

PLASTISOL COATINGS

GENERAL CHARACTERISTICS

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

Hit Dip Plastisols have the following properties:

- High chemical resistance permits use in all
- Proprietary plating cycles without deterioration or contamination. (see back cover)
- 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.

APPLICATION PROCEDURES

1. 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.
2. Apply Tolber T-100 Primer to metal part by dipping, brushing, or spraying. Air dry metal part for fifteen (15) minutes then bake in 350°F to 400°F for fifteen to forty-five 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.
3. 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.
4. Withdraw part slowly from plastisol and allow to drain until dripping stops. Bake coated part in 360°F to 400°F oven for thirty (30) minutes to two (2) 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 FOR HOT DIP PLASTISOL

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 gal, 5 gal, and 55 gallon containers.

Totes available upon request.

Meets Mil-P-20689B, Type I, Class I

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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CHEMICAL RESISTANCE OF TOLBER PLASTISOL PROTECTIVE COATINGS

REAGENT	CONCENTRATION BY WEIGHT	OPERATING TEMP. °F	IMMERSION		REAGENT	CONCENTRATION BY WEIGHT	OPERATING TEMP. °F	IMMERSION	
			Constant (as rack coating)	Intermittent (or exposure to fumes)				Constant (as rack coating)	Intermittent (or exposure to fumes)
ACIDS					NEUTRAL SALTS				
Acetic	10%	120°F	OK	OK	Calcium Chloride/ Sulfate	Saturated	150°F	OK	OK
	Glacial	—	not recommended	OK	Magnesium Chloride/ Sulfate	Saturated	150°F	OK	OK
Benzoic	Saturated	160°F	OK	OK	Potassium Chloride/ Sulfate	Saturated	150°F	OK	OK
Boric	Saturated	160°F	OK	OK	Sodium Chloride/ Sulfate	Saturated	150°F	OK	OK
Carbonic	Saturated	160°F	OK	OK	PLATING SOLUTIONS				
*Chromic	10%	150°F	OK	OK	Brass	—	150-160°F	OK	OK
	25%	130°F	OK	OK	Cadmium				
	50%	130°F	OK	OK	Copper				
Citric	Saturated	150°F	OK	OK	Gold				
Fluoboric	Any	150°F	OK	OK	Lead				
Formic	85%	—	not recommended	OK	Nickel	—	150-160°F	OK	OK
Hydrobromic	48%	120°F	OK	OK	Silver				
Hydrochloric	20%	150°F	OK	OK	Tin				
	37%	—	not recommended	OK	Zinc				
Hydrofluoric	5%	150°F	OK	OK	Chromium				
	50%	100°F	OK	OK	Manson-Van Winkle- Munning	—	All Approvals	OK	OK
	60%	—	not recommended	OK	McGean	—	All Approvals	OK	OK
Lactic	Any	150°F	OK	OK	Ucylite	—	All Approvals	OK	OK
Nitric	5%	150°F	OK	OK	Harshaw	—	All Approvals	OK	OK
	20%	120°F	OK	OK	Harshaw	—	All Approvals	OK	OK
	40%	—	not recommended	OK	Seymour	—	All Approvals	OK	OK
Oleic	Any	90-100°F	OK	OK	MacDermid	—	All Approvals	OK	OK
Oxalic	Saturated	150°F	OK	OK	ORGANIC and MISCELLANEOUS REAGENTS				
Perchloric	—	—	not recommended	OK	Chlorine (Wet)	—	—	not recommended	OK
Phosphoric	75%	130°F	OK	OK	Chlorine (Dry)	—	—	not recommended	OK
Sulfuric	50%	130°F	OK	OK	Acetone	—	—	not recommended	OK
	70%	100°F	OK	OK	Alcohol, Ethyl/ Methyl	100%	—	not recommended	OK
	98%	—	not recommended	OK	Aniline	100%	—	not recommended	OK
ALKALIES					Benzene	100%	—	not recommended	OK
Ammonium Hydroxide	10%	150°F	OK	OK	Carbontetrachloride	100%	—	Attacked	OK
	28%	—	not recommended	OK	Ethylene Chloride	100%	—	Mild attack	OK
Calcium Hydroxide	Saturated	90-100°F	OK	OK				Extracts	
Sodium Hydroxide	10%	150°F	OK	OK	Formaldehyde	35%	100°F	OK	Plasticizer
	35%	90-100°F	OK	OK	Gasoline	100%	100°F	not recommended	OK
Potassium Hydroxide	10%	150°F	OK	OK	Glycerine	100%	—	not recommended	OK
	35%	90-100°F	OK	OK				(100°F)	OK
ACID SALTS								Softens Coating	
Aluminum or Aluminum Sulfate	Saturated	150°F	OK	OK	Hydrogen Peroxide	3%	150°F	Bleaches	OK
Ammonium Chloride/ Nitrate Sulfate	Saturated	150°F	OK	OK		30%	100°F	Bleaches	OK
Copper Chloride/ Sulfate	Saturated	150°F	OK	OK	Trichloroethylene	100%	—	Attacked	OK
Ferric Chloride/ Sulfate	Saturated	150°F	OK	OK	Water: Fresh	—	130-150°F	OK	OK
Nickel Chloride/ Sulfate	Saturated	150°F	OK	OK	Sea	—	130°F	OK	OK
Stannic Chloride	Saturated	150°F	OK	OK	ALKALINE SALTS				
Zinc Sulfate	Saturated	150°F	OK	OK	Barium Sulfide	Saturated	150°F	OK	OK
					Sodium Carbonate	Saturated	150°F	OK	OK
					Sodium Bicarbonate	Saturated	150°F	OK	OK
					Sodium Sulfide	Saturated	150°F	OK	OK
					Trisodium Phosphate	Saturated	150°F	OK	OK

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REFER TO MATERIAL SAFETY DATA SHEET FOR
ADDITIONAL WARNINGS AND INFORMATION.

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