

**PRODUCT: ARSONECO 323 NERO IMMERSIONE  
W323N33-**

- : S=can; F=drum; C=tank

**THE PRODUCT IS BLACK AND USED BY DIPPING FOR IRON AND CAST IRON PARTS.  
THE BAKING CONDITION IS FORCED DRYING**

**PRODUCT CHARACTERISTICS IN DELIVERY FORM**

	Units	
- Binder		: epoxy ester
- Delivery viscosity(DIN Cup 4 at 25°C)	sec	: 60 - 90
- Density	(kg/dm <sup>3</sup> at 20°C)	: 1.300 +/- 0.030
- Solid content	(weight on weight)	: 54 +/- 2
- Storage stability (+ 5°+ 30°C)	(months)	: 12
- pH		: 8.7 - 9.2

**METHOD OF APPLICATION**

Dipping		
- Thinner type	(qual)	: water
- % Thinner	(%)	: 10 - 15
- Viscosity (DIN Cup 4 at 20°C)	NC 01 (sec)	: 25 - 30

*The lay on conditions should be defined on the customer plant*

**Units**

- Coverage	(micrometer)	: >15
- Recommended dry film thickness	(micrometer)	: 20-30
- Substrate / iron (it must be absolutely clean, i.e. dirt, rust, grease, moisture are to be removed)	(qual)	: sand blasted cast iron
- Pre- treatment		: iron phosphate

**DRYED FILM CHARACTERISTICS**

<b>- Forced drying</b>			
. Flash off time	min at 20 °C	: 15 - 30	
. Curing condition (effective on substrate)		min at 80 °C	: 30
- Adhesion	%	: 90 – 100	
- Gloss 60°	UG	: semi glossy	

**OTHER CHARACTERISTICS**

- Pigments	qual	: Pb and Cr Free
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**CHEMICAL- PHYSICAL RESISTANCE**

**Test after 10 days from the application**

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|--|--|
| • Alcohol resistance<br>(8 hour dipping at 21 °C Ethanol/Diesel fuel 85/15 )   | qual : good                                    |
| • Mineral alcohol resistance<br>(5 min dipping at Room Temp. 21 °C)  | qual : good                                    |
| • Alkali resistance<br>(2 min dipping at boiling Temp.<br>Water solution of Na(OH) 0,5% + Na <sub>2</sub> CO <sub>3</sub> 0,75% + Na <sub>3</sub> PO <sub>4</sub> 0,75%) | qual : No blistering                           |
| • Alkali resistance<br>(30 min dipping at 80°C.<br>Water solution of Na <sub>2</sub> CO <sub>3</sub> 2% + Na <sub>3</sub> PO <sub>4</sub> 1%)                            | qual : No blistering                           |
| • Diesel fuel resistance<br>(24 hours dipping at Room Temp. 21 °C)   | qual : No damaged                              |
| • Gasoline resistance<br>(20 double rubs using cotton soaked with gasoline)  | qual : Good                                    |
| • Gasoline resistance<br>(24 hours dipping at Room Temp. 21 °C<br>Gasoline/White spirit 2/1)   | qual : Good                                    |
| • Oil resistance API GL5 SAE 90(**)<br>(On panels submitted alkali resistance test<br>96 hours dipping at 125 °C)  | qual : No damaged                              |
| • Oil resistance SAE 30 motor oil/Kerosene 80/20(**)<br>(On panels submitted alkali resistance test<br>100 hours dipping at 135 °C )                                     | qual : No damaged                              |
| • Oil resistance SAE 30 (**)<br>(On panels submitted alkali resistance test<br>100 hours dipping at 107 °C)  | qual : No damaged                              |
| • Oil resistance SAE 30<br>(24 hours dipping at 82°C, Oil type SAE 30)   | qual : No damaged                              |
| • Oil resistance "FIAT AP 51"<br>(24 hours dipping at 120°C)   | qual : No damaged                              |
| • Humidity resistance (200 hours at 40°C )   | qual : Little bleaching, no blistering         |
| • Salt Spray test<br>(96 hours on phosphated steel pieces. Bonder WH W OC )  | qual : Rust 2 mm on the cross<br>good adhesion |

(\*\*) Resistances done on panels exposed to Alkali resistance

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