



CHING

Functional Coatings since 1927

Innovative Coatings for the Transformer and Radiator Industry

ching-coatings.com

Company Profile

Chemische Industrie Erlangen GmbH (CHING) has been family-owned since 1927 and is currently led by the third generation. We are a medium-sized company specializing in the development and distribution of coatings for corrosion protection and industrial coatings. For decades, we have been an approved supplier to numerous national and international clients, including RWE, E.ON, TenneT, Siemens Energy, Hitachi Energy, ALSTOM, BASF, Toshiba, GE, and many more.



In recent years, we have prioritized the development of low-emission and environmentally friendly coatings that meet high standards in corrosion protection while addressing increased demands for sustainability, cost-effectiveness, and aesthetics. Working closely with our industry partners, we have successfully created economic and high-quality technical solutions for nearly all challenges in corrosion protection and industrial coating.

We continually strive to collaborate with our customers to address current challenges in corrosion protection and to creatively and innovatively meet the requirements and wishes for new corrosion protection systems. Being there for our customers is our top priority.

Transformers & Radiators

At CHING, we proudly reflect on many years of experience in the field of coating materials for transformers and their supplier industry. Our journey began in the 1960s, when we first developed coating systems in collaboration with renowned transformer manufacturers, continually evolving to meet growing demands. We take particular pride in being the first coating manufacturer worldwide to introduce water-based coating systems to the energy market in the mid-1980s, demonstrating our commitment to environmental responsibility and human safety.

Over the past 60 years, we have successfully advanced our coating systems, resulting in an extensive portfolio that meets nearly all the needs of the transformer industry. Throughout this period, we have developed innovative system solutions in close partnership with our customers.



Coating Systems Overview



2C Medium Solid Systems

EMD/EMC primer or intermediate coat & ADD top coat

- Solvent based System
- 2-component system with duroplastic properties
- EMC/EMD primer or intermediate coat based on epoxy chemistry crosslinked with amine-based hardener
- ADD top coats are based on polyurethane chemistry crosslinked with isocyanate-based hardener
- Relatively long pot life
- Moderately long drying time
- Good price-performance ratio
- Wide application window

Products

Name	Description ^a
EMD 186	2C EP active primer for steel and aluminum
EMC 182-HS	2C EP active primer for steel, stainless steel, zinc and aluminum
EMC 182 K-DB	2C EP active primer for tank inside & outside ^b for steel, aluminium and zinc (sweep blasted) ^b
EMD 152	2C EP zinc dust primer, Zn (R)
EMD 156	2C EP zinc dust primer, economical
EMD 155	2C EP zinc flake primer, reduced zinc content
EMD 30	2C EP iron mica intermediate coat
ADD 43 / 47	2C PUR top coat

^a Technical data sheets available on request

^b Certificates for oil resistance available on request



2C High Solid Systems

ESD primer or intermediate coat & ASD top coat

- Solvent-based system with low VOC
- 2-component system with duroplastic properties
- ESD primer or intermediate coat based on epoxy chemistry crosslinked with amine-based hardener
- ASD top coats are based on polyurethane chemistry crosslinked with isocyanate-based hardener
- Short pot life (2-component spraying equipment recommended)
- Short drying time promotes increase in efficiency in paint shop
- Good price-performance ratio
- High yield

Products

Name	Description ^a
ESD 182 K-DB	2C EP-HS active primer for tank inside and outside for steel, aluminium and zinc (sweep blasted) ^b
ESD 152	2C EP-HS zinc dust primer, Zn (R)
ESD 156	2C EP-HS zinc dust primer, economical
ESD 155	2C EP-HS zinc flake primer, reduced zinc content
ESD 30	2C EP-HS iron mica intermediate coat
ASD 43 / 47	2C PUR-HS top coat

^a Technical data sheets available on request

^b Certificates for oil resistance available on request



2C Water-Based Systems

HEM primer or intermediate coat & HAD top coat

- Water-based system with very low VOC
- 2-component system with duroplastic properties
- HEM primer or intermediate coat based on epoxy chemistry crosslinked with amine-based hardener
- HAD top coats are based on polyurethane chemistry crosslinked with isocyanate-based hardener
- ⚠ Special pot-life properties: End of pot-life is not recognizable – **additional information must be considered**
- Relatively short drying time
- System requires special approach regarding layer thicknesses and drying conditions
- Material must be protected against frost

