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Phirol®

(Technical Data Sheet)

Phirol® Dip Coating Plastisol

Grades : DCB / DCR / SPR2

Number : 310 Rev.: 03

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Description :

Phirol DC is a dip coating grade PVC plastisol , specially formulated for coating electroplating jigs and other metal coating applications.

Typical properties:

(Should not be considered as specifications)

Colour	: Black / Red / Natural
Appearance	: Viscous Liquid
Viscosity	: As per agreement with customers
Curing Schedule	: 180 - 200°C for 10 to 20 Minutes
Hardness	: 60 - 80 shore A

Application :

- 1) Clean and degrease the metallic article to be coated
- 2) Apply the thin coating of Phirol Primer for DC with a brush and air dry for 20 to 30 minutes
- 3) Preheat the article in an oven at 180°C X 15 minutes.
- 4) Dip the hot article in Phirol DC at the rate of approx. 100 cm/minute
- 5) After a dwell time of 30 seconds, slowly withdrew the article from the plastisol bath at the rate of approx. 100 cm/min.
- 6) Allow excess plastisol to drain off.
- 7) Suspend the article in the oven and cure at 180 - 200°C till curing is completed.

To obtain a thicker coating, semigel the first coat (step 7) at a lower temperature at 140 - 150°C for 5 to 10 mins and repeat cycles (step4 to 7). It should be noted that thickness of coating is controlled by degree of preheating and the duration of the article remaining in plastisol tank.

Storage :

To be stored indoors, away from direct sunlight , heat source and moisture.

Shelf Life:

Six Months under above conditions

Packing:

50 kg in HDPE carboy.

Note :

It should be appreciated that the above information given here is to the best of our knowledge, true and accurate. However, since conditions under which our products are used are beyond our control, recommendations are made without warranty or guarantee.

(An ISO 9001:2008 certified Company)