



## WO1801D FREIOTHERM-Hydro-Coating

### Product description

<b>Product technology</b>	water-thinnable single-layer coating
<b>Application area</b>	e.g. in the mechanical engineering and plant construction sector
<b>Bending strength</b>	good
<b>Substrate</b>	Aluminium

### General product properties

<b>Binder-Base</b>	Combination of polyester/amino resin		
<b>Colour</b>	All common colour shades		
<b>Gloss value</b>	satın mat	40-50 GU, angle 60°	DIN EN ISO 2813
<b>Viscosity</b>	Flow time 50-60 sec. 4 mm flow cup		DIN 53211
<b>pH-Value</b>	8,5-9,0		DIN 19260
<b>Density</b>	1,000-1,150 g/cm³		theoretical
<b>Solid mass</b>	48-50 %		theoretical
<b>Solid content in volume</b>	34-35 %		theoretical
<b>Reference product</b>	The values given refer to the product with the shade WO1801D.		
<b>Resistance to storage</b>	<p>approx. 12 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. Open packages are to be used within a short time.</p> <p>The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.</p>		

### Application and processing

Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.		
Structure recommendation	Substrate	Aluminium	
	Top coat	WO1801D Dry film thickness < 30 µm	
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.		
Thinning	demineralised water		
Dry film thickness	must not exceed 30 µm – risk of reaction bubbles.		
Object temperature	10-30 °C, minimum +3 °C above dew point temperature		



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Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %	
High pressure spraying	as delivered viscosity nozzle 1,5 mm spray pressure 2-3 bar	
Pouring	45-55 sec. / 4 mm flow cup (DIN 53211)	
Electrostatic	possible, system-specific	
Material usage	without application loss 70-102 g/m² layer thickness 20-30 µm	theoretical
Oven drying	8 min. / 180 °C - 15 min. / 160 °C (object temperature)	
Cleaning of equipment	with EFD cleaning agent 400109 within the processing time.	
Further processing of coated pieces		
Repainting	possible based on pre-test	
Comments		
EFD info	Further technical information can be found in the EFD Info. No. 111.	
Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.	
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.  The information provided here contains reference values and does not constitute a specification.	