

PUMPING STABILITY FOR ELECTROCOATING PRIMERS**Application**

This procedure is used to determine the mechanical stability of electrocoating bath consisting of not more than 20 % non-volatile material content on agitation in open vessels.

Apparatus Required**Tank - (18.9 liters)**

Heat insulated, with conical bottom and variable speed circulating pump with one rheostat and a plastic flexible tube system as shown in Figure 1. The pump is submerged in a separate thermostat bath.

Source: Model #1
 Little Giant Pump Co.
 3210 N. Tulsa St.
 Oklahoma City, Oklahoma U.S.A.

Measuring Vessel - (7.6 liters)**Electrocoating Equipment**

See Ford Laboratory Test Method BI 120-01.

Procedure

1. The tank is filled with paint as used in an electrocoating tank, using some of the paint for the priming of the pump and hose system.
2. The pump is started and the paint flow measured by closing rubber hose "A" by means of a pinch clamp and letting paint flow from "B" for 60 sec into a 7.6 liter measuring vessel. The rheostat is used to adjust the flow to 7.6 liter/min. Valve "B" is closed, the pinch clamp removed, so that the paint circulates from hose "A" through the tank and the pump.
3. The bottom and walls of the tank are provided with thermal insulation so that the mechanical and other energy produced by the agitating system maintains a bath temperature of 35 +/- 2 °C against the ambient room temperature.

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Page 1 of 3

4. Water, alkali or acid, and solvent level, are maintained through periodic additions.
5. The agitation, temperature, pH, solubilizer conc, solvent level, etc. are maintained as specified by vendor for 20 days. At the end of this period the paint bath and the electrocoated panels from it must not show deviation from the original properties.

Chemicals, materials, parts, and equipment referenced in this document must be used and handled properly. Each party is responsible for determining proper use and handling in its facilities.