



## TECHNICAL BULLETIN

### Highlights

ELECTROCLEAR 2800 represents a cost-effective, environmentally friendly product for use in the general metal finishing market as a high gloss decorative clear coating. Its advantages include:

- High performance – excellent solvent and chemical resistance
- Reduced waste with high transfer efficiency (>95%).
- Easy extension of a metal finishing process.
- Robust tank operation.
- Wide process latitude to adapt to customer operations.
- Delivers a high quality reproducible finish from a low maintenance process.
- Excellent throw power delivers uniform coating on complex parts.
- Provides sharper image and higher DOI than traditional spray or dip lacquer products.
- Waterborne paint, low VOC, with reduced fire hazard and exposure of hazardous materials to workers.
- The future financial and environmental solution for lacquering metal parts.

### Technical Properties

Property	Test Method	Performance
Color	---	Clear
Film Thickness	---	12 - 25 microns
Gloss - 60 Degree	ASTM D523	Full gloss
Pencil Hardness	ASTM D3363	5H - 6H
Crosshatch Adhesion	ASTM D3359	100%
Humidity/Adhesion	ASTM D1735/D3359	500 hrs./100% (no adhesion loss)
Acetone /MEK Rubs	---	3000+ (20+ microns)
Perspiration	ANSI/BHMA 156.18-2000	6 - 9 cycles
Corrosion (Salt Spray)	ASTM B117	500 - 1,000 hrs.
UV Durability	QUV-A	2,000+ hrs. no effect
Taber Abrasion	ASTM D4060	< 25 mg./300 cycles

Film properties vary with substrate and pretreatment

### Commercial Uses

- Optical Frames
- Household Decorations
- Furniture Hardware
- Writing Instruments
- Cigarette Lighters
- Extrusions
- Lighting
- Costume Jewelry
- Door Hardware
- Picture Frames
- Office Hardware
- Hand Tools
- Military Insignia
- Performance After-market

### Application Data

**Bake (nominal):** 20 minutes at 320°F (160°C) metal temperature  
**Bake Range:** 285-375°F (140-190°C) TBD based upon customer requirements  
**VOC:** 1.5 - 2.0 lbs per gallon minus water (as supplied)  
**Heavy Metals:** None



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