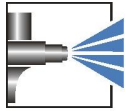


FREIOTHERM-Hydro-Dipping-Coat
WO1888M

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the construction and sanitary sector ■ Good condensation resistance ■ Good adhesion to steel and non-ferrous metals ■ For interior use 																						
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>mat 15-30 Angle 85°</td> </tr> <tr> <td>■ Viscosity DIN 53211 (formerly)</td> <td>Flow time 25-35 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,5-9,0</td> </tr> <tr> <td>■ Density calculated</td> <td>1,35-1,45 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>50-56 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>225-235 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>240-270 g/m², Layer thickness 60 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1888MRA910</td> </tr> </table>	■ Binder-Base	Combination of polyester/amino resin	■ Colour	All common colour shades	■ Gloss value DIN EN ISO 2813	mat 15-30 Angle 85°	■ Viscosity DIN 53211 (formerly)	Flow time 25-35 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,5-9,0	■ Density calculated	1,35-1,45 g/ml	■ Solid Mass calculated	50-56 %	■ Solid content in volume calculated	225-235 ml/kg	■ Material usage theoretical, without application loss	240-270 g/m ² , Layer thickness 60 µm	■ Reference colour of the specified values	Colour of WO1888MRA910
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Substrate	<ul style="list-style-type: none"> ■ 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>■ Primer</td> <td>WO1888MRA910 Dry film thickness 10 µm</td> </tr> </table>	■ Substrate	on iron-phosphated steel plate	■ Primer	WO1888MRA910 Dry film thickness 10 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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Resistance Test	<table border="1"> <tr> <td>■ Condensate constant climate DIN EN ISO 6270-2 (CH)</td> <td>240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2</td> </tr> </table>	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2																				
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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. 																						

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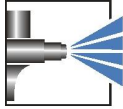
	Dry film thickness must not exceed 30 µm - risk of reaction bubbles.	
■	Object temperature	10-30 °C
■	Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
■	Immersing	15-17 Sec/ 4 mm Viscosity cup (DIN 53211)
■	Cleaning of equipment	Immediately with water - possibly with addition 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	10 min./ 150 °C - 5 min./ 170 °C
	■	Object temperature green cross-hatching = baking conditions with good final properties	

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.

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 further information.
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IATF 16949
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