



WT4113MRA903 FREIOTHERM-DipTec

Product description

Product technology	water-thinnable baking coating
Application area	e.g. in the construction and sanitary sector
Condensed water resistance	good
Substrate	Non-ferrous metals, Steel

General product properties

Binder-Base	Polyester resin modified	
Colour	RAL9003 Signal white	
Gloss visually	matt	
Viscosity	Flow time 25 - 35 sec., 4 mm flow cup	DIN 53211
pH-Value	8,5 - 9,0	DIN 19260
Density	1,35 - 1,45 g/ml	theoretical
Solid mass	50 - 56 %	theoretical
Solid content in volume	225 - 235 ml/kg	theoretical
Resistance to storage	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.	

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	mat	15 - 30 GU, Angle 85°	DIN EN ISO 2813
Structure recommendation	Substrate	On iron-phosphated steel plate	
	Primer	WT4113MRA903 Dry film thickness 10 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 30 µm – risk of reaction bubbles.		



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Object temperature

10 - 30 °C, minimum +3 °C above dew point temperature

Processing conditions

Room temperature 18 - 25 °C
Relative humidity 40 - 60 %

Flow Time

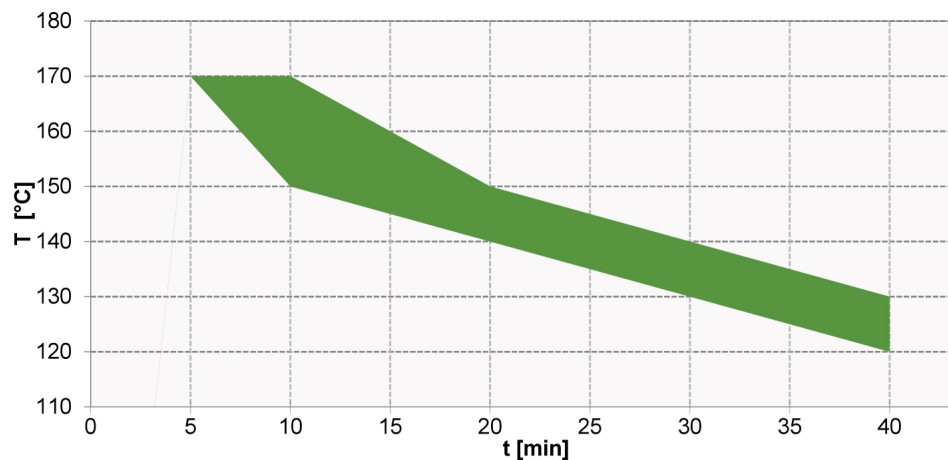
15 - 17 sec. / 4 mm flow cup (DIN 53211)

Material usage

without application loss 240 - 270 g/m² theoretical
layer thickness 60 µm

Curing

Recommended object temperature 15 min/150 °C



Objekt Temperatur in °C Object Temperature in °C	130	140	150	160	170
Haltezeit Minimum in Minuten Holding time minimum in minutes	30	20	10	7,5	5
Haltezeit Maximum in Minuten Holding time maximum in minutes	40	30	20	15	10

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

10 min. / 150 °C - 5 min. / 170 °C (object temperature)

Cleaning of equipment

cleaning immediately with water, dried-on equipment with org. solvents, e.g. EFD cleaner.



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Mechanical tests

Cross-cut-test	Gt 0	DIN EN ISO 2409
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Climatic tests

Condensate constant climate	Load duration	240 h	DIN EN ISO 6270-2 (CH)
	Bubble degree Surface	0(S0)	DIN EN ISO 4628-2

Comments

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.

Product label

Baking temperature	150°C-15min
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