



TECHNICAL BULLETIN

TAYLUBE 404E

Exhaustible Thread Lubricant Emulsion

Description:

TayLube 404E is a fifty percent (50%) active, exhaustible lubricant emulsion. This milky-white liquid contains polydimethylsiloxane and waxes.

Applications:

TayLube 404E is a fifty percent active, lubricant emulsion designed for the exhaustion process on textured or spun polyester thread. The design of the emulsion guarantees an even distribution, especially on spun polyester thread. This product is an excellent lubricant for medium- and heavy- duty sewing thread applications.

TayLube 404E improves the overall performance of sewing threads significantly. Major features are:

*	Excellent abrasion resistance.
*	Very low coefficient of friction.
*	Excellent slip stick properties.
*	Increased heat resistance.

Processing:

TayLube 404E is an exhaustible thread lubricant. The emulsion is added to the dye bath. By circulating the finishing liquor through the bobbins, the lubricant will exhaust onto the thread. This technique allows dyeing and lubrication of the thread in the same equipment.

To achieve maximum exhaustion, it is recommended to buffer the dye bath with about 1% to 2% of ammonium acetate to a pH of 6.5. After circulating the bath at ambient temperature for ten minutes, the temperature is raised at a rate of 3°C to 5°C per minute until the bath reaches a maximum temperature of 72°C (160°F).

For an even distribution of the lubricant throughout the bobbin, it is best to alternate flow direction. Three minutes from outside to inside, alternating with two minutes from inside to outside, are recommended. The normal application levels are from 4% to 12% on-weight-of-goods based on the emulsion as received.

Typical Properties:

Appearance	Milky White Liquid
Active Ingredients	Highly-Refined Silicone/Wax Combination
Active Ingredient Content (%)	50
Note: These figures are intended as a guide and should not be used in preparing specifications.	

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Storage Stability:

TayLube 404E has a shelf life of at least six {6} months if stored in its original, sealed container at 25°C or 70° F. If the material is kept beyond the recommended shelf life, it is not necessarily unusable, but quality control should be performed on the properties relevant to the application.

Safety Instructions:

Comprehensive instructions are given in the corresponding Material Safety Data Sheet. This information is available upon request from TayChem Industries, Ltd.

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