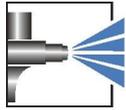


FREIOTHERM-Hydro-Coating

WO1864L

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the mechanical engineering and plant construction sector ■ Good condensation resistance ■ Can be coated over with powder coatings 																						
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of polyester/amino resin</td> </tr> <tr> <td>■ Colour</td> <td>All common colour shades</td> </tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td> <td>satın mat 30-50 Angle 60°</td> </tr> <tr> <td>■ Viscosity DIN 53211 (formerly)</td> <td>Flow time 50-65 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,7-8,9</td> </tr> <tr> <td>■ Density calculated</td> <td>1,1-1,2 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>36-40 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>220-240 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>160-180 g/m², Layer thickness 40 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1864LRU905</td> </tr> </table>	■ Binder-Base	Combination of polyester/amino resin	■ Colour	All common colour shades	■ Gloss value DIN EN ISO 2813	satın mat 30-50 Angle 60°	■ Viscosity DIN 53211 (formerly)	Flow time 50-65 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,7-8,9	■ Density calculated	1,1-1,2 g/ml	■ Solid Mass calculated	36-40 %	■ Solid content in volume calculated	220-240 ml/kg	■ Material usage theoretical, without application loss	160-180 g/m ² , Layer thickness 40 µm	■ Reference colour of the specified values	Colour of WO1864LRU905
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Substrate	<ul style="list-style-type: none"> ■ Steel ■ Steel - preliminary test required for galvanised substrates ■ Steel, passivated or pretreated substrates 																						
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. For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding 																						
Structure recommendation	<table border="1"> <tr> <td>■ Substrate</td> <td>on iron-phosphated steel plate</td> </tr> <tr> <td>■ Top coat</td> <td>WO1864LRU905 Dry film thickness 30 µm</td> </tr> </table>	■ Substrate	on iron-phosphated steel plate	■ Top coat	WO1864LRU905 Dry film thickness 30 µm																		
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Mechanical Test	<table border="1"> <tr> <td>■ Cross-cut-test DIN EN ISO 2409</td> <td>Gt 0</td> </tr> </table>	■ Cross-cut-test DIN EN ISO 2409	Gt 0																				
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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. Dry film thickness must not exceed 35 µm - risk of reaction bubbles. <table border="1"> <tr> <td>■ Object temperature</td> <td>10-30 °C</td> </tr> </table>	■ Object temperature	10-30 °C																				
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WO1864L

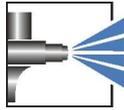
	■ Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %
	■ High pressure spraying	as delivered viscosity Nozzle: 1,5 mm Spray pressure 3-4 bar
	■ Electrostatic	possible, system-specific
	■ Over-coating capability	possible based on pre-test
	■ Cleaning of equipment	Immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916. Dried-on equipment with org. solvents, e.g. EFD thinner 400424.
	■ 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	■ Oven drying	20 min./ 140 °C - 10 min./ 170 °C
	■ Object temperature	green cross-hatching = baking conditions with good final properties

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>
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Specific comments	<p>■ EFD-info Refer to the EFD information for further technical information. Nr. 111</p> <p>■ Test conditions</p>
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FREIOTHERM-Hydro-Coating **WO1864L**

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.