WK4030GRU999
FREIOTHERM-KTL-Acrylate

Product description

Product technology	cathodic electrocoat paint depositable 1K
Application area	e.g. in the job coater sector
Application	Single coat system
Type of paste	Transparent paste, fully neutralised
Scratch resistance	high scratch resistance
Resistance to light and weather	very good

General product properties

Binder-Base	Acrylic Resin, modified	
Colour	colorless	
Viscosity	250-500 mPa*s	
Density	1,0-1,1 g/cm³	theoretical
Solid mass	49-53 %	theoretical
Resistance to storage	approx. 9 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	90-140 GU, Angle 60°	DIN EN ISO 2813
Recommended coating thickness	12-16 µm	
pH-Value	4,3-4,8	DIN 19260
Cunductance	900-1400 µS/cm	
Solid mass	18-20 %	DIN EN ISO 3251
Organic Solvent Content	1-5 %	
Bath Temperature	32-34 °C	
Coating Time	15-60 sec.	

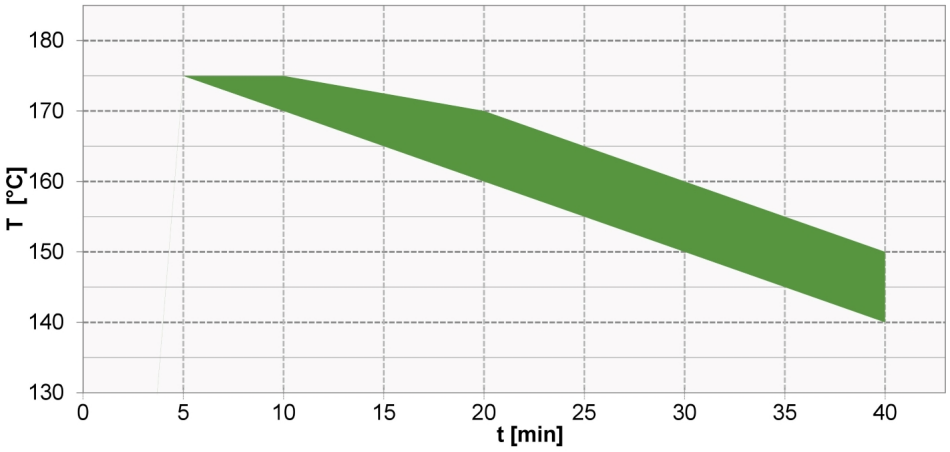
Our technical data sheets are to provide you with advice based on our latest state of knowledge.
This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications.
The sale of our products is in accordance with our terms of business, delivery and payment.

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Deposition Voltage	30-100 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.
Curing	Recommended object temperature 20 min/160 °C



Objekt Temperatur in °C Object Temperature in °C	**150**	**160**	**170**	**175**
Haltezeit Minimum in Minuten Holding time minimum in minutes	**30**	**20**	**10**	**5**
Haltezeit Maximum in Minuten Holding time maximum in minutes	**40**	**30**	**20**	**10**

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.

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DIN EN ISO 9001 | IATF 16949 | EMAS

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Mechanical tests

Test substrate	on aluminium /aluminium pressure casting		
Cross-cut-test	Gt 0		DIN EN ISO 2409
Pencil Hardness	4H		DIN EN ISO 15184
Buchholz penetration test	0,8 mm		DIN EN ISO 2815

Climatic tests

Test substrate	on aluminium /aluminium pressure casting		
Condensate constant climate	Load duration Detachment Cut	1008 h <0,5 mm	DIN EN ISO 6270-2 (CH) DIN EN ISO 4628-8
Neutral salt spray test	Load duration Detachment Cut	1008 h <1 mm	DIN EN ISO 9227 (NSS) DIN EN ISO 4628-8
Weather-O-Meter	Load duration	504 h	DIN EN ISO 16474-2 Procedure A1
QUV/B-313 test	Load duration	504 h	DIN EN ISO 16474-3 Procedure C

Chemical resistance

Test substrate	on aluminium /aluminium pressure casting
Influencing factors	The chemical resistance depends on the concentration, temperature, exposure time and test method. This has to be checked depending on the application.

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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