

## Cataphoresis Treatment (Cationic Electro Deposition of Paint / Electro Coating)

The process of cataphoresis is a electro deposition of paint in immersion with current continuous electrical worker. The deposited film confers to the pieces ones elevated characteristic anticorrosive, extending in the time the conservation also of all the parts that are not available with a traditional system to spray (box-shielded, deep bendings, connections between sheets). This technology of vanguard comes used on all the Bodies of the automobiles and on elements of other fields which: industrial vehicles, motorcycles, you furnish, tractors and you blot some agricultural and where a complete and optimal antirust protection is demanded. FORESI joint-stock corporation operates with systems, consistent chemical and varnishing products to the European Directives of reference for the fields automotive, industrial vehicles and elettrical/elettronico equipment.

### **Description cycle Cataforesi treatment:** Advance chain to step

- ⇒ Pre-treatment to 7 spray a stages
  - 1° Degrease to warmth with alkaline products in water solution
  - 2° Degrease to warmth with alkaline products in water solution
  - 3° Washing with demineralized water and activation
  - 4° Phosphating to knows them of Zinco-Manganese-Nikel (tricationic/trimetallic)
  - 5° Washing with recycled demineralized water
  - 6° Washing with demineralized water
  - 7° Washing with demineralized water to the passage and dropping zone
- ⇒ Elettrodeposition , in immersion, with epoxy paint
  - N° 2 washing with ultrafiltrated
  - N° 2 washing with demineralized water
  - ⇒ Polymerization (baking in oven with forced air circulation 180-200°C)

**Painting type of materials:** Sheet and pieces of material conductor electrical worker: ferrous, ferrous - it galvanizes not passivated , aluminum and its alloys, branch, magnesium.

### **Physical characteristics chemical of the deposited film:** (test laboratory on champion bench)

In compliance at the standards 2000/53/CE e 2002/95/CE

Medium thickness 12 - 18 micron ( $\mu\text{m}$ ), advanced inferior or in function of the morphology of the piece.

Resistance to the salt fog test ISO 7253: 500 standards ore; ASTM Inferior or advanced B117:standard 500 hours to the 500 hours in function of the superficial characteristics of the piece one.

Direct and Inverse resistance to crash: (test method: NFT30-017) - 1KG/1 MT

Resistance to the U.V. in the case of I use like hand to end: Discreet (typical Pulverization of the epoxy products)

Hardness: Pencil (ASTM D 3363-92): beyond 5H

Adhesion: 98 -100 % to the grid (degree Or UNICHIM) (ISO 2409=G T Æ)

Resistance to acids, alkali, hydrocarbons and substances chemistries: Good

### **Cycles of paint job succeeded to you :**

- Epoxy Powders, to epossipolyester, polyester, polyuretanic, acrylic
- Enamels catalyze or to oven, made up of rendered of it alkyd, acrylic, melamminich polyesters