



**霖辉**  
L I N W A Y

东莞市霖辉金属表面处理材料有限公司

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## **EC-7002 Acrylic Anodic Electrodeposition Coating**

### **1. FEATURES**

EC-7002 is a high performance anodic acrylic electrodeposition coating offering high gloss clear coatings with excellent image clarity, superior chemical and abrasion wear resistance.

- Exceptional levels of resistance to perspiration and sweat
- Excellent corrosion and UV light weathering resistance
- Superior chemical and abrasion wear resistance
- High performance hardness and solvent rub properties
- Medium and High build capability
- Low maintenance and high stability working solution

### APPLICATIONS

- Door Hardware
- Hinges
- Lock Parts
- Bicycle Parts
- Electronic Parts
- Lighting
- Spectacles
- Furniture Fittings
- Electrical Fixtures



## 2. Properties

### Test Results

Item	
Thickness $\mu\text{m}$	10-25
Cure temperature $^{\circ}\text{C}$	150-180
Cure Time min	30
Appearance	Glossy
Hardness	4H
Cross Hatch Adhesion	100/100
Coating property	Hard
5% NaOH (20 $^{\circ}\text{C}$ / 72 hours)	Pass
5% HCL (20 $^{\circ}\text{C}$ / 72hours )	Pass
Sulfuric Acid (20 $^{\circ}\text{C}$ / 72hours	Pass
CASS (50 $^{\circ}\text{C}$ / 72hours )	Pass Pass
CASS Corrosion resistance ( 50 $^{\circ}\text{C}$ /72hours )	
Salt Spray Test (35 $^{\circ}\text{C}$ , 350Hours)	Pass
Perspiration and sweat resistance (55 $^{\circ}\text{C}$ 24 Hours)	Pass
Gloss (60 degree)	>95
Acetone rubbing	➤ 300 cycles
RCA abrasion wear resistance (175 g)	➤ 100 cycles
Boiling (100 $^{\circ}\text{C}$ , 1hour)	Pass
MEK Solvent test	Pass

※ JIS Hardness Pencil, Mitsubishi Japan

※ According to JIS-H-8602.2371.8617、ISO-12870 ( 8.5 ) Standard



### 3. Equipment

Tank:	PP or PVC with overflow weir
Heating/Cooling	Yes
Filtration:	Yes
Ultrafiltration:	Yes
Cathode:	316 Stainless steel
Oven:	Batch or tunnel oven
Rack:	Stainless steel
Rectifier:	50-100A/ 100-200V

### 4. Solution Make Up

Solid content:	8-12%
EC700 ecoat:	1 part
DI water	5-7 parts

Note: the conductivity of DI water must be controlled below 1 $\mu$ S/cm with pH=6.8-8.0.

Add 50% of DI water into the working tank and pour required e-coat concentrate into the bath while stirring.

Keep stirring and add DI water to the working level. Filter the solution with 1 um bag or cartridge for 12-24 hours. Use diatomaceous earth filtration if necessary.

For e-coat concentrate replenishment, stir the e-coat concentrate with working solution then pour the mixed concentrate into the overflow weir. Replenishment should be done after production to ensure the emulsification. Resin solid content need to be checked regularly.



## 5. Operation conditions

Solid content	8-12%
pH	7.4-8.5
Conductivity	800-1250 $\mu$ S/cm @ 24°C
Temperature	24 $\pm$ 2°C
Voltage	60-150V
Time	20-180s

## 6. Curing

150-180°C (metal surface temperature) , 30min.

## 7. Safety

This product contains glycol ethers type solvent.

1. Workplace must be in full ventilation.
2. Spills must be cleaned up promptly and thoroughly according to the MSDS.
3. Proper personal protective equipment is required in workplace to protect workers from injury.

## 8. Waste Treatment

Resin in waste solution can be precipitated by acidified the solution. The filtrate of the waste solution contains small amount of solvent and other organic compounds and should be treated according to the discharge requirements.

## 9. Package and Storage

1. 20 kg/drum
2. Store at 0- 35°C full ventilation area and avoid direct sunlight.
3. Storage time: 12 months. Expired product can be used after quality checking.



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## **Disclaimer**

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