Technical Datasheet





Characteristics		Cathodic electrocoat paint depos	sitable 1K	
	.	Application, e.g. in the job coater sector		
		■ Transparent paste, fully neutralised		
		Single coat system		
	_ v	Very good light- and weather res	sistance	
	- 1	High scratch resistance		
Technical / Physical Data	- 1	Binder-Base	Acrylic Resin, modified	
		Colour	colourless	
		Solid Mass DIN EN ISO 3251	59-63 %	
		Density calculated	1,05 g/cm³	
		Viscosity	3000-7000 mPa.s	
		Test layer thickness	12-16 µm	
Mechanical Test	on aluminium / aluminium pressure casting			
		Cross-cut-test DIN EN ISO 2409	Gt 0	
		Buchholz penetration test DIN EN ISO 2815	0,8 mm	
	١	Pencil Hardness acc. Wolff- Wilborn ISO 15184	4H	
Resistance Test		on aluminium / aluminium pressure casting		
		Condensate constant climate DIN EN ISO 6270-2 (CH)	1008 hours water ingress Wb <0,5 mm DIN EN ISO 4628-8	
		Salt spray test (NSS) DIN EN ISO 9227	1008 hours water ingress Wb <1 mm DIN EN ISO 4628-8	
		QUV/B-313-Test DIN EN ISO 11507 postup 1A	504 hours	
		WOM-Test DIN EN ISO 11341 Process 1A	504 hours	
		Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.	
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).		
		Gloss value DIN EN ISO 2813	5-15 geometry 60°	
	- 1	pH-Value	4,3-4,8	

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.

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Cunductance	900-1400 μS/cm
Solid Mass DIN EN ISO 3251	18-20 %
Organic Solvent Content	1-5 %
■ Bath Temperature	32-34 °C
Coating Time	15-60 seconds
Deposition Voltage	30-100 voltage

Health & Safety at Work guidlines

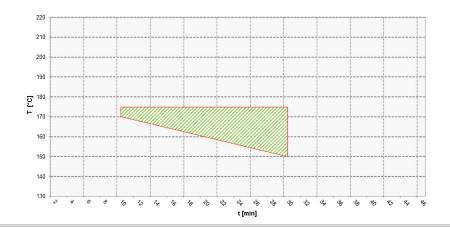
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

Curing

Object temperature

Recommended baking temperature 20 Min./160 °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.

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