



FREIOTHERM-KTL-Automotive

WK4778HRU724

Characteristics	<ul style="list-style-type: none"> ■ Cathodic electrocoat paint depositable 2K ■ Application, e.g. in the construction and sanitary sector ■ Pigment paste, fully neutralised ■ Primer ■ Good corrosion protection 	
Technical / Physical Data	<ul style="list-style-type: none"> ■ Binder-Base 	Expoxy Resin, modified
	<ul style="list-style-type: none"> ■ Colour 	graphite grey Based on the specified colour template (i.e. RAL)
	<ul style="list-style-type: none"> ■ Solid Mass DIN EN ISO 3251 	58-62 %
	<ul style="list-style-type: none"> ■ Density calculated 	1,48 g/cm ³
	<ul style="list-style-type: none"> ■ MEQ/s-Value 	22-28 mmol/100g
	<ul style="list-style-type: none"> ■ Viscosity 	1300-3300 mPa.s
	<ul style="list-style-type: none"> ■ Test layer thickness 	20-30 µm
Mechanical Test	<ul style="list-style-type: none"> ■ on iron phosphating 	
	<ul style="list-style-type: none"> ■ Cross-cut-test DIN EN ISO 2409 	Gt 0
Resistance Test	<ul style="list-style-type: none"> ■ on iron phosphating 	
	<ul style="list-style-type: none"> ■ Condensate constant climate DIN EN ISO 6270-2 (CH) 	504 hours water ingress Wb <1 mm DIN EN ISO 4628-8
	<ul style="list-style-type: none"> ■ Salt spray test (NSS) DIN EN ISO 9227 	240 hours water ingress Wb <2 mm DIN EN ISO 4628-8
Processing and application Dependent on plant and buildings	<ul style="list-style-type: none"> ■ 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). 	
	<ul style="list-style-type: none"> ■ Mixing ratio 	4:1 WK4035 : WK4778
	<ul style="list-style-type: none"> ■ Gloss value DIN EN ISO 2813 	30-50 geometry 60°
	<ul style="list-style-type: none"> ■ pH-Value 	5,0-6,0
	<ul style="list-style-type: none"> ■ Conductance 	1200-1600 µS/cm
	<ul style="list-style-type: none"> ■ Solid Mass DIN EN ISO 3251 	14-16 %
	<ul style="list-style-type: none"> ■ MEQ/b-Value 	5-6 mmol/100 g
	<ul style="list-style-type: none"> ■ Organic Solvent Content 	1,3-3,0 %
	<ul style="list-style-type: none"> ■ Bath Temperature 	32-34 °C



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	■ Coating Time	60-180 seconds
	■ Deposition Voltage	170-300 voltage
	■ Health & Safety at Work guidelines	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./150 °C green cross-hatching = baking conditions with good final properties
Resistance to storage	■ One Turn-Over per year	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.
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.