



# **Product Data Sheet**

## **CLEARCLAD LCX GLOSS BLACK**

Product code: 252B026

### **Product description:**

General purpose cathodic gloss black with low temperature cure capability. It possesses good resistance to UV light and when combined with appropriately prepared metals it delivers high levels of corrosion protection.

### **Delivery form:**

Black coloured liquid of moderate viscosity. Solids content 48 – 52% w/w (determined gravimetrically at 120C for one hour). For theoretical covering power using the TRAP reclaim system at maximum efficiency, divide the factor 474 by the thickness required to obtain the number of square metres that can be coated per 1kg of delivered product. The recommended minimum thickness for corrosion protection is 15 microns.

### **Application equipment:**

#### 1. Rack coating (manual or transporter):

For general information on equipment design for rack coating, refer to the *CLEARCLAD Process and Installation Manual*. For further details refer to the LVH technical department or the local LVH distributor as appropriate. For specific advice about particle filtration refer to the bulletin: *Maximising quality from electrocoat systems: - the role of filtration*.

#### 2. Other techniques – e.g. continuous conveyor, basket coating etc.

Refer to the LVH technical department or the local LVH distributor for information and recommendations.

### **New bath make-up and replenishment procedures:**

To obtain 10% coating solids, for every 100 litres of bath, dilute 20kg of concentrate with 80 litres D.I.water (conductivity less than 5  $\mu$ S/cm). For solids replenishment, 1% increase in solids is obtained by adding 2kg concentrate per 100 litres bath. If additions of Solvent HC are necessary, refer to the Solvent HC Product Data Sheet for the procedure.





# Product Data Sheet

*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.*

## Bath operation conditions:

### 1. User determined parameters:

	<u>Low</u>	<u>High</u>	<u>Optimum</u>
Solids w/w:	8.0	12.0	10.0
MEQ corrected:	30	40	35
Solvent PM/A264 w/w:	2.0	4.0	2.5 – 3.5
Solvent HC/A250 w/w:	2.5	3.5	3.0
Temperature °C:	23	29	26

### 2. Derivative parameters:

Conductivity $\mu\text{S}/\text{cm}$ :	Recommended range 600 - 800
pH (instrumental):	Normal range 3.6 – 4.4

## Coating conditions:

Applied voltage and coating time will vary according to the thickness required, the surface area being coated and geometry of the workpieces. Typical voltages are 30 – 120 at an average current density of 0.15 amps per  $\text{dm}^2$ . Typical coating time can be from 60 – 120 seconds. Longer times may be necessary to obtain adequate throwing power into more complex shaped workpieces.

## Curing conditions:

Normal curing requires 160C metal temperature for minimum 15 minutes. The LCX resin system also has low temperature cure capability. The minimum practical metal temperature is 130C for minimum 60 minutes.

## Performance characteristics:

LCX Black is a versatile coating process that can be applied over a large variety of substrates and pre-treatments to comply with various performance requirements.





# **Product Data Sheet**

To establish compliance with any performance specification, the user should perform the appropriate tests on the correctly applied LCX Black coating on the relevant and representative pre-treated substrate.

Technical advice on complying with performance specifications is available from LVH directly or through its local distributors as appropriate.

## **Health & Safety:**

Refer to separate MSDS for Health & Safety and environmental issues.

b026a.doc/1

