



WO1864L

FREIOTHERM-Hydro-Coating

Product description

Product technology	water-thinnable baking coating
Application area	e.g. in the mechanical engineering and plant construction sector
Over-coating capability	possible with powder coatings
Substrate	Steel

General product properties

Binder-Base	Combination of polyester/amino resin		
Colour	All common colour shades		
Gloss value	satin mat	30-50 GU, angle 60°	DIN EN ISO 2813
Viscosity	Flow time 50-65 sec. 4 mm flow cup		DIN 53211
pH-Value	8,7-8,9		DIN 19260
Density	1,10-1,25 g/ml		theoretical
Solid mass	37-46 %		theoretical
Solid content in volume	29-34 %		theoretical
Reference product	The values given refer to the product with the shade WO1864LRU905.		
Resistance to storage	<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	On iron-phosphated steel plate	
	Top coat	WO1864LRU905	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 35 µm – risk of reaction bubbles.		
Object temperature	10-30 °C, minimum +3 °C above dew point temperature		

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms of business, delivery and payment.

DIN EN ISO 9001 | IATF 16949 | EMAS

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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 3-4 bar
Electrostatic	possible, system-specific
Material usage	without application loss 160-180 g/m ² theoretical layer thickness 40 µm
Oven drying	20 min. / 140 °C - 10 min. / 170 °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 based on pre-test
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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.
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.