



## WT6000GRA999 FREIOTHERM-DipTec

### Product description

<b>Product technology</b>	water-borne dipping coating
<b>Application area</b>	e.g. in the mechanical engineering and plant construction sector
<b>Substrate</b>	Non-ferrous metals, Steel, according to customer requirements

### General product properties

<b>Binder-Base</b>	Acrylic Resin, modified	
<b>Viscosity</b>	800-1050 mPa*s, spindle 4, 60 revolutions/min.	DIN EN ISO 2555
<b>pH-Value</b>	8,4-8,9	DIN 19260
<b>Density</b>	1,0-1,1 g/ml	theoretical
<b>Solid mass</b>	43-47 %	theoretical
<b>Solid content in volume</b>	400-420 ml/kg	theoretical
<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	According to customer requirements
	Top coat	WT6000GRA999 Dry film thickness 5-10 µm
<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 70 µm – risk of reaction bubbles.	
<b>Object temperature</b>	10-30 °C, minimum +3 °C above dew point temperature	



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<b>Processing conditions</b>	Room temperature 18-22 °C Relative humidity 40-60 %	
<b>Flow Time</b>	49-52 sec. / 2 mm flow cup (DIN 53211)	
<b>Material usage</b>	without application loss 190-200 g/m <sup>2</sup> layer thickness 80 µm	theoretical
<b>Oven drying</b>	up to 100 °C possible	
<b>Air drying</b>	20 °C, 0 % relative humidity	
<b>Dust drying</b>	after 45 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 4 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 14 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	cleaning immediately with water, dried-on equipment with org. solvents, e.g. EFD cleaner.	

### Further processing of coated pieces

<b>Repainting</b>	possible with same quality, dry at the earliest after matting.
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### Mechanical tests

<b>Cross-cut-test</b>	Gt 0	DIN EN ISO 2409
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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.