



non-stick coatings

PRODUCT DATA SHEET

DURACERAM®

Basecoat

Product	Basecoat Component A	Basecoat Component B	Catalyst C
Code	CB100528-1(A)	CB100528-1(B)	CB100528-1(C)
Viscosity	9±1 second Iwata#2 @ 25°C	8±1 second Iwata#2 @ 25°C	
Wt. Solids	52±2%	N/A	N/A
Mixing Ratio	A:B:C = 68.47 : 27.68: 4.45		
Mixing Speed/Time	Add Component C into Component A. Mix 15-30 min then Add Component B into A+C. Mix @ 160-180 rpm for 24 hours. After mixing, initial 3 hours, maintain the material temperature between 30~35°C.		
Density	1.34±0.04 kg/L		
Total Wt. Solids(A+B+C)	40±2 %		
Total Vol. Solids(A+B+C)	30±2%		
Theoretical Coverage	11.47m ² /kg at 12 micron		
Application Parameter	To ensure superior finished quality, it is of crucial importance that the surface be thoroughly cleaned, removing all surface particles including sand, grease and cleaning solutions.		
Substrate	Aluminum or Stainless steel		
Substrate Preparation	Grit blast with 60-80 mesh Ra=2.5-4.0 microns. (Pre-heat the substrate 50-60°C while spraying the coating.)		

HEALTH AND SAFETY PRECAUTIONS: As with any coatings material care should be exercised when using this product. The vapor may be harmful and may cause irritations. Adequate ventilation should be provided and breathing of the vapor or mist should be avoided. The use of an appropriate respirator is recommended. Avoid contact with eyes or skin, and never take internally. Keep away from heat, sparks or flames. Keep container tightly closed. Comply with all local safety disposal and transportation regulations. Refer to the Material Safety Data Sheet (MSDS) for additional Health, Safety and Environmental Information.

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Preparation of Coating It is very important that the product is well mixed and homogeneous. It must be adequately dispersed at room temperature prior to use.
First mix the component C into Component A. Then Add Component B into (A+C) in recommended ratio in clean container. Put the container on roller for 24 hours for mixing. After mixing for 24 hours adjust the viscosity by recommended thinners. All the product are filtered before shipping however further filtration through an appropriate mesh may be required to reduce the contamination.

Filter mesh	100 mesh
Application	Conventional spray
Dry Film Thickness	12-14 per coat recommended.
Applied Viscosity	8±1 second Iwata#2 @ 25°C
Reducer	Direct spray, if needed use IPA (Iso Propyl Alcohol)
Curing of coating	To ensure the proper curing of coating, the temperature of substrate must be kept at specified temperature for entire cure process.
Flash Dry	5 min @60-80°C
Final Curing	Refer to the topcoat curing specification
Product Specification	
Pencil hardness	6H
Gloss	Medium
Cross Hatch Adhesion	Boiling water 20 min, then cross hatch adhesion- Pass 100%
MEK rub	50 double rub
Storage	3 months, Store at 5-30°C in dry atmosphere
Others	<ol style="list-style-type: none"> 1. After A/B/C gets matured, coating must be used up within 24 hours 2. Final curing temperature should be increased gradually, too fast temperature increase will cause blister on final film. 3. IPA can be used to clean spraying gun and other equipments. 4. Mix the A+B+C= 61.92+31.90+5.31 in proper recommended ratio and recommended order. 5. After component A/B/C blend together, there will be a exothermic reaction, within 20-30 min, system temperature will reach to 50°C and then drop down gradually. This is normal. 6. As gas will be liberated during the reaction, we suggest depressurized the container after roll 20-30 min, also be care of causticity of the gas liberated. 7. Component A pH=3.5-5.0 and after mature of A/B/C system pH= 3.5-5.0 avoid contact skin, Component B is neutral. 8. Please refer to MSDS of this product before use.

Date 28th May, 2010

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