



# FREIOTHERM-KTL-Acrylate

## WK4711HRU711

<b>Characteristics</b>	<ul style="list-style-type: none"> <li>■ Cathodic electrocoat paint depositable 2K</li> <li>■ Application, e.g. in the vehicle construction sector</li> <li>■ Pigment paste, fully neutralised</li> <li>■ Primer</li> <li>■ Good corrosion protection</li> </ul>												
<b>Technical / Physical Data</b>	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Expoxy Resin, modified</td> </tr> <tr> <td>■ Colour</td> <td>transparent Based on the specified colour template (i.e. RAL)</td> </tr> <tr> <td>■ Solid Mass <small>DIN EN ISO 3251</small></td> <td>63-67 %</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,662 g/cm<sup>3</sup></td> </tr> <tr> <td>■ MEQ/s-Value</td> <td>25-30 mmol/100g</td> </tr> <tr> <td>■ Test layer thickness</td> <td>15-30 µm</td> </tr> </table>	■ Binder-Base	Expoxy Resin, modified	■ Colour	transparent Based on the specified colour template (i.e. RAL)	■ Solid Mass <small>DIN EN ISO 3251</small>	63-67 %	■ Density <small>calculated</small>	1,662 g/cm <sup>3</sup>	■ MEQ/s-Value	25-30 mmol/100g	■ Test layer thickness	15-30 µm
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<b>Processing and application</b> Dependent on plant and buildings	<ul style="list-style-type: none"> <li>■ <b>Pretreatment</b> 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).</li> <li>■ <b>Mixing ratio</b> The mixing ratio is dependent on various factors and is therefore coordinated with the relevant system in cooperation with the application technology department.</li> <li>■ <b>Gloss value</b> <small>DIN EN ISO 2813</small> 20-50 geometry 60°</li> <li>■ <b>pH-Value</b> 5-6</li> <li>■ <b>Cunductance</b> 800-1400 µS/cm</li> <li>■ <b>Solid Mass</b> <small>DIN EN ISO 3251</small> 12-16 %</li> <li>■ <b>MEQ/b-Value</b> 5,5-7,0 mmol/100 g</li> <li>■ <b>Organic Solvent Content</b> 1,5-3,0 %</li> <li>■ <b>Bath Temperature</b> 32-34 °C</li> <li>■ <b>Coating Time</b> 120-240 seconds</li> <li>■ <b>Deposition Voltage</b> 150-350 voltage</li> </ul>												



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■ **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./160 °C

green cross-hatching = baking conditions with good final properties

Objekt Temperatur   °C	150	160	170
Object Temperature   °C	150	160	170
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.