



WK4512HRU512 FREIOTHERM-KTL-Acrylate

Product description

Product technology	cathodic electrocoat paint depositable 2K
Application area	e.g. in the vehicle construction sector
Application	Primer and single coat system
Type of paste	Pigment paste, fully neutralised
Resistance to light and weather	very good

General product properties

Binder-Base	Acrylic Resin, modified
Density	1,1 - 1,4 g/cm ³ theoretical
Solid mass	60 - 65 % theoretical
Resistance to storage	approx. 9 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-improving 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 - 70 GU, Angle 60°	DIN EN ISO 2813
Mixin ratio	Products WK4046 : WK4512 Parts by weight 1 : 1	
Recommended coating thickness	20 - 40 µm	
pH-Value	4 - 6	DIN 19260
Cunductance	800 - 1600 µS/cm	
Solid mass	10 - 20 %	DIN EN ISO 3251
Organic Solvent Content	1,0 - 5,0 %	
Bath Temperature	30 - 34 °C	
Coating Time	120 - 240 sec.	
Deposition Voltage	80 - 240 Volts	



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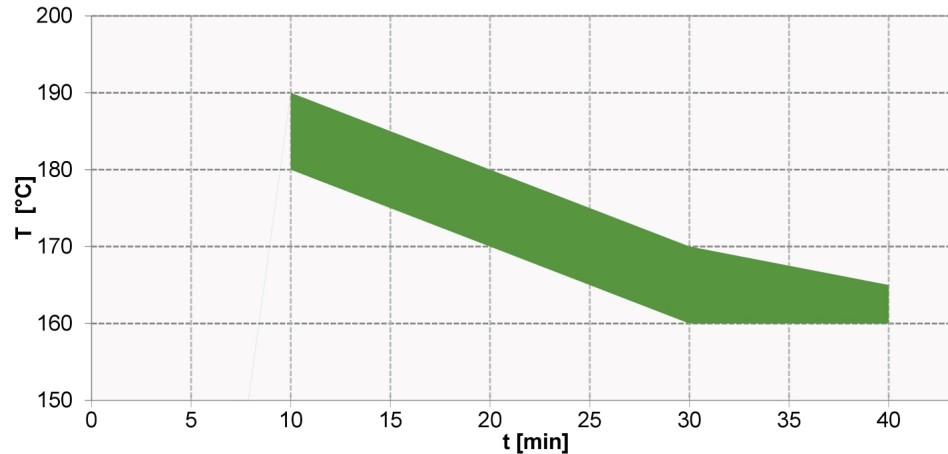
Turn-over

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.

Mechanical tests

Test substrate	on phosphate free conversion	
Cross-cut-test	Gt 0	DIN EN ISO 2409

Climatic tests

Test substrate	on phosphate free conversion		
Condensate constant climate	Load duration	504 h	DIN EN ISO 6270-2 (CH)
	Detachment Cut	< 0,5 mm	DIN EN ISO 4628-8
Neutral salt spray test	Load duration	480 h	DIN EN ISO 9227 (NSS)
	Detachment Cut	< 2 mm	DIN EN ISO 4628-8



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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 and 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.