Products

Name	Description ^a
HEM 182	2C EP HYDRO active primer for steel, aluminium and zinc (sweep blasted)
HEM 182 K-DB	2C EP HYDRO active primer for tank inside and outside for steel, aluminium and zinc (sweep blasted) ^b
HEM 152	2C EP-HYDRO zinc dust primer, Zn (R)
HEM 33	2C EP HYDRO mica intermediate coat
HAD 43 / 47	2C PUR HYDRO top coat

^a Technical data sheets available on request

^b Certificates for oil resistance available on request



1C Water-Based Systems

HV primer, intermediate coat or top coat

- Water-based system with very low VOC
- 1-component system with thermoplastic properties – very flexible & high impact and abrasion resistance
- HV primer, intermediate coat, top coat or single-layer system (DTM) based on same acrylic-dispersion-binder chemistry (same chemistry, very good compatibility)
- No pot life – generates less waste
- Temperature resistant from -50 °C to 120 °C
- Excellent adhesion on steel, galvanized steel, non-ferrous metals and pre-existing coatings
- Very short drying time, but large air exchange required!
- Material must be protected against frost

Products

Name	Description ^a
HV 186	1C AY HYDRO active primer for steel, stainless steel, zinc and aluminum
HV 33	1C AY HYDRO mica intermediate coat
HV 43 / 47	1C AY HYDRO top coat
HV 08	1C AY HYDRO single-layer system (DTM) for steel, stainless steel, zinc and aluminum
HV 286 EPD	1C AY HYDRO primer for EPD and powder coating

^a Technical data sheets available on request



2C High Solid Epoxy Systems

ESD 182 RAL 7016 coat for dry transformer

- Solvent-based system with low VOC
- 2-component system with duroplastic properties
- ESD coat based on epoxy chemistry crosslinked with amine-based hardener
- Short pot life (2-component spraying equipment recommended)
- Short drying time promotes increase in efficiency in paint shop
- Good price-performance ratio
- High yield
- Excellent adhesion on steel core sheets
- Thickness of 120 - 160 µm in one run possible
- Temperature resistance up to 180 °C

Products

Name	Description ^a
ESD 182 RAL 7016	2C EP-HS active primer for core sheets, steel, aluminium and zinc (sweep blasted) ^b

^a Technical data sheets available on request

^b Certificates for oil resistance available on request



2C Epoxy System (acc. Blatt 3 & Blatt 40)

Special product line for locomotive transformer

- Two-layer epoxy system in accordance with the German Railway standard DBS 918300, Blatt 3 & Blatt 40
- 2-component system with duroplastic properties
- Primer based on epoxy chemistry crosslinked with amine-based hardener (product code: 603.01)
- Top coat based on epoxy chemistry crosslinked with amine-based hardener (product code: 640.01)
- Moderate pot life
- High yield
- Excellent adhesion on steel (primer)
- Thickness of the primer 60 - 80 µm
- Thickness of the top coat 140 - 160 µm
- Certificate of oil immersion test available
- Fire protection certificate acc. EN 45545 available
- Test report acc. DBS 918300, Blatt 3 available
- Test report acc. DBS 918300, Blatt 40 available

Products

Name	Description ^a
603.01	2C EP active primer for rail vehicles acc. DBS 918300, app. B - Blatt 3, good adhesion on metal substrate, available colour: RAL 3012
640.01	2C EP elastified top coat for rail vehicles acc. 918300, app. B - Blatt 40, available colours: RAL 7012, RAL 9005, other colours on request

^a Technical data sheets available on request



1C Low Solid PVB Primer

RD 124 primer for radiator inside

- Solvent based System
- 1-component system based on polyvinyl butyral- chemistry with thermoplastic properties
- RD 124 is a physical drying primer for steel radiator inside coating
- Function: Fixation of metal particles so that they cannot enter the oil circuit
- No pot life
- Excellent oil resistance to most common radiator/transformer oils
- Good price-performance ratio
- Wide application window

Products

Name	Description ^a
RD 124 R	1C solvent based primer, based on PVB chemistry for steel radiator inside coating

^a Technical data sheets available on request



General System Properties Comparison

The comparison table below provides you with a short overview of the various products we offer. By evaluating essential criteria such as drying time, application window, and VOC, you can quickly and easily identify the product that best suits your needs. Use this guide to make informed decisions and find the optimal solution for your requirements.

