh powder that can provide a uniform clean surface. The blast shall not exceed 690 kPa and will be directed in such a manner as to not change the surface dimensional tolerances.

30.3 General instructions for all metals. All metal surfaces shall be treated or coated in accordance with the applicable specification or drawing before applying the lubricant.

30.4 Application. The lubricant is applied through an air blast gun at 828 kPa, 25.4 to 30.5 cm from the part. Only one coat of dry film lubricant can be applied. Material will not adhere to itself for additional buildup. The control thickness ranges from 0.00038 and 0.00051 mm, but should not exceed 0.0025 mm unless otherwise specified in the contract or purchase order and determined in accordance with ASTM D1186.

30.5 Curing. Curing shall be in accordance with the applicable classification. Recommended cure cycles are as follows:

Type I: No curing required.

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Type II: Air Dry. Seven days at ambient temperature (25 °C nominal) before using part in its intended application.

Oven Cure: 149 °C for 2.0 hrs.

30.6 Post-treatment. No post-treatments are recommended unless approved by the procuring activity."

Preparing activity:
Navy – AS

(Project 9150-N001)

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