

GE Betz* DC-9746 / DC-9858

Black Acryshield* Treatment

- Provides:
 - Excellent roll forming lubricity
 - Superior corrosion protection
 - Excellent appearance
 - Superior fingerprint resistance
- Can be roll coat or flow squeegee applied
- Sludging minimized
- Applicable for Galvalume, hot dipped galvanized and electrogalvanized metal (Galvalume is a registered trademark of BIEC International Inc.)
- Operates at low temperature
- Low dry-off temperature
- No organic solvents
- Paintable with most systems
- Same products for makeup and replenishment

Description and Use

DC-9746 / DC-9858 are used to enhance appearance, lubricity, corrosion resistance and fingerprint resistance of zinc-coated sheet. It is designed for continuous coating of coil by roll coat or flow-squeegee. Coating appearance varies from grey to black depending on coating weight. The coating is dry and uniform. GE AccuTrak Plus* equipment can be used for monitoring and control.

Summary of Operating Data

Coating Bath Makeup

DC-9746/DC-9858 are used at a 3/1 ratio. Typical premix compositions are:

DC-9746	30 to 75%
DC-9858	10 to 25%
DI Water	0 to 60%

Caution: First mix DC-9746 and any required DI water. Then add DC-9858 to that mixture.

Normal Operating Controls

Chrome titration (AP305 with 1 mL sample)	4 to 12 mL
Temperature	70 to 100°F (21 to 38°C)
Chrome Coating Weight (AP457)	0.5 to 15 mg/ft ²

Surface Preparation

For most applications, DC-9746 / DC-9858 are applied after production of the galvanized or Galvalume surface. Therefore, cleaning is unnecessary. If cleaning is required, a suitable GE Kleen* Series product should be used. The metal should then be thoroughly rinsed prior to applying DC-9746 / DC-9858.

Drying

It is essential the metal strip leaving the chemical applicator be dried by any means that does not contaminate the surface with fumes, oil or partially burnt gases. The metal temperature of the strip leaving the drying section should be at least 140°F (60°C). Hot air convection, infrared or induction dry-



ing can be used. Any air flow necessary to aid drying should be limited to a maximum velocity of 3000 ft/min (91m/min).

Operational Recommendations

1. The treated metal should not be rinsed or exposed to quench water during processing unless the peak metal temperature during drying is 300 to 400°F (149 to 204°C).
2. If the treatment is stopped (e.g., for maintenance) the system should be thoroughly washed and then the rolls solvent wiped (e.g., with MEK).
3. A Portaspec (or similar x-ray fluorescence instrument) should be used for monitoring chrome coating weight.
4. Diaphragm pumps should be used for transfer, application and recirculation.

Equipment

The equipment for the DC-9746 / DC-9858 coating stage should be constructed of Type 316 stainless steel. Rolls (applicator or squeegee) should be covered with neoprene, hypalon or an alternate compatible elastomer. DC-9746 / DC-9858 solutions are compatible with many common plastics, including Teflon, Polysulfone, Kynar and Polyethylene HDCL. (Teflon is a registered trademark of DuPont. Kynar is a registered trademark of Autofina Chemicals.)

Packaging

DC-9746 and DC-9858 are blended as liquids and are supplied by the unique ChemSure* Delivery Services. ChemSure is safe, reliable, easy to use and environmentally compliant. GE offers two universal delivery systems: Bulk and Semi-Bulk. The containers are available in a variety of other packages including drums and pails. Ask your representative for more details.

Storage

DC-9746 freezes at 30°F (-1°C) and DC-9858 at 10°F (-12°C). If product freezes, warm and mix thoroughly prior to use. Long term, high temperature storage of DC-9746 must be avoided. Ideal storage

conditions for these products are 40 to 100°F (4 to 38°C).

Materials

The following chemicals are needed to operate the process and can be obtained from GE:

- DC-9746
- DC-9858

Safety Precautions

Material Safety Data Sheets containing detailed information relative to the products used in this process are available upon request.