

## TECHNICAL LEAFLET

IIDA INDUSTRY Co. Ltd.

### **Spot Weld Sealer** **OROTEX 580M**

**Orotex 580M** spot weld sealer is a black, viscous paste type sealer, which becomes spongy (foam) when cured by heat in painting process and adheres to steel sheet and thus exhibits excellent rust proof properties.

#### **a). Characteristics**

1. Butadiene copolymer based
2. Foaming occurs upon curing by heat
3. Ensures perfect sealing even there are gaps or distortions on welded steel sheets.
4. Adheres well to oily surface and had good workability

#### **b). Properties**

Appearance	: Black Paste
Viscosity cps (25°C)	: 2100 ± 500
Specific Gravity	: 1.30-1.50
Non Volatile Content	: >95
Expansion (%)	: 61-120
Water Absorption (%)	: >5
Shear Strength	: >0.5 kgf/cm <sup>2</sup> & 90% CF
Water Resistance	: >0.5 kgf/cm <sup>2</sup> & 90% CF
Heat Resistance	: >0.5 kgf/cm <sup>2</sup> & 90% CF
Flow Properties (mm)	: <10
Corrosion Properties	: No Corrosion

#### **c). Applications**

1. Apply using high pressure pump and spray equipment with a pump ratio of 30:1 to 55:1
2. Operating temperature range is between 140 °C to 215 °C, 30 mins

#### **d). Precaution**

1. Store in a cool, dry and clean place
2. Do not dilute with solvent
3. During setting up the pump, let out the air trapped between press plate and sealant
4. Clean with cloth soaked in solvent upon contact with undercoat. Wash well with soap

**e). Packaging**

Pail Can	25kg
Cartridge	300 ml