

ARSONKOTE 100 2K

CHARACTERISTICS OF SUPPLIED PRODUCT

CHARACTERISTICS	Units	ARSONKOTE 100 2K PP - W100 B 80 -	ARSONKOTE 100 2K CLEAR - W 100 X 69 -
Solids	2h @120°C	58 – 62 %	35 - 37%
Type of binder		Acrylic melamine	Acrylic melamine
Type of pigments		Titanium dioxide	
Pigments	%	69 - 71	
Organic solvents		Butylglycol	Butylglycol
Neutralizing agent		Inorganic	Inorganic
Specific weight	gr/cm ³	1,49 – 1,51	1,03 – 1,07
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 / 0,8 – 1,5	

BATH CONDITION

Solids	%	11 - 14
pH 25°C		7,5 – 8,5
Conductivity 25°C	µS/cm	1000 - 2000
Binder /Pigment ratio		

ARSONKOTE 100 2K

BATH DILUTION

Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	400
Keep well stirred and add		
Clear W 100 X 69	kg	176
Stir for 15 minuts and then add slowly		
Pigment paste W100 B 80	kg	125
Stir for 15 minuts and then add slowly		
Demineralized water (Conductivity 25°C 20 µS/cm max)	Liters	299
Before applying the bath stir it for 24 h at 25°C		

APPLICATION DATA (*)

Voltage		200 - 350
Dipping time	sec	120 – 180
Film thickness	µm	10 – 24
Bath temperature	°C	24 – 28
Baking temperature	°C	170 - 180
Backing time	min	15 - 20

CHARACTERISTICS OF APPLIED PRODUCT (*)

Film thickness	µm	18
Gloss 60°	UG	60 - 70
Erichsen indentation test	µm	6 - 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 100 h	ASTM B 117	< 2 mm at the cross No Blistering

* Aluminium pretreated support

Lainate, March 11th 2011