Technical Data Sheet





WA4911HRU905 FREIOTHERM-ATL-EcoOne

Product description

Product technology anodic electrocoat paint depositable 2K

Application area e.g. in the functional furniture and storage technology sector

Application Primer and single coat system

Type of paste Pigment paste, fully neutralised

Scratch resistance high scratch resistance

General product properties

Binder-Base Acrylic Resin

Colour Jet black

MEQ-Base-Value 30-40 mg/g DIN EN ISO 15880

Density1,1-1,3 g/cm³theoreticalSolid mass48-52 %theoretical

Resistance to storage approx. 6 month in original packagings at an ambient temperature of 5 to 25 °C. Protect

from frost. Open packages are to be used within a short time.

The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.

Application and processing

Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust,

scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment

processes (e.g. phosphating) according to the requirements.

Gloss value 40-55 GU, Angle 60° DIN EN ISO 2813

Mixin ratio Products WA4000 : WA4911

Parts by weight 1:1

Recommended coating

thickness

13-17 µm

pH-Value 8,1-8,7 DIN 19260

Cunductance 1700-2500 μS/cm

Solid mass 12-14 % DIN EN ISO 3251

Bath Temperature 24-27 °C

Coating Time 60-180 sec.

Deposition Voltage 100-260 Volts

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications.

The sale of our products is in accordance with our terms of business, delivery and payment.

DIN EN ISO 9001 | IATF 16949 | EMAS

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6 78199 Bräunlingen-Döggingen | Deutschland +49 77071510

www.freilacke.de | info@freilacke.de

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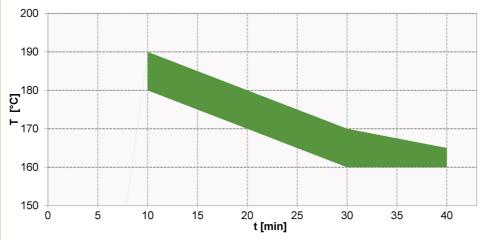
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Turn-over

1 Turnover per year

To ensure bath stability and thus the coating quality, the specified turnover (solids exchange of the tank) must be observed.

Curing Recommended object temperature 20 min/170 °C



Objekt Temperatur in °C Object Temperature in °C	160	170	180
Haltezeit Minimum in Minuten Holding time minimum in minutes	30	20	10
Haltezeit Maximum in Minuten Holding time maximum in minutes	40	30	20

Note on curing

Coloured area = stoving conditions with good end properties

The displayed baking conditions are based on results from laboratory tests and therefore merely serve as a guideline when configuring the processing company's coating systems. The processing company is responsible for ensuring that the coating is fully cured. The complete curing of the coating must be checked by means of additional analytical and resistance tests using representative original parts under production conditions. Please do not hesitate to contact us if you require consultation.

Comments

Work-and Healthprotection

The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.

Test conditions

All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.

The information provided here contains reference values and does not constitute a specification.

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