

Title (en)  
Process for painting heatingbodies.

Title (de)  
Verfahren zur Lackierung von Heizkörpern.

Title (fr)  
Procédé de peinture de corps chauffants.

Publication  
**EP 0540996 B1 19950830 (DE)**

Application  
**EP 92118393 A 19921028**

Priority  
DE 4136237 A 19911102

Abstract (en)  
[origin: EP0540996A1] The process according to the invention relates to a process for painting radiators, in which A - 1 the radiators are immersed into a first aqueous electrodeposition bath which contains a cationic amine-modified epoxy resin and an aliphatic or cycloaliphatic, blocked polyisocyanate which is part of the amine-modified epoxy resin and/or is in the form of a separate component, and has a temperature of from 22 to 35 DEG C, a conductivity of at least 1000 mu S cm<-1> and a pH of at most 7.0, A - 2 the radiators are connected as the cathode, A - 3 a voltage of from 20 to 450 V is applied, A - 4 a paint film is deposited on the radiators within from 5 to 120 seconds by means of direct current, A - 5 the radiators are removed from the first electrodeposition bath, B the coating material which has not been deposited electrochemically is rinsed off, C the deposited paint film is dried until it has an electrical resistance of at least 5.10<10> OMEGA cm, D - 1 the radiators are again immersed into an aqueous electrodeposition bath as described under A - 1, D - 2 the radiators are connected as the cathode, the anode being selected so that the quotient of the area of the anode and the area of the radiators still to be painted is greater than 0.05, D - 3 a voltage of from 50 to 500 V is applied, D - 4 a paint film is deposited on the radiators within from 60 to 240 seconds by means of direct current, D - 5 the radiators are removed from the electrodeposition bath, E the coating material which has not been deposited electrochemically is rinsed off, and F the electrodeposition films applied in this way are baked (stoved).

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**C25D 13/22**; **C25D 13/12**

IPC 8 full level  
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