

**ARSONKOTE 100 2K ONE COAT**

**CHARACTERISTICS OF SUPPLIED PRODUCT**

CHARACTERISTICS	Units	ARSONKOTE 100 2K PP - W 100 B 74	ARSONKOTE 100 2K CLEAR - W 100 X 79 -
Solids	2h @120°C	45 - 49 %	65 - 69%
Type of binder		Acrylic melamine	Acrylic melamine
Type of pigments		Titanium dioxide	
Pigments	%	63 - 65%	
Organic solvents		Butylglycol	Butylglycol
Neutralizing agent		Inorganic	Inorganic
Specific weight	gr/cm <sup>3</sup>	1,33 - 1,37	1,00 - 1,03
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 / 1 - 1,3	

**BATH CONDITION**

Solids		%	10 - 14
pH	25°C		8,3 - 9,0
Conductivity	25°C	µS/cm	900 - 1300

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### BATH DILUTION

<b>Demineralized water (Conductivity 25°C 20 µS/cm max )</b>	<b>Liters</b>	<b>646</b>
<b>Keep well stirred and add</b>		
<b>Neutralizing agent W920P96</b>		<b>11,9</b>
<b>Clear W 100 X 79</b>	<b>kg</b>	<b>119</b>
<b>Stir for 15 minuts and then add slowly</b>		
<b>Pigment paste W 100 B 74</b>	<b>kg</b>	<b>85</b>
<b>Stir for 15 minuts and then add slowly</b>		
<b>Demineralized water (Conductivity 25°C 20 µS/cm max )</b>	<b>Liters</b>	<b>138,1</b>
<b>Before applying the bath stir it for 24 h at 25°C</b>		

### APPLICATION DATA (\*)

<b>Voltage</b>		<b>100 - 300</b>
<b>Dipping time</b>	<b>sec</b>	<b>120 – 180</b>
<b>Film thickness</b>	<b>µm</b>	<b>15 - 28</b>
<b>Bath temperature</b>	<b>°C</b>	<b>24 – 28</b>
<b>Baking temperature</b>	<b>°C</b>	<b>170 - 180</b>
<b>Backing time</b>	<b>min</b>	<b>15 - 20</b>

### CHARACTERISTICS OF APPLIED PRODUCT (\*)

<b>Film thickness</b>	<b>µm</b>	<b>25 ± 2</b>
<b>Gloss 60°</b>	<b>UG</b>	<b>60 ÷ 80</b>
<b>Erichsen indentation test</b>	<b>µm</b>	<b>6 ÷ 8</b>
<b>Direct impact resistance (2 lbs x 100 cm) Ø = 1 inch</b>		<b>No cracking</b>
<b>Mandrel bending test (Ø = 6 mm)</b>		<b>No cracking</b>
<b>Salt spray resistance 100 h</b>	<b>ASTM B 117</b>	<b>&lt; 2 mm at the cross No Blistering</b>

\* Iron pretreated support

Lainate, March 11<sup>th</sup>, 2013