

USER INSTRUCTIONS

CATAFOR 600

CATAFORETIC LACQUERS

Colour : **VARIOUS**

Use : **BATH**

Colour coordinates **N.D.**

Product description

CATAFOR[®] 600 is a cataphoretic coating process designed for those seeking performance, aesthetics, and reliability in a single solution.

The transparent water-based lacquer (CATAFOR[®] 600BS | 600CS) ensures advanced oxidation protection and is suitable for all metallic substrates. Thanks to its innovative formulation, it offers high resistance to wear, scratching, perspiration and aggressive agents, without compromising the transparency of the coating or causing yellowing over time. Ideal for both technical and decorative applications, it can be combined with a wide range of post-dye colorations through simple immersion, allowing for stable, controllable and fully customizable chromatic finishes. For a correct deposition it needs a specific ramp programmable rectifier. It is very important to use a ventilated oven for cooking the paint.

Operative Conditions for CATAFOR[®] 600BS | 600CS

Parameter	Average suggested value (1 - 5 L)	Note
Treatment time (TOTAL)	45 Sec	See application procedure
Temperature	28-30 °C	
Voltage	28 V	
Anodes	Inox Steel	
Agitation	Slow during rest	Off during treatment
Aspiration	Necessary	
Oven type	Hot air / ventilated	
Hardening temperature	120 °C- 160 °C	On Ag and Cu based alloys, don't exceed 135°C
Hardening time	20 - 40 min	Optimal: 135°C - 40 min

Notes:

- Shake the container well before pouring, making sure that there is no residue on the bottom of the bottle.
- Put the contents inside the bottle in case it is not used.
- Keep away from direct sources of heat and light.

Maintenance of plating bath

From statistical data we have observed that on average with 1 liter of product we can treat from 70 to 100 square decimetres of surface. Later, the solution is considered exhausted.

Safety Information

Please refer to the safety data sheets for any information regarding safety and disposal (MSDS).

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CATAFOR[®] 600 line – Application Procedure

1. Pre-Treatments

- **Galvanic pre-treatment standard sequence up to neutralization**, followed by **two rinses**: one with **running water** and one with **demineralized water**.
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2. Preparation Rinse

- **Product**: CATAFOR 600W
- **Concentration**: 2 mL/L
- **Time**: 15 seconds

Notes: Prepares the substrate for cathodic electrophoretic coating.

3. Cathodic Electrophoretic Coating

- **Product**: CATAFOR 600BS or CATAFOR 600CS (33% lacquer – 67% demineralized water)
- **Bath temperature**: 28–30 °C
- **Applied voltage**: 28–35 V with voltage ramp

Immersion sequence:

- 10 seconds **immersion without current**
 - 15 seconds with **ramped voltage application**
 - 20 seconds **at maximum voltage**
 - 10 seconds **immersion without current**
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4. Post-Coating Rinse (1)

Product: CATAFOR 600W

Concentration: 2 mL/L

Time: 15 seconds

5. Post-Coating Rinse (2)

Product: CATAFOR 600C

Concentration: 10 mL/L

Time: 15 seconds

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6. Post-Coloration (optional)

- Product: CATAFOR 600-01 or other coloration
 - Bath temperature: 25–30 °C
 - **Immersion time** (depending on desired effect):
 - 30 seconds for **transparent coloration**
 - 120 seconds for **full coverage coloration**
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7. Final Rinse (1)

- **Product:** CATAFOR 600C
 - **Concentration:** 10 mL/L
 - **Time:** 15 seconds
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8. Final Rinse (2)

- **Product:** CATAFOR 600W
 - **Concentration:** 2 mL/L
 - **Time:** 15 seconds
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9. Curing

- **Oven type:** Forced-air oven with controlled temperature
 - **Temperature:** 120–160 °C (do not exceed 160 °C)
 - **Time:** 20–40 minutes
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Correlated Products

Article Code	Description	Colour	Packaging
VE01006801	CATAFOR 600CS - 10L - Concentrated cataphoretic lacquer - colorless	Neutral	10 L
VE01008001	CATAFOR 600BS - 1L - Ready-to-use cataphoretic lacquer - colorless	Neutral	1 L
VE01006901	CATAFOR 600S - 1L - Solvent for cataphoretic lacquer	-	1 L
VE01007001	CATAFOR 600W - 100ML - Rinse aid for cataphoretic lacquer	-	100 mL
VE01008101	CATAFOR 600C - 100ML - Conditioning additive for pre and post coloration	-	100 mL
VE01007101	CATAFOR 600-01 - 1L - Post coloration - yellow	Yellow	1 L
VE01007201	CATAFOR 600-02 - 1L - Post coloration - red	Red	1 L
VE01007301	CATAFOR 600-03 - 1L - Post coloration - blue	Blue	1 L
VE01007401	CATAFOR 600-04 - 1L - Post coloration - gold	Gold	1 L
VE01007501	CATAFOR 600-05 - 1L - Post coloration - green	Green	1 L
VE01007601	CATAFOR 600-06 - 1L - Post coloration - black	Black	1 L
VE01007701	CATAFOR 600-07 - 1L - Post coloration - violet	Violet	1 L
VE01007801	CATAFOR 600-08 - 1L - Post coloration - orange	Orange	1 L
VE01007901	CATAFOR 600-09 - 1L - Post coloration - bronze	Bronze	1 L