Technical Datasheet





Characteristics	Anodic electrocoat paint of the control of the c	depositable 1K	
	Application, e.g. in the vehicle construction sector		
	Subsequent paste filling,	partly neutralised	
	Very good corrosion prote	ection	
Technical / Physical Data	■ Binder-Base	Acrylic-Epoxy Resin	
	Colour	black Based on the specified colour template (i.e. RAL)	
	Solid Mass DIN EN ISO 3251	63-67 %	
	Density calculated	1,11 g/cm³	
	■ MEQ-Base-Value DIN EN ISO 15880	58-65	
	■ Viscosity	2000-6000 mPa.s	
	■ Test layer thickness	17-25 μm	
Mechanical Test	on iron phosphating		
	Cross-cut-test DIN EN ISO 2409	Gt 0	
	■ Erichsen index DIN EN ISO 1520	5 mm	
	■ Impact-Test DIN EN ISO 6272-1	50 kg cm (front)	
Resistance Test	on iron phosphating		
	■ Salt spray test (NSS) DIN EN ISO 9227	240 hours water ingress Wb <2 mm DIN EN ISO 4628-8	
	■ Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.	
Processing and application Dependent on plant and buildings	rust, scale, rolling skin, w For more demanding requ	Pretreatment The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. For more demanding requirements on corrosion inhibiting properties, we recommend suitable conversion processes (e.g. phosphatizing).	
	Gloss value DIN EN ISO 2813	30-50 geometry 60°	
	■ pH-Value	8,0-8,6	
	■ Cunductance	1000-1800 μS/cm	
	Solid Mass DIN EN ISO 3251	13-15 %	
	■ MEQ-Base-Value DIN EN ISO 15880	52-58 mg/g	
	■ Organic Solvent Content	0,6-2,2 %	

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 and delivery.

Page: 1 / 2 Version: 2 14.02.2021 DIN EN ISO 9001 IATF 16949 EMAS Emil Frei GmbH & Co. KG Döggingen Am Bahnhof 6 78199 Bräunlingen | GERMANY Phone +49 [0] 7707.151-0 Fax +49 [0] 7707.151-238 www.freilacke.de info@freilacke.de





■ Bath Temperature	24-27 °C
Coating Time	120-240 seconds
■ Deposition Voltage	70-230 voltage

Health & Safety at Work guidlines

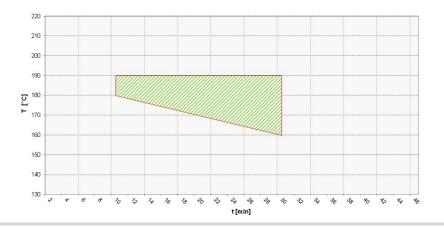
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

Curing

Object temperature

Recommended baking temperature 20 Min./170 °C

green cross-hatching = baking conditions with good final properties



Resistance to storage

One Turn-Over per year

Approx. 12 month in original packagings at an ambient temperature of 5 to 25 $^{\circ}$ 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.

Specific comments

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.