



FREIOTHERM-KTL-Automotive

WK4709HS2852

Characteristics	■ Cathodic electrocoat paint depositable 2K ■ Application, e.g. in the mechanical engineering and plant construction sector ■ Pigment paste, fully neutralised ■ Primer ■ Good corrosion protection	
Technical / Physical Data	■ Binder-Base	Expoxy Resin, modified
	■ Colour	SKC grey Based on the specified colour template (i.e. RAL)
	■ Solid Mass DIN EN ISO 3251	68-70 %
	■ Density calculated	1,80 g/cm ³
	■ MEQ/s-Value	42-47 mmol/100g
	■ Test layer thickness	15-25 µm
Mechanical Test	■ on zinc phosphate	
	■ Cross-cut-test DIN EN ISO 2409	Gt 0
Resistance Test	■ on zinc phosphate	
	■ Salt spray test (NSS) DIN EN ISO 9227	500 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	The mixing ratio is dependent on various factors and is therefore coordinated with the relevant system in cooperation with the application technology department.
	■ Gloss value DIN EN ISO 2813	40-60 geometry 60°
	■ pH-Value	5-6
	■ Conductance	900-1600 µS/cm
	■ Solid Mass DIN EN ISO 3251	15-18 %
	■ MEQ/b-Value	5,5-7,0 mmol/100 g
	■ Organic Solvent Content	1,5-3,0 %
	■ Bath Temperature	28-34 °C
	■ Coating Time	600-800 seconds
	■ Deposition Voltage	150-350 voltage



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Curing

Health & Safety at Work guidelines

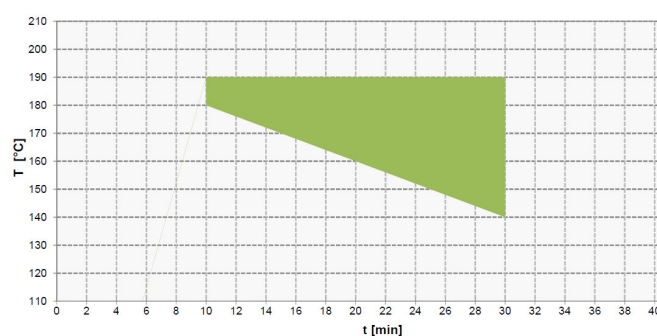
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

Object temperature

Recommended baking temperature 20 Min./160 °C

green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C	140	160	180
Object Temperature °C	140	160	180
Haltezeit Minimum Minuten	30	20	10
Holding time minimum Minutes	30	20	10
Haltezeit Maximum Minuten	40	30	20
Holding time maximum Minutes	40	30	20



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 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.