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Drying time	●	● ● ● ●	● ● ●	● ● ●
Yield	● ●	● ● ● ●	● ●	● ●
Efficiency	● ●	● ● ● ●	● ●	● ● ●
Application window	● ● ● ●	● ● ●	● ●	● ●
Handling	● ● ● ●	● ● ●	●	● ● ●
VOC	●	● ● ●	● ● ● ●	● ● ●
Pot life	● ● ●	● ●	● ●	● ● ● ●
UV resistance (top coat)	● ● ●	● ● ● ●	● ● ● ●	● ●
Chemical resistance	● ● ●	● ● ● ●	● ●	●
Oil resistance (primer)	● ● ● ●	● ● ● ●	● ● ● ●	●
Film flexibility	● ●	● ●	● ● ●	● ● ● ●

● Sufficient ● ● Good ● ● ● Very Good ● ● ● ● Excellent



Coating Systems & Climate Classes



Steel

Corrosivity category (protection period) - C3 (H) $\approx$ C4 (M) $\approx$ C5 (L)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182/K-DB (60 μ m)	ESD 182/K-DB (60 μ m)	HEM 182/K-DB (70 μ m)	HV 186/08 (70 μ m)
Intermed. coat	EMD 182/K-DB/30 (60 μ m)	ESD 182/K-DB/30 (60 μ m)	HEM 182/K-DB/33 (70 μ m)	HV 186/08 (70 μ m)
Top coat	ADD 43/47 (60 μ m)	ASD 43/47 (60 μ m)	HAD 43/47 (40 μ m)	HV 43/47/08 (60 μ m)
Total dft ^c	180 μ m	180 μ m	180 μ m	200 μ m
Drying time	35 h ^d / 5 h ^e	13h ^d / 3 h ^e	11 h ^d / 3 h ^e	11 h ^d / 4 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	520 $\pm$ 20 g/m ²	400 $\pm$ 20 g/m ²	530 $\pm$ 20 g/m ²	590 $\pm$ 20 g/m ²
VOC content ^g	135 $\pm$ 10 g/m ²	65 $\pm$ 10 g/m ²	45 $\pm$ 10 g/m ²	45 $\pm$ 10 g/m ²
Test report	PB300/058/11	PB300/197/22	PB300/223/24	PB300/224/24

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Steel

Corrosivity category (protection period) - C3 (VH) $\approx$ C4 (H) $\approx$ C5 (M)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182/K-DB (80 μ m)	ESD 182/K-DB (80 μ m)	HEM 182/K-DB (80 μ m)	HV 186/08 (80 μ m)
Intermed. coat	EMD 182/K-DB/30 (80 μ m)	ESD 182/K-DB/30 (80 μ m)	HEM 182/K-DB/33 (120 μ m)	HV 186/08 (100 μ m)
Top coat	ADD 43/47 (80 μ m)	ASD 43/47 (80 μ m)	HAD 43/47 (40 μ m)	HV 43/47/08 (80 μ m)
Total dft ^c	240 μ m	240 μ m	240 μ m	260 μ m
Drying time	40 h ^d / 6 h ^e	16 h ^d / 4 h ^e	14 h ^d / 5 h ^e	14 h ^d / 6 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	700 $\pm$ 20 g/m ²	530 $\pm$ 20 g/m ²	710 $\pm$ 20 g/m ²	750 $\pm$ 20 g/m ²
VOC content ^g	180 $\pm$ 10 g/m ²	90 $\pm$ 10 g/m ²	60 $\pm$ 10 g/m ²	60 $\pm$ 10 g/m ²
Test report	PB300/282/19	PB300/319/23	PB300/316/23	PB300/225/24

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Steel

Corrosivity category (protection period) - C4 (VH) $\approx$ C5 (H)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMD 156 (80 μ m)	ESD 152 (80 μ m)	HEM 152 (80 μ m)	HEM 152 (80 μ m)
Intermed. coat	EMD 182/K-DB/30 (100 μ m)	ESD 182/K-DB/30 (100 μ m)	HEM 182/K-DB/33 (140 μ m)	HV 186/08 (100 μ m)
Top coat	ADD 43/47 (80 μ m)	ASD 43/47 (80 μ m)	HAD 43/47 (40 μ m)	HV 43/47/08 (80 μ m)
Total dft ^c	260 μ m	260 μ m	260 μ m	260 μ m
Drying time	40 h ^d / 6 h ^e	16 h ^d / 4 h ^e	14 h ^{*d} / 5 h ^e	34 h ^d / 8 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	840 $\pm$ 20 g/m ²	760 $\pm$ 20 g/m ²	900 $\pm$ 20 g/m ²	880 $\pm$ 20 g/m ²
VOC content ^g	200 $\pm$ 10 g/m ²	130 $\pm$ 10 g/m ²	85 $\pm$ 10 g/m ²	80 $\pm$ 10 g/m ²
Test report	PB300/059/11	PB300/226/24	PB300/317/23_1	--

