

TECHNICAL DATA SHEET

RESIN COAT - 9000

CLEAR CATHODIC ELECTROCOAT

RESIN COAT 9000 is an economical Cathodic Electro-deposition process for depositing clear coatings on Gold, Brass, Chromium, Silver, Nickel, Aluminium, Stainless Steel etc.

RESIN COAT 9000 provides excellent gloss with high wear resistance on metal plated surfaces.

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 (for 100 Lts. tank) :

RESIN COAT 9000 concentrate	20 Kg
DM water	80 Lts
- Maintain circulation through cartridge filter for 12 – 16 hours.
- Permeate approximately 10% of tank volume to waste by adding DM water.
- Filter the solution by 0.5 micron glass fiber absolute cartridge.
- Adjust the pH(4.5 – 5.0) with stabilizer before commencing.

PROPERTIES:

BATH PARAMETERS :	
pH @ 28°C	4.5 – 5.0
Conductivity @ 28°C	Max 1200 µS/cm
MEQ	40 – 60
Characteristics:	
Coating Thickness	5 - 30µ
Coating Voltage	20 – 120 Volts
Bath Temperature	26 – 32°C
Coating Time	30 - 60 Seconds
Anode to Cathode Ratio	1 : 6 – 1 : 4
Backing Condition	160°C / 20' EMT
Flash Off	Hot Air Blow / 5 – 10 min

BACKED FILM PROPERTIES:

BATH PARAMETERS	
Appearance	Normal
Gloss	High Glossy
Pencil Harness	Min. 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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