



## WO1820M

### 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>Over-coating capability</b>	possible with powder coatings		
<b>Substrate</b>	Steel, Aluminium		

#### General product properties

<b>Binder-Base</b>	Combination of polyester/amino resin		
<b>Colour</b>	All common colour shades		
<b>Gloss value</b>	mat	20-50 GU, angle 85°	DIN EN ISO 2813
<b>Viscosity</b>	Flow time 50-60 sec. 4 mm flow cup		DIN 53211
<b>pH-Value</b>	8,7-8,9		DIN 19260
<b>Solid mass</b>	38-45 %		theoretical
<b>Solid content in volume</b>	31-32 %		theoretical
<b>Reference product</b>	The values given refer to the product with the shade WO1820MND008.		
<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

<b>Pretreatment</b>	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.		
<b>Structure recommendation</b>	Substrate	On iron-phosphated steel plate	
	Top coat	WO1820MND008 Dry film thickness 30 µm	
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.		



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#### Thinning

demineralised water

#### Dry film thickness

must not exceed 40 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 %

#### ESTA high rotation

as delivered viscosity

#### Material usage

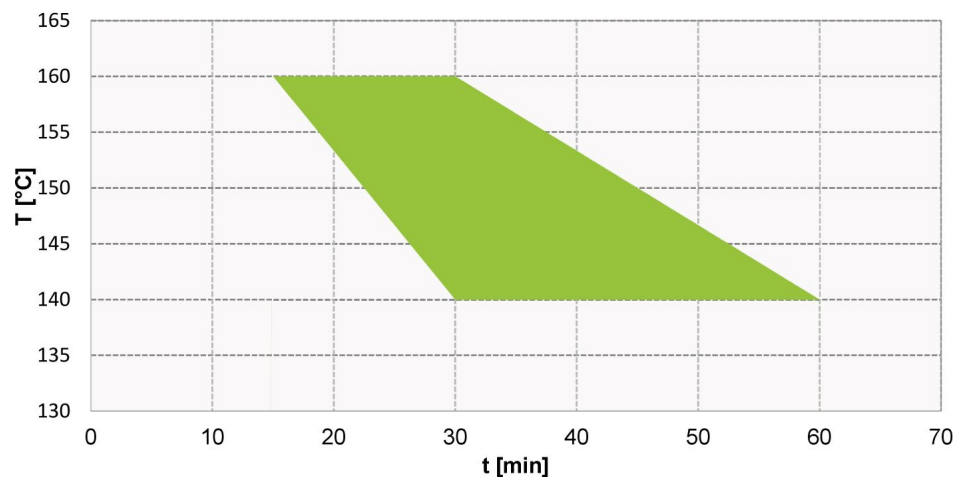
without application loss 345-380 g/m<sup>2</sup>

theoretical

layer thickness 80 µm

#### Curing

Recommended object temperature 15 min/160 °C



Objekt Temperatur in °C Object Temperature in °C	<b>140</b>	<b>160</b>
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Haltezeit Minimum in Minuten Holding time minimum in minutes	<b>30</b>	<b>15</b>
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Haltezeit Maximum in Minuten Holding time maximum in minutes	<b>60</b>	<b>30</b>
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#### 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

30 min. / 140 °C - 15 min. / 160 °C (object temperature)



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#### 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.

#### 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 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.