

PRODUCT DATA SHEET

ECOMET TOP BLACK

These water-based sealer topcoat products can be applied with Non Electrolytically applied Dip Spin or Spray coating techniques for mass produced hardware parts. Other Application techniques can be used such as Dip Drain, Dip centrifuge or spray etc.

PHYSICAL PROPERTIES	Units	
Colour		Black -Semi Glossy
Theoretical coverage	m ² /kg/10 μ	20-25
Viscosity (Zhan Cup 2)	Seconds	35-45
Solids (By Weight)	%	42 ± 2
Density	Gms/cc	1.10 +/- 0.1
Flash point	°C	100
COF Values ISO 16047	μtot	0.12 -0.18

APPLICATION

Substrate	Alloy and unalloyed steel, other on request
Surface preparation	The substrate must be dry and free from dust and grease. Acidic/ basic impurities and particularly salts must be avoided.
Possible Pre-treatment	<u>Zinc/Al flake-based Basecoats, Electroplating etc.</u>
Application Method	Dip-Spin, Dip, Spray etc.
Filtration	150 mesh stainless steel Sieve
Application viscosity	20 – 30 sec. on Zhan cup 2 for Dip-spin & 20 – 25 for Spray application.
Recommended DFT	8-12 μ
Addition	DM Water
Addition of DM Water	4 - 5 % by weight
Flash Off	5 -10 min.at 100 – 120 °C.
Curing (metal temp.)	15 – 30 min. at 190 - 200 °C.

- Physical constants are averages and are not to be used as product specifications. They may vary up to 5 % of the values shown are specifications representative for the process capability.

- Storage life is 12 months at 20-25°C

- For more information on health & safety refer Material safety data sheet for handling and applying.

SUMMMARY

ECOMET Top Black

Coating Test

Recommended Base Coat:

- Acid Zinc Plating
- Alkaline Zinc Plating
- ECOMET Corundum
- ECOMET 500

PHYSICAL TESTS OF LIQUID PAINT

#	Name of Test	Procedure	Results	Comment
1.	Viscosity	By Zhan Cup no 2	35-45 seconds	
2.	Solid Content	By weight	42 % +-2	
3.	pH	pH meter	8-9	

AFTER APPLICATION ON SUBSTRATE: PHYSICAL TESTS

#	Name of Test	Procedure	Results	Comment
1.	Coating Layer Thickness		4 - 6 Micron	By Thickness gauge
2.	Adhesion	ISO-10683	Pass	7Nm/12mm2
3.	Hardness of Film	Pencil Test	>4 H	

AFTER APPLICATION ON SUBSTRATE: CHEMICAL TESTS

#	Name of Test	Procedure	Results	Comment
1.	Automotive Oil and Fuel Tests	Dip	Pass	
2.	Acid Test – 2 PH	Dip	Passes (30 Seconds)	

AFTER APPLICATION ON SUBSTRATE: PERFORMANCE TESTS

#	Name of Test	Procedure	Results	Comment
1.	SST	ASTM B117	500 Hours	Additional to base coat
2.	COF Test	ISO16047	0.15 +/- 0.03 tot	Others on request

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