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## Detailed e-Coating (electrophoretic-Coating) Process for Heat Exchangers and Radiators

Electrochemical Deposition Coating (EDC) is typically divided into several distinct work stations:

**TANK 1** - The CoreKote Process starts with the removal of a weak Oxide layer that has formed in the bare surface. Heated Alkaline cleaning is used to remove the oxide film and any process lubricant residues.

**TANKS 2 & 3** - A neutral PH rinse is used to remove the oxide film and process lubricant residues.

**TANK 4** - A full immersion process then deposits the Zirconium\* Oxide layer on the surface of the material. A conversion layer forms on the surface enhancing improved fin edge build and adhesion.

*\* Zirconium corrosion resistance has been tested as a stand-alone material, showing improved protection*

- Organic Zirconium Pretreatment Designed For High Performance On All Substrates.
- Extremely Uniform Coatings Promote Uniform E-coat Applications
- Technology Proven In HVAC, Appliance, Construction, And Agriculture Industries.
- Zirconium Oxide Material is a High Strength Particulate Matter
- Formation of a Barrier Layer - Restricting Ion, Water and Oxygen Access to the Substrate
- Chemical and Mechanical Stabilization of the Native Oxide Film
- Environmentally Friendly, No Heavy Metals, Ambient Application

**TANK 5** – Rinse.

**TANKS 6 & 7** - After pretreatment, coils pass thru multiple rinse tanks to ensure a neutral ph surface.

**TANK 8** - E-COATING Full Immersion With our patented technology, film build is controlled to +/- .0002. Anode control ensures no bridging and 100% coated to the center.

**TANKS 9 & 10** - Post rinse before curing ensures no loose material is left on the surface, contributing to an even film build.

**OVEN CURE** - The next stage is oven cure. Axalta E-coat material is a lower temperature cure (355F) then other E-coats on the market.

**TOP COAT** - Final stage is the Spray Top Coat. This provides an additional protective layer and attractive finish.