WT4108GRA916
FREIOTHERM-LC-DipTec

Product description

Product technology	water-thinnable baking coating
Application area	e.g. in the mechanical engineering and plant construction sector
Mechanical resistance	good
Condensed water resistance	good
Substrate	Steel

General product properties

Binder-Base	Polyester resin modified		
Viscosity	Flow time 30-40 sec., 4 mm flow cup		DIN 53211
pH-Value	8,7-9,0		DIN 19260
Density	1,25-1,4 g/ml		theoretical
Solid mass	50-55 %		theoretical
Solid content in volume	240-260 ml/kg		theoretical
Resistance to storage	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. 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.		

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.		
Gloss value	glossy	60-70 GU, Angle 60°	DIN EN ISO 2813
Structure recommendation	Substrate	On iron-phosphated steel plate	
	Top coat	WT4108GRA916 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 40 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 18-25 °C Relative humidity 40-60 %	
Material usage	without application loss 120-150 g/m² layer thickness 40 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	15 min. / 140 °C - 10 min. / 150 °C (object temperature)	
Cleaning of equipment	cleaning immediately with water, dried-on equipment with org. solvents, e.g. EFD cleaner.	

Mechanical tests

Cross-cut-test	Gt 0	DIN EN ISO 2409

Chemical resistance

Influencing factors	The chemical resistance depends on the concentration, temperature, exposure time and test method. This has to be checked depending on the application.

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.

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