

# **MICCRO<sup>®</sup> PRODUCTS**

## **PLASTISOL HOT DIP COATING**

Hot Dip Plastisols are highly stable vinyl dispersion coatings with a wide range of industrial uses which include:

- Coating racks, baskets, hooks and other materials.
- Handling equipment when resilience is required to protect finished parts.
- Providing a corrosion-resistant coating for duct work, tanks, pipes and other surfaces.
- Giving plating racks highly efficient electrical insulation properties.

Hot Dip Plastisols have the following properties:

- High chemical resistance permits use in all proprietary plating cycles without deterioration or contamination.
- High dielectric strength.
- Maximum toughness and abrasion resistance.
- High material stability and adhesion for ease of application.
- Maximum resilience and flexibility.
- High gloss provides optimum drainage.

Clean metal physically and chemically. Sandblasting with clean sand or pickling and degreasing are usually satisfactory. Metal must be free of any greases, oil, old coating or other foreign objects.

Apply TOLBER<sup>®</sup> T-100 Primer to metal part by dipping, brushing, or spraying. Air dry metal part for 15 minutes then bake in 350°F to 400°F for 15 to 45 minutes depending on the mass of the metal part. The primer cures when the metal part reaches 350°F. Make certain primer totally covers area that will receive the plastisol coating.

Remove metal part from oven and dip hot part into plastisol. Leave part in plastisol until desired coating thickness is formed. Thickness will be determined by the temperature of the part and the length of time part is in the plastisol.

Withdraw part slowly from plastisol and allow to drain until dripping stops. Bake coated part in 360°F to 400°F oven for 30 minutes to two hours. Required baking time depends on oven efficiency, mass of the part and thickness of the coating. The coating will become shiny when fully cured. If excessive smoke is noticed during the curing process, check oven temperature for compliance. As a general rule, the plastisol will be 30-60 mils thick when cured.

### **SPECIFICATIONS**

Color.....	Various
Viscosity as Mfg.....	4000-6000 cps
Wt./Gal.....	10 lbs.
Spec. Gravity.....	1.24
Flash Point.....	Cures
Solids.....	100%
Recommended Primer.....	T-100

Available in 1 gallon, 5 gallon, and 55 gallon containers. Totes available upon request.  
Meets Mil-P-20689, Type I, Class II

### **PROPERTIES**

Tensile Strength.....	2000 psi
Elongation.....	310%
Durometer (Shore A).....	70±5
Tear Strength.....	400 lbs/in.
Abrasion Resistance.....	Excellent Normal Temp.
Low Temperature Flex.....	-40°F 1" Mandril
Softening Point.....	225°F
Weathering.....	Excellent
Dielectric Properties.....	500-600 V/Mill
Aging Properties.....	Unlimited
Water Absorption.....	96%
Chemical Resistance.....	(See back cover)
Acids.....	Excellent
Alkalis.....	Excellent



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