FreiLacke

FREIOTHERM-ATL-Korrosionsfest
WA4980HRU905

Characteristics	■ Anodic electrocoat paint depositable 1K	
	■ Application, e.g. in the vehicle construction sector	
	■ Subsequent paste filling, partly neutralised	
	■ Very good corrosion protection	
Technical / Physical Data	■ Binder-Base	Acrylic-Epoxy Resin
	■ Colour	schwarz Based on the specified colour template (i.e. RAL)
	■ Solid Mass DIN EN ISO 3251	58-62 %
	■ Density calculated	1,04 g/cm³
	■ MEQ-Base-Value DIN EN ISO 15880	65-75
	■ Viscosity	2000-6000 mPa.s
	■ Test layer thickness	20-26 µm
Mechanical Test	■ on zinc phosphate	
	■ Cross-cut-test DIN EN ISO 2409	Gt 0
	■ Erichsen index DIN EN ISO 1520	4 mm
	■ Impact-Test DIN EN ISO 6272-1	50 kg cm (front)
Resistance Test	■ on zinc phosphate	
	■ Salt spray test (NSS) DIN EN ISO 9227	480 hours water ingress Wb <2 mm DIN EN ISO 4628-8
	■ 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	30-50 geometry 60°
	■ pH-Value	8,0-8,6
	■ Cunductance	1000-1800 µS/cm
	■ Solid Mass DIN EN ISO 3251	14-16 %
	■ MEQ-Base-Value DIN EN ISO 15880	60-70 mg/g
	■ Organic Solvent Content	0,6-2,2 %

DIN EN ISO 9001
IATF 16949
EMAS

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	Bath Temperature	24-27 °C
	Coating Time	135 seconds
	Deposition Voltage	70-200 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.

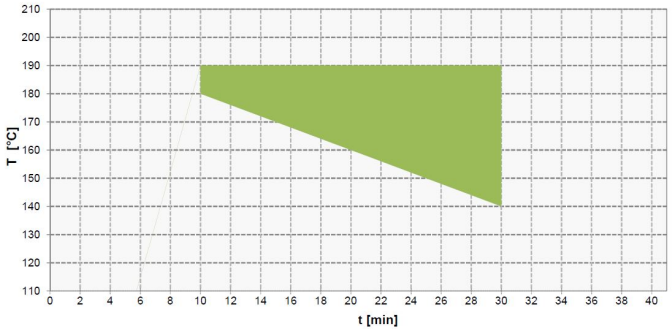
Curing

Object temperature

Recommended baking temperature 20 Min./170 °C

green cross-hatching = baking conditions with good final properties

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



Resistance to storage

One Turn-Over per year

Approx. 12 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 further information.
The information provided here contains reference values and does not constitute a specification.

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