

Technical data sheet Rev. n. 1
 Lainate, 18 Dec 2017

ARSONKOTE 212 2K CATA TIN FREE EPOXY BLACK

* : S=pail; F=drum; C=tank

PRODUCT CHARACTERISTICS AS SUPPLIED

CHARACTERISTICS	Units	ARSONKOTE 212 2K PP - W212 N50 -	ARSONKOTE 212 2K CLEAR - W 212 X 35 -
Solids (2h at 120°C)	%	48 - 52	34 - 36
Type of binder		Epoxy modified	Epoxy modified - PU
Type of pigment		Carbon black – Aluminium silicates	--
Organic solvents		Butylglycol	Glycol ethers
Neutralizing agent		Inorganic Acid	Organic Acid
Density	gr/cm ³	1,10 – 1,18	1,05 – 1,12
Expiry date Storage Condition (+5 ÷ +30°C)	months	12	8
Pigm Paste / Clear Ratio (the actual rate will be established on the plant)	--	1 / 5	

BATH CONDITION

CHARACTERISTICS	Units	ARSONKOTE 212 2K Diluted
Solids	%	12 - 18
pH 25°C	--	5,0 - 5,8
Conductivity 25°C	µS/cm	800 - 2000
Pigment / Binder Ratio	/100	15 - 25

BATH PREPARATION

Demineralised Water (Conductivity at 25°C 10 µS/cm max)	kg	400
Maintain it under stirring and add		
Clear W212X35	kg	339,3
Stir for 15 minutes and then add slowly		
Pigment paste W212N50	kg	62,5
Stir for 15 minutes and then add slowly		
Demineralised Water (Conductivity at 25°C 10 µS/cm max)	kg	198,2
Before the application stir the bath for 24 hours at 25°C		

APPLICATION DATA (*)

Voltage	V	120 - 340
Dipping time	sec	120 - 150
Thickness	µm	15 - 30
Bath temperature	°C	25 - 30
Baking temperature	°C	160- 180*
Baking time	min	20 - 25

* depending on the applied pieces' shape , conformation and plant lay out

APPLIED FILM CHARACTERISTICS (*)

Film applied thickness	µm	15 - 20
Gloss 60°	UG	50 - 60
Erichsen Indentation test	mm	7 - 8
Direct impact resistance (2 lbs x 100 cm) Ø = 1 inch		Without cracking
Mandrel bending test (Ø = 6 mm)		Without cracking
Salt spray resistance 1000 h	ASTM B 117	< 2 mm at the cross Without Blistering

* Zinc salt support phosphated