



VICOTE®

VICTREX® PEEK COATING TECHNOLOGY

VICOTE® COATINGS 700 SERIES

Quick 10 Step Guide For Optimum Results

- 1** Substrate must be thoroughly cleaned and degreased.
- 2** Grit blast the substrate to give a profile 20 -25% of the total coating DFT (Dry Film Thickness). A final solvent wash of the substrate is advisable.
- 3** VICOTE powder should be dried in a shallow tray before use – 150°C (302°F) for 3 hours or 120°C (248°F) overnight.
- 4** VICOTE powder, drying in an oven should be covered with aluminium foil to prevent cross contamination from other powders.



- 5** All electrostatic equipment that is in contact with the VICOTE powder must be thoroughly stripped and cleaned to remove all vestiges of previously used powders. Powder delivery hoses should be dedicated to VICOTE Coatings unless they can be completely cleaned of other powders. Guns should be completely stripped down and ideally washed with (for example) IPA and then dried. If this step is not undertaken the finished coating may contain significant surface defects.
- 6** Parts can either be heated up in the oven and then the first coat applied to the hot part or the first coat applied cold and then subsequent coats hot flocked.
- 7** Recommended oven temperatures for different VICOTE grades are
 - VICOTE 701: 400°C- 420°C (752°F-788°F)
 - VICOTE 702 / 703 / 705 / 706: 380°C- 400°C (716°F- 752°F)
 - VICOTE 709: 420°C (788°F)
- 8** As soon as the powder has melted and flowed out, the part can be taken out of the oven and either left to cool or another coat hot flocked on top of the first coat. Leaving the part for too long in the oven will result in oxidative degradation resulting in the coating becoming darker in colour.
- 9** Subsequent coats can be applied to build up the coating thickness by the hot flocking technique. A minimum of 2 coats is recommended.
- 10** After the final coat and flow out remove the part from the oven and let cool down to ambient temperature.

For further technical assistance please contact your local Victrex office or Technical Centre.

High Temperature Performance Coatings For Strength and Durability

www.vicote.com



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