Technical Datasheet





Solid Mass DiN EN ISO 3251 Exercised Exercis					
Pigment paste, fully neutralised Primer and single coat system	Characteristics	-	Cathodic electrocoat paint depo	sitable 2K	
Primer and single coat system			Application, e.g. in the vehicle construction sector		
Tochnical / Physical Data Binder-Base		ŀ	Pigment paste, fully neutralised		
Technical / Physical Data Binder-Base		ŀ	Primer and single coat system		
Binder-Base		-	Thick layer application		
Colour Reverneland red Based on the specified colour template (i.e. RAL			■ Very good light- and weather resistance		
Based on the specified colour template (i.e. RAL	Technical / Physical Data	Œ	Binder-Base	Acrylic Resin, modified	
Dink EN ISO 3251		ŀ	Colour	kverneland red Based on the specified colour template (i.e. RAL)	
Viscosity 2000-6000 mPa.s		ŀ		63-67 %	
Test layer thickness 40-50 μm				1,19 g/cm³	
On zinc phosphate		Ŀ	Viscosity	2000-6000 mPa.s	
Cross-cut-test DIN EN ISO 2409 Erichsen index DIN EN ISO 1520		٠	Test layer thickness	40-50 μm	
Erichsen index DIN EN ISO 1520 6 mm Mandrel bending test cylindrical 8 mm	Mechanical Test		on zinc phosphate		
Mandrel bending test cylindrical 8 mm		ŀ		Gt 0	
Resistance Test Stone chipping test DIN EN ISO 20567-1		ŀ		6 mm	
Resistance Test On zinc phosphate Condensate constant climate bin En Iso 6270-2 (CH) Salt spray test (NSS) Din En Iso 9227 A80 hours water ingress Wb <0,5 mm DIN En Iso 4628-8 GUV/B-313-Test Din En Iso 11507 postup 1A WOM-Test Din En Iso 11341 Process 1A Chemical resistance 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).		ŀ		8 mm	
Condensate constant climate DIN EN ISO 6270-2 (CH) Salt spray test (NSS) DIN EN ISO 9227 480 hours water ingress Wb <0,5 mm DIN EN ISO 4628-8 QUV/B-313-Test DIN EN ISO 11507 postup 1A WOM-Test DIN EN ISO 11341 Process 1A 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).		F	Stone chipping test DIN EN ISO 20567-1	Sensitivity 2,5	
Salt spray test (NSS) 480 hours water ingress Wb <2 mm DIN EN ISO 4628-8 Salt spray test (NSS) 480 hours water ingress Wb <2 mm DIN EN ISO 4628-8 QUV/B-313-Test 504 hours WOM-Test DIN EN ISO 11341 Process 1A 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).	Resistance Test	Е	on zinc phosphate		
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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 / 3 Version: 2 16.05.2021 DIN EN ISO 9001 IATF 16949 EMAS Emil Frei GmbH & Co. KG Döggingen Am Bahnhof 6 78199 Bräunlingen | GERMANY Phone +49 [0] 7707.151-0 Fax +49 [0] 7707.151-238 www.freilacke.de info@freilacke.de





	WK4025 : WK4314
Gloss value DIN EN ISO 2813	60-70 geometry 60°
■ pH-Value	4,5-5,5
Cunductance	1000-1400 μS/cm
Solid Mass DIN EN ISO 3251	16-18 %
Organic Solvent Content	5,5-6,5 %
■ Bath Temperature	32-34 °C
Coating Time	120-240 seconds
Deposition Voltage	200-350 voltage
Organic Solvent Content Bath Temperature Coating Time	5,5-6,5 % 32-34 °C 120-240 seconds

Health & Safety at Work guidlines

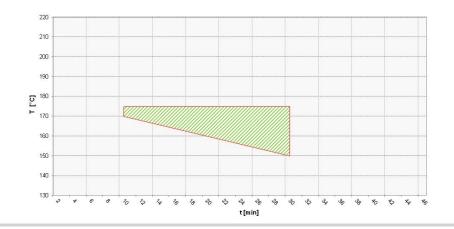
The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.

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 °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

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further information.

The information provided here contains reference values and does not constitute a specification.

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