



KANSAI NEROLAC PAINTS LIMITED			
PRODUCT :- CED HG 350 E BLACK			
I. SUPPLY PAINT			
A . COMPONENT – PIGMENT PASTE (F-1)			
	1	CONDITION IN CONTAINER	HOMOGENEOUS BY AGITATION AND FREE FROM FOREIGN MATTER AND HARD CAKING.
	2	NON VOLATILE	$45 \pm 2\%$
	3	FINENESS OF GRIND	$< 15 \mu$
	4	VISCOSITY AT 28°C	300 ± 200 CPS
	5	SPECIFIC GRAVITY 28°C	1.3 ± 0.1
	6	ASH	$60 \pm 3 \%$
	7	pH @ 28°C (50g F-1 + 50g DIW)	7.0 ± 0.5
	8	SP CONDUCTIVITY @ 28°C (50g F-1 + 50g DIW)	$1500 \pm 300 \mu\text{S}/\text{CM}$
II COMPONENT – CLEAR EMULSION (F-2)			
	1	CONDITION IN CONTAINER	HOMOGENEOUS AND FREE FROM FOREIGN MATTERS
	2	NON VOLATILES	$34 \pm 2 \%$
	3	VISCOSITY AT 28°C	30 ± 20 CPS
	4	SPECIFIC GRAVITY AT 28°C	1.05 ± 0.1
	5	pH @ 28°C (50g F-2 + 50g DIW)	6.5 ± 0.5
	6	SP CONDUCTIVITY @ 28°C (50g F-2 + 50g DIW)	$1400 \pm 300 \mu\text{S}/\text{CM}$
	7	MEQ	29 ± 3



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III. BATH PAINT(3.5 LIT IN 4 LIT CONTAINER) (AGING 40 HRS. AT 30°C, OPEN CONTAINER)

1	NON VOLATILE	14 ~ 18 %
2	pH AT 28°C	5.6 ~ 6.4
3	CONDUCTIVITY AT 28°C	1200 ~ 1900 μ S/CM
4	MEQ	26 ~ 32
5	RESIDUE ON 400 MESH	< 10 MGS./LIT.
6	TOTAL SOLVENTS	1.0 ~ 2.0 %
7	ASH	12 ~ 17 %

IV. ED CHARACTERISTICS OF BATH PAINT

1	FILM THICKNESS AT 150 V 200 V 250 V	3' 15 $\pm$ 5 μ 20 $\pm$ 5 μ 25 $\pm$ 5 μ
2	COULOMBIC YIELD	MIN. 30 MGS./Q
3	FILM RESISTANCE @200V	500 ~ 800 K Ω CM ²
4	THROWING POWER @200V (PIPE METHOD)	MIN.18 CMS
5	L – EFFECT (H/V)	NORMAL
6	RESIDUE ON #400 MESH	< 10 MGS./LIT.



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V. ED FILM PERFORMANCE

*** BAKING CONDITION 170°C /20 MIN.(EMT)**

*** FILM THICKNESS 20 ± 2 μ**

1	APPEARANCE	NORMAL
2	GLOSS AT 60°	Min-50
3	PENCIL HARDNESS	MIN. H
4	ADHESION	0 /100
5	IMPACT RESISTANCE – DIRECT (DUPONT IMPACT TESTER 500 GMS. ½ " DIA)	MIN 50 CMS
6	SALT SPRAY RESISTANCE (JIS- K 5400 /ASTM B 117)	MIN. 960 HRS. CREEP WIDTH MAX 3 MM ON EITHER SIDE OF SCRIBED LINE BLISTER SIZE MAX. 8 F