### **Technical** Data Sheet





## WA4422GE301A FREIOTHERM-ATL-WheelTec

#### **Product description**

Product technology anodic electrocoat paint depositable 1K

**Application area** e.g. in the automotive sector

**Application** Primer

Type of paste Pigment paste, fully neutralised

Scratch resistance high scratch resistance

#### **General product properties**

Binder-Base Acrylic Resin

**Colour** red translucent

MEQ-Base-Value 45-65 mg/g DIN EN ISO 15880

Density1,0-1,3 g/cm³theoreticalSolid mass35-43 %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 >50 GU, Angle 60° DIN EN ISO 2813

**Recommended coating** 

thickness

15-20 µm

**pH-Value** 7,5-9 DIN 19260

**Cunductance** 700-1200 μS/cm

 Solid mass
 8-12 %
 DIN EN ISO 3251

 MEQ-Base-Value
 45-60 mg/g
 DIN EN ISO 15880

Bath Temperature24-27 °CCoating Time60-90 sec.Deposition Voltage50-150 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

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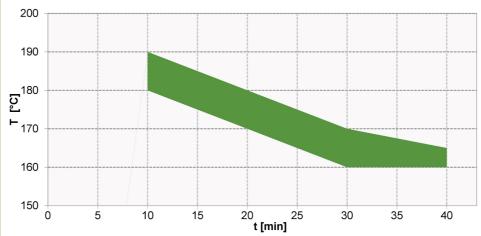
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#### Turn-over

#### 1 Turnover per year

To ensure bath stability and thus the coating quality, the specified turnover (solids exchange of the ETL 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.

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#### Mechanical tests

**Test substrate** on aluminium /aluminium pressure casting **Cross-cut-test** Gt 0 DIN EN ISO 2409

**Climatic tests** 

**Test substrate** on aluminium /aluminium pressure casting

**Condensate constant** DIN EN ISO 6270-2 (CH) Load duration climate **Detachment Cut** <1 mm **DIN EN ISO 4628-8** 

Neutral salt spray test Load duration 240 h **DIN EN ISO 9227 (NSS)** 

**DIN EN ISO 4628-8 Detachment Cut** <1 mm

Comments

Work-and The standard personal safety precautions must be observed when handling painting Healthprotection

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

Print date: Aug 8, 2023

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.

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