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Steel

Corrosivity category (protection period) - C5 (VH)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMD 156 (80 µm)	ESD 152 (80 µm)	HEM 152 (80 µm)	HEM 152 (80 µm)
Intermed. coat	EMD 182/K-DB/30 (160 µm)	ESD 182/K-DB/30 (160 µm)	HEM 182/K-DB/33 (200 µm)	HV 186/08 (160 µm)
Top coat	ADD 43/47 (80 µm)	ASD 43/47 (80 µm)	HAD 43/47 (40 µm)	HV 43/47/08 (80 µm)
Total dft ^c	320 µm	320 µm	320 µm	320 µm
Drying time	45 h ^d / 7 h ^e	18 h ^d / 5 h ^e	20 h ^d / 6 h ^e	38 h ^d / 10 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	1030 ± 20 g/m ²	890 ± 20 g/m ²	1080 ± 20 g/m ²	1070 ± 20 g/m ²
VOC content ^g	250 ± 10 g/m ²	155 ± 10 g/m ²	100 ± 10 g/m ²	100 ± 10 g/m ²
Test report	PB300/321/19	PB300/235/19_1	--	--

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Steel

Corrosivity category (protection period) - CX

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMD 156 (80 µm)	ESD 152 (80 µm)	HEM 152 (80 µm)	HEM 152 (80 µm)
Intermed. coat	EMD 182/K-DB/30 (120 µm)	ESD 182/K-DB/30 (120 µm)	HEM 182/K-DB/33 (160 µm)	HV 186/08 (120 µm)
Top coat	ADD 43/47 (80 µm)	ASD 43/47 (80 µm)	HAD 43/47 (40 µm)	HV 43/47/08 (80 µm)
Total dft ^c	280 µm	280 µm	280 µm	280 µm
Drying time	42 h ^d / 6 h ^e	18 h ^d / 4 h ^e	16 h ^d / 5 h ^e	36 h ^d / 8 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	900 ± 20 g/m ²	800 ± 20 g/m ²	960 ± 20 g/m ²	950 ± 20 g/m ²
VOC content ^g	210 ± 10 g/m ²	140 ± 10 g/m ²	90 ± 10 g/m ²	85 ± 10 g/m ²
Test report	PB300/183/12	PB300/069/17	--	--

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Zinc

Corrosivity category (protection period) - C3 (H) ≈ C4 (M) ≈ C5 (L)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182-HS (60 µm)	EMC 182-HS (60 µm)	EMC 182-HS (80 µm)	HV 186/08 (80 µm)
Intermed. coat	--	--	--	--
Top coat	ADD 43/47 (60 µm)	ASD 43/47 (60 µm)	HAD 43/47 (40 µm)	HV 43/47/08 (80 µm)
Total dft ^c	120 µm	120 µm	120 µm	160 µm
Drying time	24 h ^d / 3 h ^e	12 h ^d / 2 h ^e	12 h ^d / 3 h ^e	8 h ^d / 3 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	340 ± 20 g/m ²	330 ± 20 g/m ²	380 ± 20 g/m ²	460 ± 20 g/m ²
VOC content ^g	80 ± 10 g/m ²	70 ± 10 g/m ²	70 ± 10 g/m ²	30 ± 10 g/m ²
Test report	--	PB300/090/25	--	PB300/088/25

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Zinc

Corrosivity category (protection period) - C3 (VH) $\approx$ C4 (H) $\approx$ C5 (M)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182-HS (80 μ m)	EMC 182-HS (80 μ m)	EMC 182-HS (60 μ m)	HV 186/08 (70 μ m)
Intermed. coat	--	--	HEM 182/K-DB/33 (60 μ m)	HV 186/08 (70 μ m)
Top coat	ADD 43/47 (80 μ m)	ASD 43/47 (80 μ m)	HAD 43/47 (40 μ m)	HV 43/47/08 (60 μ m)
Total dft ^c	160 μ m	160 μ m	160 μ m	200 μ m
Drying time	30 h ^d / 4 h ^e	16 h ^d / 3 h ^e	16 h ^d / 4 h ^e	11 h ^d / 4 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	450 $\pm$ 20 g/m ²	430 $\pm$ 20 g/m ²	490 $\pm$ 20 g/m ²	590 $\pm$ 20 g/m ²
VOC content ^g	105 $\pm$ 10 g/m ²	90 $\pm$ 10 g/m ²	70 $\pm$ 10 g/m ²	45 $\pm$ 10 g/m ²
Test report	--	PB300/106/25	--	PB300/104/25

