# **Technical Datasheet**





Chavastaviation		
Characteristics	Cathodic electrocoat paint de	•
	Application, e.g. in the const	ruction and sanitary sector
	Pigment paste, fully neutralis	sed
	■ Primer	
	■ Good corrosion protection	
Technical / Physical Data	■ Binder-Base	Expoxy Resin, modified
	Colour	graphite grey Based on the specified colour template (i.e. RAL)
	Solid Mass DIN EN ISO 3251	58-62 %
	Density calculated	1,48 g/cm³
	■ MEQ/s-Value	22-28 mmol/100g
	■ Viscosity	1300-3300 mPa.s
	■ Test layer thickness	20-30 μm
Mechanical Test	on iron phosphating	
	Cross-cut-test DIN EN ISO 2409	Gt 0
Resistance Test	on iron phosphating	
	Condensate constant climate DIN EN ISO 6270-2 (CH)	e 504 hours water ingress Wb <1 mm DIN EN ISO 4628-8
	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	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).	
	Mixing ratio	4:1 WK4035 : WK4778
	Gloss value DIN EN ISO 2813	30-50 geometry 60°
	■ pH-Value	5,0-6,0
	■ Cunductance	1200-1600 μS/cm
	Solid Mass DIN EN ISO 3251	14-16 %
	■ MEQ/b-Value	5-6 mmol/100 g
	Organic Solvent Content	1,3-3,0 %
	■ Bath Temperature	32-34 °C

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 and delivery.

Page: 1 / 2 Version: 0 16.05.2021 DIN EN ISO 9001 IATF 16949 EMAS Emil Frei GmbH & Co. KG
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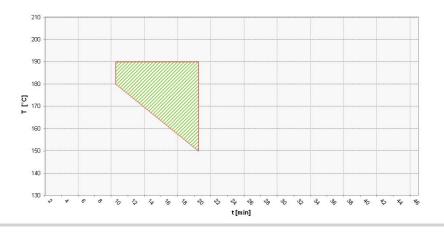
Coating Time	60-180 seconds	
Deposition Voltage	170-300 voltage	
■ Health & Safety at Work guidlines  The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work 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  $^{\circ}$ 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.

DIN EN ISO 9001

IATF 16949 EMAS