

ZINCOLLUM D60 SILVER GREY

FLAKE COATING SYSTEM

INTRODUCTION

Zincollum D60 is a single component coating system which gives a corrosion resistant zinc rich aluminium flake base coat. It has a wide range of applications for fasteners, electric parts, stamping parts.

BENEFITS

- Low temperature operation.
- Does not give hydrogen embrittlement.
- Corrosion resistance of 1000 hours salt spray with 2 coats giving 8µm thickness.
- Low viscosity allows coating of blind holes without blocking

SOLUTION MAKE-UP

Zincollum D60 Ready to use

It is essential that the tanks to be used for Zincollum D60 are thoroughly cleaned and leached before any chemistry is introduced. If in any doubt as to the cleaning procedure please contact PMD Chemicals Technical Department.

OPERATING DATA

	Soak – Centrifugal	Spray
Viscosity	25 – 30 sec cup #2	25 – 30 sec cup #2
Solids content	45 – 50%	➤ 35%
Time	250 – 350 rpm forward and reverse 20 secs. Repeat	
Pre-heat	90 – 110 °C 10 mins	
Curing	240 – 260°C 30 mins	

PROCESS SEQUENCE

1. Degrease – Ultrasonic preferred
2. Shot blast – To remove rust 0.2-0.3mm stainless steel shot.
3. Zincollum D60 Coating (mix thoroughly before use).
4. Pre-heat 90 – 110°C 10 – 15 mins
5. Cure 240 – 260°C 30 mins
6. Apply topcoat if required for friction control.

MAINTENANCE AND CONTROL

For a coating of 10µm 1kg of Zincolium D60 will cover 20-21m²

Solids content and viscosity should be checked on a regular basis.

ANALYSIS METHOD

1. Solids content

Method

1. Weigh an aluminium dish and record weight as A g
2. Add ~1 g of Zincolium D60 bath. Record weight as B g
3. Place in oven at 250°C for 30 mins
4. Allow to cool and record weight as C g

Calculation

$$\frac{(C - A)}{(B - A)} \times 100 = \% \text{ solids}$$

2. Viscosity

1. Immerse viscosity cup #2 in to the Zincolium D60
2. Record the time taken to drain.

NOTES

1. Storage. Zincolium D60 should be stored in tightly sealed containers in cool dry conditions.
2. Ensure bath is mixed well prior to use to ensure an even coating.
3. Do not allow water/moisture to enter the bath as this will degrade the bath.
4. Pre-heat. Raise temperature gradually to prevent rough coatings.

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
Zincolium D60	581040

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