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Zinc

Corrosivity category (protection period) - C4 (VH) $\approx$ C5 (H)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182-HS (60 μ m)	EMC 182-HS (60 μ m)	EMC 182-HS (60 μ m)	EMC 182-HS (60 μ m)
Intermed. coat	EMD 182/K-DB/30 (80 μ m)	ESD 182/K-DB/30 (80 μ m)	HEM 182/K-DB/33 (100 μ m)	HV 186/08 (80 μ m)
Top coat	ADD 43/47 (60 μ m)	ASD 43/47 (60 μ m)	HAD 43/47 (40 μ m)	HV 43/47/08 (60 μ m)
Total dft ^c	200 μ m	200 μ m	200 μ m	200 μ m
Drying time	32 h ^d / 5 h ^e	18 h ^d / 4 h ^e	18 h ^d / 5 h ^e	14 h ^d / 5 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	580 $\pm$ 20 g/m ²	500 $\pm$ 20 g/m ²	600 $\pm$ 20 g/m ²	610 $\pm$ 20 g/m ²
VOC content ^g	145 $\pm$ 10 g/m ²	95 $\pm$ 10 g/m ²	80 $\pm$ 10 g/m ²	70 $\pm$ 10 g/m ²
Test report	--	PB300/118/25	PB300/123/23	PB300/117/25

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

Zinc

Corrosivity category (protection period) - C5 (VH)

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182-HS (80 µm)	EMC 182-HS (80 µm)	EMC 182-HS (80 µm)	EMC 182-HS (80 µm)
Intermed. coat	EMD 182/K-DB/30 (80 µm)	ESD 182/K-DB/30 (80 µm)	HEM 182/K-DB/33 (120 µm)	HV 186/08 (80 µm)
Top coat	ADD 43/47 (80 µm)	ASD 43/47 (80 µm)	HAD 43/47 (40 µm)	HV 43/47/08 (80 µm)
Total dft ^c	240 µm	240 µm	240 µm	240 µm
Drying time	38 h ^d / 6 h ^e	20 h ^d / 5 h ^e	22 h ^d / 6 h ^e	18 h ^d / 6 h ^e
Pot life NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	700 ± 20 g/m ²	610 ± 20 g/m ²	730 ± 20 g/m ²	710 ± 20 g/m ²
VOC content ^g	175 ± 10 g/m ²	120 ± 10 g/m ²	100 ± 10 g/m ²	90 ± 10 g/m ²
Test report	--	coming soon	--	coming soon

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Normative specified layer thickness

Zinc

Corrosivity category (protection period) - CX

	2C Medium Solid	2C High Solid	2C Water-Based	1C Water-Based
Primer	EMC 182-HS (60 µm)	EMC 182-HS (60 µm)	EMC 182-HS (60 µm)	EMC 182-HS (60 µm)
Intermed. coat	EMD 182/K-DB/30 (80 µm)	ESD 182/K-DB/30 (80 µm)	HEM 182/K-DB/33 (100 µm)	HV 186/08 (80 µm)
Top coat	ADD 43/47 (60 µm)	ASD 43/47 (60 µm)	HAD 43/47 (40 µm)	HV 43/47/08 (60 µm)
Total dft ^c	200 µm	200 µm	200 µm	200 µm
Drying time	32 h ^d / 5 h ^e	18 h ^d / 4 h ^e	18 h ^d / 5 h ^e	14 h ^d / 5 h ^e
Potlife NC 23/50	approx. 4-6 h	approx. 2-3 h	approx. 3-4 h	--
Consumption ^f	580 ± 20 g/m ²	500 ± 20 g/m ²	600 ± 20 g/m ²	610 ± 20 g/m ²
VOC content ^g	145 ± 10 g/m ²	95 ± 10 g/m ²	80 ± 10 g/m ²	70 ± 10 g/m ²
Test report	PB300/244/14	coming soon	--	coming soon

^c Normative specified layer thickness

^d At room temperature

^e Forced drying at 60°C

^f W/o loss for total film build up

^g Theoretical value for total film build up

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