

ARSONKOTE 212 2K CATHODIC WHITE

Pag 1/2

CHARACTERISTICS OF SUPPLIED PRODUCT

CHARACTERISTICS	UNITS	ARSONKOTE 212 2K PP - W 212 B 01 -	ARSONKOTE 212 2K CLEAR - W 212 X 38 -
Solids	2h @ 120°C	58 - 62 %	34 - 38%
Type of binder		Modified epoxy	Modified epoxy - PU
Type of pigments		Titanium dioxide – aluminium silicates	--
Ashes	%	44 - 46	--
Organic solvents		Butilglycol	Glycol ether
Neutralizing agent		Organic acid	Organic acid
Specific weight	gr/cm ³	1,51 – 1,53	1,08 – 1,12
Expiry date		1 year	8 months
Storage condition		+5 ÷ +30°C	+5°C +30°C
Pigment paste /Resin ratio (the actual rate will be established on the plant)		1 / 2	

BATH CONDITION

Solids	%	10 - 12
pH 25°C	--	5,8 – 6,8
Conductivity 25°C	µS/cm	900 - 1300
Binder /Pigment ratio	--	2,0 – 3,3

ARSONKOTE 212 2K CATHODIC WHITE

Pag 2/2

BATH DILUTION

Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	400
Keep well stirred and add		
Clear W 212 X 38	kg	193
Stir for 15 minuts and then add slowly		
Pigment paste W212 B 01	kg	87
Stir for 15 minuts and then add slowly		
Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	320
Before applying the bath stir it for 24 h at 25°C		

APPLICATION DATA (*)

Voltage		100 - 340
Dipping time	sec	120 - 150
Film thickness	µm	8 - 14
Bath temperature	°C	25 - 30
Baking temperature	°C	160 - 180
Backing time	min	15 - 20

CHARACTERISTICS OF APPLIED PRODUCT (*)

Film thickness	µm	10 - 12
Gloss 60°	UG	50 - 60
Erichsen indentation test	µm	6 - 8
Direct impact resistance (2 lbs x 100 cm) Ø = 1 inch		No cracking
Conical bending test (Ø = 6 mm)		No cracking
Salt spray resistance 800 h	ASTM B 117	< 2 mm at the cross No Blistering

* Support Bonder 26S W42 OC

Lainate , October 2013