

AquaEC™ 4021

Description

Definition

2K cathodic epoxy electrocoat with outstanding corrosion resistance and mechanical properties

Product Information

AquaEC™ 4021 Cathodic Electrocoat is an all-purpose electrocoat for use in automotive OEM and industrial parts markets

Areas of Use

- **Agricultural and Construction**
- **Automobiles**
- **Heavy Duty Trucks**
- **Automotive Parts**

Application Data

Minimum Cure Temp*

18 min at 150 °C metal temperature

Recommended Cure Temp.

10 min at 175 °C metal temperature

VOC

RACT: 0.43 lbs/gal; NSPS: 0.46 lbs/gal

HAPs

< 0.02 lbs/gal

**Please consult with Axalta representative for specific applications*

Film Properties

| Property | Test Method | Result |
|---------------------|---------------|-----------------|
| Film Thickness | --- | 13 - 23 µm |
| Humidity Test | ASTM D1735 | 1000 h min |
| Salt Spray (1000 h) | ASTM B117 | 1 - 3 mm |
| 20 Cycle Scab | GM9511P | 1 - 3 mm |
| Edge Coverage | FLTM BI127-01 | < 40 rust spots |
| Water Immersion | ASTM D870 | 250 h min |
| Throwpower | FLTM BI120-02 | > 200 mm |

For a full list of approvals, please consult website or an Axalta representative.

HIGHLIGHTS

- ✓ Superior corrosion
- ✓ Wide bake window
- ✓ High coating efficiency
- ✓ Robust operation window
- ✓ Low VOC
- ✓ HAPS compliant
- ✓ Lead free

Effective: September 30th, 2014



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