

TECHNICAL DATA SHEET

Sealer 350 WL8

Organic / Inorganic sealer

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1 Process Information

- **Sealer 350 WL8** is a water dilutable, organic/inorganic sealing-system based on silicon with integrated lubricant for friction adjustment and is used for dip/spin of metal work pieces.
- **Sealer 350 WL8** contains no chromates in the dry film and does not produce hydrogen embrittlement into the coated material.
- **Sealer 350 WL8** is an inorganic/organic sealing system which reacts with all our passivations and chromates on top of zinc or zinc alloys.

2 Equipment

Tank	Polyethylene, Polypropylene or PVC
Heater	Heater made of hard glass, hard porcelain or PTFE. Avoid high power > 2 W/cm ²
Filtration	Only use membrane pumps or peristaltic pumps with polypropylene filter tubes. Filter media rated at 10-40 µm

3 Make-Up for Barrel Parts

Make-Up of 100 l	Liter	kg
Deionized water	10 – 55	10 – 55
Sealer 350 WL8	45 – 90	46.8 – 93.6

4 Make-Up for Rack Parts

Make-Up of 100 l	Liter	kg
Deionized water	60 – 80	60 – 80
Sealer 350 WL8	20 – 40	20.8 – 41.6

5 Working Parameters

Spin application parameter for bulk parts	Temperature: 22 °C (20 – 30 °C) Dipping time: 10 – 60 s Spinning time: 10 s (5 – 30 s) Centrifuge speed: 200 – 400 rpm
Drying	15 minutes at 80 °C (part temperature)
pH	9 - 10

6 Maintenance for Barrel

Nominal Values	On Make-Up	During operation
Sealer 350 WL8	450 – 900 ml/l	450 ml/l – 900 ml/l
Solid content	12.7 – 25.3 %	12.7 % – 25.3 %

7 Maintenance for Rack

Nominal Values	On Make-Up	During operation
Sealer 350 WL8	200 ml/l– 400 ml/l	200 ml/l – 400 ml/l
Solid content	5.6 % – 11.3 %	5.6 % – 11.3 %

The addition of 3.5 ml/l **Sealer 350 WL8** increases the solids content by 0.1%.

8 Material No. for Make-Up and Maintenance Products

PRODUCT	MATERIAL NO.
SEALER 350 WL8	1687934

9 Document History

Current revision status	Date	Change against last version:
01	07. Apr.2016	New
02	25. Jan.2017	QDS to Sales
03	05. May.2020	Heater Equipment changed

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