

**SOCOMASK PRT2130 is a hand-peelable protective coating developed to protect surfaces during chemical milling.**

This product has been especially formulated to provide the following properties and performance:

- High solids content in order to reduce solvents emission and make the application of thick layers easier with conventional spraying systems (airless, pneumatic) or by dipping.
- Exceptional chemical resistance which offers a solution to most of the chemical protection problems : alkaline machining bath from 60 to 110° C (140 to 230° F), chromic-sulphuric mixture bath, hydrofluoric acid bath, detergent solution..., even with only 150 to 200 microns dry thickness
- Resistance to shocks during forming and degreasing processes as well as storage, transport and various handling operations.
- Protection of parts against corrosion and splashes of acid or alkaline chemicals.
- Resistance to temperature and very easy peeling, even after all chemical processes, exposure to bad weather and corrosive atmospheres.
- SOCOMASK PRT2130 when applied in sufficient thickness is easy to peel off, even after machining cycles.

### ***DIRECTIONS FOR USE***

The product can be applied with an airless or pneumatic spray gun, hot or cold, by automation or by hand, under normal industrial climatic conditions (temperature 10 to 30° C / 50 to 86° F, 20 to 90 % relative humidity), or by immersion.

After a long storage, the product must be stirred, it is most important to avoid the incorporation of air. Check the homogeneity before use.

Parts to be covered must be perfectly clean ; if necessary use DIESTONE cleaners.

Spray in conditions without air turbulence or extreme heating.

### **HOT AIRLESS OR PNEUMATIC SPRAYING**

- Equipment: GRACO, KREMLIN or NORDSON
- Temperature: 60 to 80° C (140 to 176° F) in the heater
- Pressure of the pump: 160 to 200 bars
- Application distance: from about 300 to 700 mm
- Number of layers: 2 or 3 according to the required thickness.
- Drying time between 2 coatings: 15 minutes min.

- The first coating must be thin: 100 microns max.

## COLD AIRLESS OR PNEUMATIC SPRAYING

Same general application conditions as for hot spraying, except for temperature and drying time (minimum drying time between layers: 15 minutes).

## IMMERSION

According to the required thickness, increase the number of immersions (100 microns after a 15 seconds dipping). Minimum drying time between layers: 1 hour minimum.

## TECHNICAL CHARACTERISTICS

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Solid content (weight) . . . . .	30%
Specific gravity . . . . .	(at 20°C/68°F) 0.96
Consistency AFNOR cup N°6 . . . . .	98 seconds (for information only)
Brookfield viscosity LV3 12t . . . . .	approximately 1100 cps (for information only)
Colour . . . . .	green
Flash point . . . . .	< 21°C / 69°F
Storage temperature . . . . .	-5° to +35°C (+23 to +95° F)
Film thickness . . . . .	200 µ
Film appearance . . . . .	green, elastic, cohesive
Film initial elongation at rupture . . . . .	approximately 340%
Initial rupture power of the film . . . . .	approximately 80 kg/cm <sup>2</sup>
Film peel strength on aluminium . . . . .	0.1 à 0.3 kg/cm depending on parts

## PRECAUTIONS FOR USE AND STORAGE

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- SOCOMASK PRT2130 contains solvents; prolonged exposure to concentrated vapours as well as contact with the skin are to be avoided.
- Use suitable ventilation. Keep sheltered from sun and heat sources.
- In case of ingestion, move the patient to fresh air and call a doctor.

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation.  
For professional use only.

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**This technical data sheet replaces and cancels the previous one.**

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