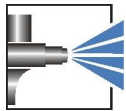


FREIOTHERM-Hydro-Basecoat

WO1871HOE02A

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the automotive sector ■ Good stone chip resistance ■ Can be coated over with powder coatings 																						
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of acrylate/polyester/amino resin</td> </tr> <tr> <td>■ Colour</td> <td>All common colour shades</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>satın glossy</td> </tr> <tr> <td>■ Viscosity <small>DIN 53211 (formerly)</small></td> <td>Flow time 18-20 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,0-8,4</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,00-1,04 g/ml</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>12-14 %</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>90-110 ml/kg</td> </tr> <tr> <td>■ Material usage <small>theoretical, without application loss</small></td> <td>190-210 g/m², Layer thickness 20 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1871</td> </tr> </table>	■ Binder-Base	Combination of acrylate/polyester/amino resin	■ Colour	All common colour shades	■ Gloss value <small>visual</small>	satın glossy	■ Viscosity <small>DIN 53211 (formerly)</small>	Flow time 18-20 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,0-8,4	■ Density <small>calculated</small>	1,00-1,04 g/ml	■ Solid Mass <small>calculated</small>	12-14 %	■ Solid content in volume <small>calculated</small>	90-110 ml/kg	■ Material usage <small>theoretical, without application loss</small>	190-210 g/m ² , Layer thickness 20 µm	■ Reference colour of the specified values	Colour of WO1871
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■ Reference colour of the specified values	Colour of WO1871																						
Substrate	<ul style="list-style-type: none"> ■ Light alloy wheels 																						
Pretreatment	<ul style="list-style-type: none"> ■ The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. Chromating or corresponding chrome-free conversion coatings. 																						
Structure recommendation	<table border="1"> <tr> <td>■ Substrate</td> <td>on light alloy wheels</td> </tr> <tr> <td>■ Primer</td> <td>PB6205B Dry film thickness 90 µm</td> </tr> <tr> <td>■ Base coat</td> <td>WO1871H Dry film thickness 20 µm</td> </tr> <tr> <td>■ Clear coat</td> <td>PY1005BRA999 Dry film thickness 90 µm</td> </tr> </table>	■ Substrate	on light alloy wheels	■ Primer	PB6205B Dry film thickness 90 µm	■ Base coat	WO1871H Dry film thickness 20 µm	■ Clear coat	PY1005BRA999 Dry film thickness 90 µm														
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Resistance Test	<table border="1"> <tr> <td>■ Condensate constant climate <small>DIN EN ISO 6270-2 (CH)</small></td> <td>240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2</td> </tr> </table>	■ Condensate constant climate <small>DIN EN ISO 6270-2 (CH)</small>	240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2																				
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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 and delivery.



FREIOTHERM-Hydro-Basecoat

WO1871HOE02A

	<ul style="list-style-type: none"> ■ Salt spray test (CASS) DIN EN ISO 9227 	240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8
Processing and application	<ul style="list-style-type: none"> ■ Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water. 	
	<ul style="list-style-type: none"> ■ Object temperature 	50 °C
	<ul style="list-style-type: none"> ■ Processing conditions 	Room temperature 15-25 °C Relative humidity 50-70 %
	<ul style="list-style-type: none"> ■ Electrostatic 	possible, system-specific
	<ul style="list-style-type: none"> ■ ESTA high rotation 	as delivered viscosity
	<ul style="list-style-type: none"> ■ 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.
	<ul style="list-style-type: none"> ■ Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet. 	
Curing	<ul style="list-style-type: none"> ■ Oven drying 	10 min./ 180 °C - 20 min./ 170 °C
	<ul style="list-style-type: none"> ■ Object temperature Baking window on request 	
Resistance to storage	<ul style="list-style-type: none"> ■ Approx. 9 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.
Specific comments	<ul style="list-style-type: none"> ■ 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.