

TECHNICAL DATA SHEET

RESIN COAT 601

RESIN COAT 601 is an economical Cathodic Electro-deposition process for depositing clear coatings on Gold, Brass, Chromium, Silver, Nickel, Aluminium, Stainless Steel etc.

RESIN COAT 601 provides excellent gloss and high throwing power into recesses.

BATH PREPARATION :

- Rinse tank and ultra filtration unit with deionised water containing 1 % by volume solvent and 1 ml/l rinse aid.
- Drain tank and wash with DM water.
- Now add :

RESIN COAT 601 concentrate	1 part
Dye (mix)	10 – 15 ml in resin thoroughly and dilute
DM water	2 part
- Maintain circulation through cartridge filter for 12 – 24 hours.
- Filter the solution by 0.5 micron glass fiber absolute cartridge.
- Adjust the pH(4.5 – 5.5) with stabilizer before commencing.

PROPERTIES:

BATH PARAMETERS :	
pH @ 28°C	4.5 – 5.5
Conductivity @ 28°C	850 – 1200 µS/cm
MEQ	40 – 50
Characteristics:	
Coating Thickness	5 – 10 microns
Coating Voltage	30 – 50 Volts
Bath Temperature	26 – 32°C
Coating Time	10 - 80 Seconds
Anode to Cathode Ratio	1 : 6 – 1 : 4
Backing Condition	150 – 180°C / 20' EMT
Backing Time	20 – 22 minutes
Flash Off	Hot Air Blow / 5 – 10 min

BACKED FILM PROPERTIES:

BATH PARAMETERS	
Appearance	Normal
Gloss	High Glossy
Pencil Harness	3 - 4H
Adhesion	0 / 100
Resistance to sweat test cycle (one cycle of 15')	Passes 4 cycles
Acetone Rub Resistance(No. of Double Rubs)	Min. 8000@ 15 u DFT
Salt Spray Resistance ASTM B -117	Min 100 hours creep width Max 2mm on either side of scribe line and Blister size max 8F

DISCLAIMER :

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