



## WO1839V

### 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>Bending strength</b>	good
<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	30-50 GU, angle 85°	DIN EN ISO 2813
<b>Viscosity</b>	Flow time 42-45 sec. 4 mm flow cup		DIN 53211
<b>pH-Value</b>	8,5-9,0		DIN 19260
<b>Solid mass</b>	45-50 %		theoretical
<b>Solid content in volume</b>	34-35 %		theoretical
<b>Reference product</b>	The values given refer to the product with the shade WO1839VS1501.		
<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	WO1839VS1501 Dry film thickness 30 µm	



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<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.	
<b>Thinning</b>	demineralised water	
<b>Dry film thickness</b>	must not exceed 40 µm – risk of reaction bubbles.	
<b>Object temperature</b>	10-30 °C, minimum +3 °C above dew point temperature	
<b>Processing conditions</b>	Room temperature 18-22 °C Relative humidity 40-60 %	
<b>High pressure spraying</b>	as delivered viscosity nozzle 1,5 mm spray pressure 3-4 bar	
<b>Pouring</b>	42-45 sec. / 4 mm flow cup (DIN 53211)	
<b>Electrostatic</b>	possible, system-specific	
<b>Material usage</b>	without application loss 325-340 g/m <sup>2</sup> layer thickness 80 µm	theoretical
<b>Oven drying</b>	30 min. / 140 °C - 15 min. / 160 °C (object temperature)	
<b>Cleaning of equipment</b>	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

<b>Repainting</b>	possible based on pre-test
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#### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 111.
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	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.