



TIBCHEMICALS

PROTEFAN® Dip Coating 4110 / 4110 B / 4110 BT

PVC-based Plastisole for coating Metals
in hot dipping Process

Description

PROTEFAN® Dip Coating 4110 is a plastisol based on PVC for coating metals using a hot-dip process.

Uses

Coating of

- galvanizing racks
- grids
- pipe clamps
- rollers
- metals

Benefits

Resistant to

- acids
- alkalis
- salt solutions
- degreasing agents and detergents

Product Data

Type	hot-dip paste
Base	PVC
Consistency	Viscous
Density	1.2 g/cm ³
Temperature resistance (permanent stress)	-20°C - +70°C
Hardness	Shore A approx. 75
Max. coating thickness	several millimetres per dipping operation. The process can be repeated as necessary.
Flash point	approx. 200°C

Colours

Green (further colours are available on request subject to a minimum order quantity).

Coverage

Approx. 600 g / m² at 500 µm dry film thickness

Packaging

30 kg drum
200 kg drum
1000 kg container

Storage

In a dry place at room temperature, do not store above 35°C. The shelf life is 12 months.

Application

Substrate

Substrates to be coated must be dry, clean, bare down to the metal, free from oil and grease, eventually blasted. To obtain a reliable bond between metal and coating and to avoid infiltration or disbonding, pretreatment of the substrate with PROTEFAN® Primer 200 is necessary.

For details of application see separate data sheet PROTEFAN® Primer 200.

PROTEFAN® Dip Coating 4110 is formulated ready for use and may not be thinned. Material temperature during application shall be +10°C - +30°C. Stir gently after prolonged storage.

Take care not to entrap air!

Immediately after stoving of the primer (approx. 20 min. between 180°C and 190°C) frames to be coated shall be dipped in still hot condition into PROTEFAN® Dip Coating 4110, allowed to fuse slightly and stoved after drawing and draining. Dipping should be done quickly, drawing should be done slowly and steadily (approx. 30 cm/min.).

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Stoving Conditions

20 - 30 minutes at 180°C.

The stoving time is reckoned from the moment the metal has obtained the specified temperature and depends on the kind of metal and its thickness. In case several coats are required, then allow each coat to fuse slightly for not more than 5 to 10 minutes at 180°C and have only the last coat completely cured. When applying several coats, the parts should be redipped while hot, immediately after removal from the stove. Insufficiently fused coatings are matt and brittle. Restoving is possible. With complete fusion the coating has a glossy finish.

Repairs

Large damaged areas should first be cleaned, dried and primed with PROTEFAN® Primer 200 and stoved for 10 minutes at 180°C. Fill in damaged area with PROTEFAN® Protective Filler 5000 and stove until the object to be coated has obtained a temperature of 180°C - 195°C.

Damaged areas may also be repaired by applying PROTEFAN® Repair Lacquer 50 several times, allow to air-dry. Waiting periods between coating operations: 1 hour, prior to stressing 24 hours.

Removal of existing coatings

Old and useless coats may be removed by burning them off and subsequent blasting of the objects. Please observe safety instructions and conditions for environmental protection.

Health and Safety

Detailed health and safety advice can be found in the Material Safety Data Sheets.

Vapours generated during stoving should be extracted. Do not inhale for prolonged periods.

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