

**ARSONKOTE 212 2K CATHODIC BLACK
X38-N05**

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CHARACTERISTICS OF SUPPLIED PRODUCT

CHARACTERISTICS	UNITS	ARSONKOTE 212 2K PP - W212 N 05 -	ARSONKOTE 212 2K CLEAR - W 212 X 38 -
Solids	2h @ 120°C	40 - 44 %	35 - 38%
Type of binder		Modified epoxy	Modified epoxy - PU
Type of pigments		Carbon black – aluminium silicates	--
Organic solvents		Butilglycol	Glycol ether
Neutralizing agent		Organic acid	Organic acid
Specific weight	gr/cm ³	1,13 – 1,15	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 / 4	

BATH CONDITION

Solids	%	12 - 16
pH 25°C	--	5,8 - 6,8
Conductivity 25°C	µS/cm	1000 - 2000
Pigment / Binder ratio	/ 100	15 - 20

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BATH DILUTION

Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	250
Keep well stirred and add		
Clear W 212 X 38	kg	293
Stir for 15 minuts and then add slowly		
Pigment paste W212 N 05	kg	80
Stir for 15 minuts and then add slowly		
Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	377
Before applying the bath stir it for 24 h at 25°C		

APPLICATION DATA (*)

Voltage	V	120 - 340
Dipping time	sec	120 - 150
Film thickness	µm	10 - 25
Bath temperature	°C	25 - 30
Baking temperature	°C	160 - 170
Backing time	min	15 - 20

CHARACTERISTICS OF APPLIED PRODUCT (*)

Film thickness	µm	15 - 17
Gloss 60°	UG	50 - 60
Erichsen indentation test	µm	7 - 8
Direct impact resistance (2 lbs x 100 cm) Ø = 1 inch		No cracking
Mandrel bending test (Ø = 6 mm)		No cracking
Salt spray resistance 1000 h	ASTM B 117	< 2 mm at the cross No Blistering

* Support Bonder 26S W42 OC

May , the 27th 2013