



WO1821V

FREIOTHERM-Hydro-Metallic

Product description

Product technology	water-thinnable baking coating	
Application area	e.g. in the construction and sanitary sector	
Surface finish	Metallic effect	
Drying	quickly	
Blocking resistance	good	
Substrate	Steel, Aluminium, Primer	

General product properties

Binder-Base	Combination of acrylate/polyester/amino resin	
Colour	Metallic colour shades	
Gloss visually	matt	
Viscosity	Flow time 23-27 sec. 4 mm flow cup	DIN 53211
pH-Value	7,9-8,1	DIN 19260
Solid mass	15-18 %	theoretical
Solid content in volume	13-15 %	theoretical
Reference product	The values given refer to the product with the shade WO1821VS737.	
Resistance to storage	<p>approx. 6 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	WO1821VS2737 Dry film thickness 30 µm



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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 80 µm – risk of reaction bubbles.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	
Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %	
High pressure spraying	23-27 sec. / 4 mm Flow cup Nozzle 1,2 mm Injection pressure 4 bar	DIN 53211
Material usage	without application loss 200-220 g/m ² layer thickness 30 µm	theoretical
Note on curing	Coloured area = stoving conditions with good end properties The displayed baking conditions are based on results from laboratory tests and therefore merely serve as a guideline when configuring the processing company's coating systems. The processing company is responsible for ensuring that the coating is fully cured. The complete curing of the coating must be checked by means of additional analytical and resistance tests using representative original parts under production conditions. Please do not hesitate to contact us if you require consultation.	
Oven drying	10 min. / 170 °C - 20 min. / 150 °C (object temperature)	
Cleaning of equipment	immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916, dried-on equipment with org. solvents, e.g. EFD thinner 400424.	

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.
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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.



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Test conditions

All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge and 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.