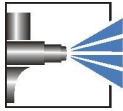


FREIOTHERM-Hydro-Coating

WO1860H

| | | | | | | | | | | | | | | | | | | | | | | | |
|---|--|-------------------------------------|-------------------------------------|------------|--|----------------------------------|------------------------------|-------------------------------------|---|-----------|---------------------|------------|---------|-------------------------|----------------|----------------------------|---------|---|---------------|---|--|--|------------------------|
| Characteristics | <ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the functional furniture and storage technology sector ■ Good chemical resistance ■ Good adhesion to steel and non-ferrous metals ■ For interior use ■ Good hardness and elasticity | | | | | | | | | | | | | | | | | | | | | | |
| Technical / Physical Data | <table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of acrylate/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>satin mat 40-55 Angle 60°</td> </tr> <tr> <td>■ Viscosity DIN 53211 (formerly)</td> <td>Flow time 45-65 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,5-8,7</td> </tr> <tr> <td>■ Density calculated</td> <td>1,15-1,45 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>50-54 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>260-300 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>130-150 g/m², Layer thickness 40 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1860HRA735</td> </tr> </table> | ■ Binder-Base | Combination of acrylate/amino resin | ■ Colour | All common colour shades | ■ Gloss value DIN EN ISO 2813 | satin mat 40-55 Angle 60° | ■ Viscosity DIN 53211 (formerly) | Flow time 45-65 seconds 4 mm viscosity cup | ■ Thinner | demineralised water | ■ pH-Value | 8,5-8,7 | ■ Density calculated | 1,15-1,45 g/ml | ■ Solid Mass calculated | 50-54 % | ■ Solid content in volume calculated | 260-300 ml/kg | ■ Material usage theoretical, without application loss | 130-150 g/m ² , Layer thickness 40 µm | ■ Reference colour of the specified values | Colour of WO1860HRA735 |
| ■ Binder-Base | Combination of acrylate/amino resin | | | | | | | | | | | | | | | | | | | | | | |
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| ■ Gloss value DIN EN ISO 2813 | satin mat 40-55 Angle 60° | | | | | | | | | | | | | | | | | | | | | | |
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| ■ Reference colour of the specified values | Colour of WO1860HRA735 | | | | | | | | | | | | | | | | | | | | | | |
| Substrate | <ul style="list-style-type: none"> ■ Steel ■ ATL-primed | | | | | | | | | | | | | | | | | | | | | | |
| 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 bare steel plate</td> </tr> <tr> <td>■ Top coat</td> <td>WO1860HRA735 Dry film thickness 30 µm</td> </tr> </table> | ■ Substrate | on bare steel plate | ■ Top coat | WO1860HRA735 Dry film thickness 30 µm | | | | | | | | | | | | | | | | | | |
| ■ Substrate | on bare steel plate | | | | | | | | | | | | | | | | | | | | | | |
| ■ Top coat | WO1860HRA735 Dry film thickness 30 µm | | | | | | | | | | | | | | | | | | | | | | |
| 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 | | | | | | | | | | | | | | | | | | | | |
| ■ Cross-cut-test DIN EN ISO 2409 | Gt 0 | | | | | | | | | | | | | | | | | | | | | | |
| 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. | | | | | | | | | | | | | | | | | | | | | | |

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.



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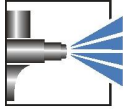
| | |
|--|--|
| ■ Object temperature | 10-30 °C |
| ■ Processing conditions | Room temperature 18-25 °C Relative humidity 40-60 % |
| ■ High pressure spraying | 50-60 Sec./ mm Viscosity cup (DIN) Nozzle 1,4 mm Spray pressure 3,5 bar |
| ■ Over-coating capability | possible based on pre-test |
| ■ Cleaning 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 | 9 min./ 150 °C - 5 min./ 170 °C |
| | ■ Object temperature | green cross-hatching = baking conditions with good final properties |
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| Resistance to storage | ■ | 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. |
| | 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. | |

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| Specific comments | ■ 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 |
|--------------------------|--------------------------|--|

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further information.

The information provided here contains reference values and does not constitute a specification.