WA4913HRU902
FREIOTHERM-ATL-Special

Product description

Product technology	anodic electrocoat paint depositable 1K
Application area	e.g. in the construction and sanitary sector
Type of paste	Subsequent paste filling, partly neutralised

General product properties

Binder-Base	Acrylic Resin	
Viscosity	2000-6000 mPa*s	
MEQ-Base-Value	28-35 mg/g	DIN EN ISO 15880
Density	1,2-1,3 g/cm³	theoretical
Solid mass	63-67 %	theoretical
Resistance to storage	approx. 12 month in original packagings at an ambient temperature of 5 to 30 °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	30-50 GU, Angle 60°	DIN EN ISO 2813
Recommended coating thickness	15-35 µm	
pH-Value	8,3-8,7	DIN 19260
Cunductance	1200-1800 µS/cm	
Solid mass	12-14 %	DIN EN ISO 3251
MEQ-Base-Value	60-70 mg/g	DIN EN ISO 15880
Organic Solvent Content	1,2-2,2 %	
Bath Temperature	24-27 °C	
Coating Time	120-240 sec.	
Deposition Voltage	100-260 Volts	
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.	

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.

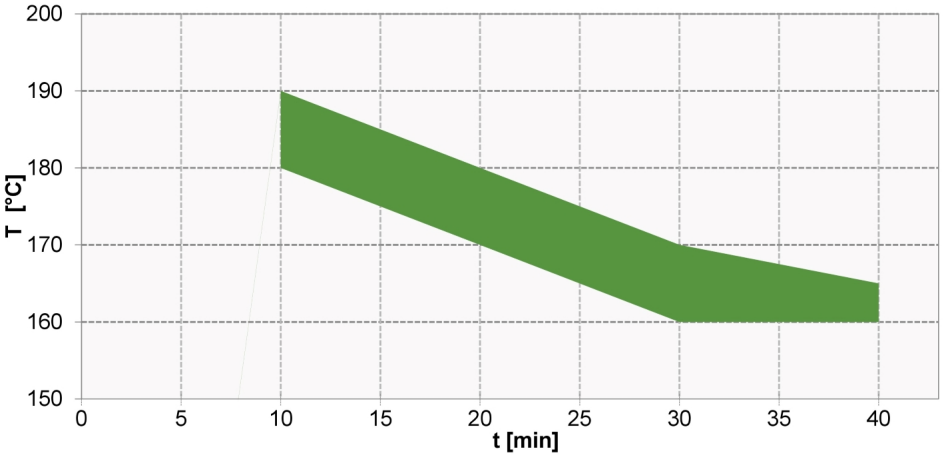
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Curing

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.

Mechanical tests

Test substrate	on phosphate free conversion	
Cross-cut-test	Gt 0	DIN EN ISO 2409
Mandrel bending test cylindrical	8 mm	DIN EN ISO 1519

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Climatic tests

Test substrate	on phosphate free conversion		
Condensate constant climate	Load duration	504 h	DIN EN ISO 6270-2 (CH)
	Detachment Cut	<1 mm	DIN EN ISO 4628-8

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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