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GENERAL INSTRUCTIONS FOR USE OF VP446 PLATING RACK COATING PLASTISOL

VINACRON VP446 IS 100% PLASTICIZED POLYVINYL CHLORIDE AND CONTAINS NO FILLERS. WE RECOMMEND THE USE OF PA3011A / DHL19-7 PLASTISOL PRIMER ADHESIVES FOR A PERMANENT BOND THAT PREVENTS THE CREEP OF PLATING BATHS UNDER THE PLASTISOL SHOULD THE COATING BE CUT OR ABRADED.

METAL PREPARATION:

ALL RACKS SHOULD BE THOROUGHLY DEGREASED WITH SOLVENTS SUCH AS 111 TRICHLOROETHYLENE, METHYL ETHYL KETONE, TOLUENE, ETC. TO REMOVE ANY SUBSTANCE WHICH MAY AFFECT THE ADHESION BETWEEN THE PRIMER AND THE METAL SURFACE. WITH PREVIOUSLY COATED RACKS, IT IS ESSENTIAL THAT THE OLD RACK COATING AND PRIMER BE COMPLETELY REMOVED. THE OLD COATING MAY BE BURNED OFF AND THE SURFACE SAND BLASTED. FRESH METAL, CLEAN AND UNOXIDIZED, IS THE IDEAL FOR ANY ADHESIVE.

PRIMING:

1. PRIME THE CLEANED METAL SURFACE WITH ONE COAT OF PLASTISOL PRIMER PER MANUFACTURER'S RECOMMENDATION. THE PRIMER MAY BE APPLIED BY DIPPING, BRUSHING OR SPRAYING. PRIMERS MAY BE THINNED WITH METHYL ETHYL KETONE IF A THINNER CONSISTENCY PRIMER IS DESIRED. CHECK OUT THE ADHESION ON A TEST PIECE USING THE THINNED DOWN PRIMER BEFORE BEGINNING PRODUCTION.
2. AIR DRY THE PRIMER. RACKS COATED WITH PRIMER MAY BE SET ASIDE FOR DIPPING AT A LATER TIME IF THE RACKS ARE PROTECTED FROM CONTAMINATION DURING STORAGE.

NOTE: IF THE RACK CONTACTS ARE TO BE STRIPPED OF PLASTISOL, THE PRIMER CAN BE BLOCKED AT THESE CONTACT POINTS. MRV-1000 IPA PRIMER BLOCKER WILL AIR DRY IN MINUTES AND BLOCK ALL PRIMER

ADHESION. APPLY IT TO THE RACK AFTER THE PRIMER IS DRY BY DIPPING OR BRUSHING. READ ALL MRV-1000 IPA INSTRUCTIONS AND MSDS CAREFULLY. AFTER CURING, THE PLASTISOL COATING IS EASILY REMOVED BY CUTTING AND PEELING. CHECK ALL AREAS ADJACENT TO THE STRIPPED CONTACTS TO MAKE SURE THE PLASTISOL IS BONDING PROPERLY. UNBONDED SURFACES WILL ALLOW THE PLATING BATH ACIDS TO PENETRATE UNDER THE COATING.

DIPPING:

1. HEAT THE UNCOATED PRIMED RACK FOR 15-30 MINUTES AT A TEMPERATURE OF 370° - 425^a F, THE TIME AND TEMPERATURE WILL DEPEND ON THE MASS OF THE PART, OVEN EFFICIENCY, COATING THICKNESS DESIRED, ETC.
2. DIP THE HEATED PART INTO THE PLASTISOL. AFTER IMMERSION THE DIP TIME WILL BE 20-50 SECONDS, DEPENDING ON THE COATING THICKNESS DESIRED. WITHDRAW AT A RATE OF APPROXIMATELY 1 INCH EACH 5 SECONDS. WITHDRAWING TOO FAST WILL CAUSE THE PLASTISOL TO DRIP EXCESSIVELY.

CURE:

THE CURE CYCLE OF VP446 WILL DEPEND UPON THE RACK COMPONENT SIZE AND SUBSEQUENT BUILD OF THE COATING. MOST RACKS USE A WIDE RANGE OF METAL COMPONENTS; 13-16 GAUGE (B&S) WIRE TIPS AND CLIPS AND 1/4" - 1/2" COPPER BAR STOCK ARE COMMONLY UTILIZED. THESE RACKS WILL BE PROPERLY CURED IN 20 MINUTES IN A 380°- 400° F OVEN.

OTHER PLATING PARTS SUCH AS BASKETS, BASKET CARRIERS AND ELECTRODES, WHICH USE ONE COMMON METAL COMPONENT, DEVELOP A UNIFORM COATING BUILD BECAUSE OF EVEN METAL THICKNESS AND MASS OVER THE ENTIRE PART. WITH SUCH A BUILD THESE PARTS CAN BE PROPERLY CURED AT HIGHER TEMPERATURES AND SHORTER TIMES, SUCH AS 10 MINUTES AT 425^a F.

WE DO NOT RECOMMEND TEMPERATURES GREATER THAN 400° F FOR RACKS THAT USE THIN GAUGE CLIPS AND WIRE. HIGHER TEMPERATURES RESULT IN OVERCURED THIN AREAS BY THE TIME THICK AREAS ARE PROPERLY CURED. SHORTER TIMES AT 425° F THAT WOULD RESULT IN PROPERLY CURED THIN AREAS WOULD PRODUCE UNDERCURED THICK AREAS. IN EITHER CASE, THE SLIGHTLY UNDERCURED OR OVER CURED COATINGS MAY BE GLOSSY BUT WILL ACID ETCH MORE RAPIDLY OR SEVERELY THAN THEY SHOULD ONCE IN USE.

THE 400^a F TEMPERATURE FOR 20 MINUTES USES A SLOWER, MORE GENTLE

HEAT TRANSFER THAT EFFECTIVELY CURES THICK AREAS WITH MINIMUM DEGRADATION OF THIN AREAS.

PATCHING

FOR REPAIRING DEFECTS, USE VINYL PATCHING COMPOUND AD 510-BL. AD 510-BL IS AN AIR DRY COATING SYSTEM WHICH DOES NOT REQUIRE FURTHER BAKING ONCE APPLIED TO THE DEFECT. FOLLOW INSTRUCTIONS FOR AD 510, "USE AS A PATCHING COMPOUND."

LARGE COATING RACKS WHICH BOLT TOGETHER MAY BE DIPPED IN SECTIONS AND BOLTED TOGETHER LATER WITH THE BOLTS PROTECTED BY COATING WITH THE AD 510-BL SYSTEM.

PHYSICAL PROPERTIES:

SHORE A HARDNESS	85/80
SURFACE	GLOSSY
BROOKFIELD VISC MODEL RVT	2.5 RPM 6-8000 CPS
INITIAL 75° F SPINDLE #6	20 RPM 4-6000 CPS
AGED 1 MONTH (77° F)	2.5 RPM 8-14,000 CPS
	20 RPM 6-13,000 CPS
SHELF LIFE	1 YEAR OR MORE AT
	TEMPERATURES BELOW 90° F
DENSITY (WT/GALLON)	10 LBS
TENSILE STRENGTH	2300-2800 PSI
ULTIMATE ELONGATION	300%