

AquaEC™ 6100

Description

Definition	2K Epoxy-based primer
Product Information	AquaEC 6100 Cathodic epoxy electrocoat that offers excellent mechanical properties, superior corrosion resistance, and enhanced edge protection.

Areas of Use

General Information	AquaEC 6100 is a universal e-coat for use across many applications in OEM, industrial and ACE markets.
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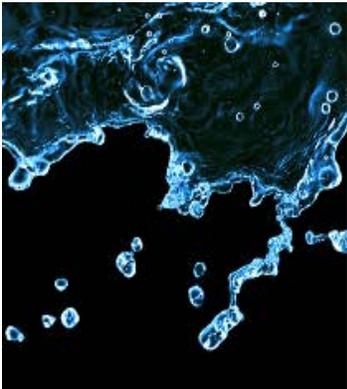
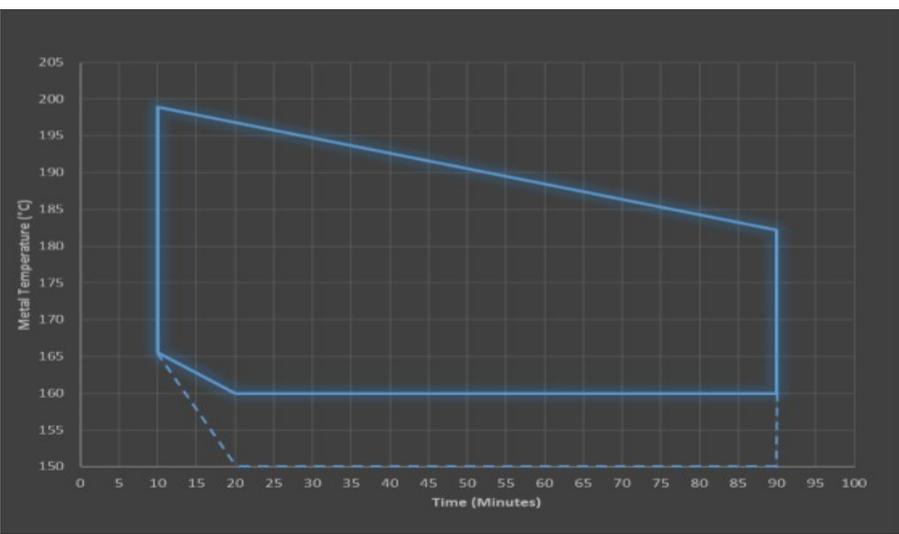
Material Characteristics

	Resin	Pigment Paste
Color	Milky, white	Black
Density	1.07 ± 0.03 g/cm ³	1.38 ± 0.03 g/cm ³
Solid content	38 ± 1 %	50 ± 1 %
Mix ratio	4.0 – 10.0	1.0
Flash point (DIN EN ISO 1523)	> 95 °C	> 95 °C
Storage stability	12 months (> 5 < 35 °C)	6 months (> 5 < 35 °C)

Application Data

Minimum Cure Conditions	10 min 165 °C object temperature
Recommended Cure Conditions	15 min 175 °C object temperature
VOC	< 0.55 lbs/gal (minus water)
HAPs	<0.01 lbs/gal
Efficiency	35 mg/Coulomb

Cure Window



HIGHLIGHTS

- Superior corrosion resistance
- Enhanced edge protection
- Robust operation window
- Low emissions - HAPS compliant
- Cationic lead free, tin free

Effective:
October 11, 2015



This information complies with the present state of our knowledge and is intended to provide information concerning our products and their possibilities for operation. In that capacity, then, it does not possess the significance of a legally enforceable assurance of specific characteristics of products or of their suitability for a specific application. Warning notices on product labels should be obeyed. Any legal rights should be taken into account. We contractually guarantee the condition of our products in the context of our general trading conditions nationally and for export.



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Bath Operating Conditions

Conductivity	1200 - 2000 $\mu\text{S}/\text{cm}$
pH	5.5 – 6.2
Solid content	18 - 22 %
Coating time	120 - 240 s
Deposition Voltage	160 - 350 V
Bath temperature	33 \pm 2°C

Film Properties

Coating Thickness	ASTM D7091	15 – 35 μm
Throwpower	FLTM BI120-02	>200 mm
Appearance	Profilometry	10 – 20 $\mu\text{inches Ra}$

Corrosion Resistance

Salt Spray test (1000 h)	ASTM B117	1 – 2 mm
Humidity test	ASTM D1735	1000 h min
20 Cycle Scab	GM9511P	1 – 2 mm
Edge Coverage	FLTM BI127-01	< 5 rust spots
Water Immersion	ASTM D870	250 h min

Please consult website or Axalta representative.

COMMERCIAL USES

- Agricultural and Construction equipment
- Automotive parts
- Heavy Duty equipment
- Computer components
- Wheels



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