

UVICLAD 601

Product Code 252B362

Product Description

UVICLAD 601 is a cathodically deposited electropaint system that provides a clear or colored finish for temperature sensitive electrically conductive substrates, for example metallized or plated plastic.

Delivery Form

UVICLAD 601 in base (transparent) form is a medium viscosity liquid. The solids content is nominally 50% w/w (determined gravimetrically at 120C for 1 hour). Packaging is in 5 or 25 liter plastic containers or 20 liter steel pails. Other packaging types may be available on request.

Equipment and Handling

See Clearclad process *Installation and Operation Manual* and *UVICLAD - General Information* for relevant details.

Bath Operating Parameters

User Determined Parameters

	<u>Low</u>	<u>High</u>	<u>Optimum</u>
Solids %w/w:	8.0	10.0	9.0
MEQ corrected:	35	40	37
Solvent A264 %w/w:	2.0	6.0	3.0 - 4.0
Temperature °C (°F):	23 (73)	29 (84)	26 (79)

Derivative Parameters

Conductivity $\mu\text{S/cm}$: recommended range 400 - 600
 pH (instrumental): normal range 3.6 - 4.4

Note: New baths should be conditioned for 24 – 48 hours before use. At least one bath volume of UF permeate should be eliminated during this conditioning period. The MEQ and solvent content should be adjusted as necessary before commencing production.

Curing Conditions**Pre-Cure Drying and Flow Out:**

Under safelight conditions, 10 - 30 minutes in an air circulated oven at 75°C (167°F) for ABS plastics or at 5°C below the Tg of the base plastic.

UV curing:

Depending on work piece geometry and sharpness of focus from the UV sources, five (5) seconds or more exposure time using lamps with 260nm wavelength output at between 40 - 120 watts/cm.

Cured Coating Properties

- Pencil hardness: 5 – 6H (ASTM D3363 gouge method 3N force)
- Cure response: up to 150 double rubs acetone resistance
- Clarity and flow: excellent
- Mar resistance: excellent

Covering Power and Cost per unit area:

UVICLAD 601 is a very high transfer efficiency process using the LVH TRAP system (98%+ utilization of supply solids). For example, at 10 microns coating thickness one (1) liter of UVICLAD 601 resin concentrate will cover 489 square feet. Accordingly, the UVICLAD 601 cost per square foot can be calculated by dividing the purchase price of the resin concentrate by 489.

For Health & Safety and environmental information - see separate MSDS.

The information given in this data sheet is provisional and may be subject to change without notice. Users should satisfy themselves that this product is suitable for their application.