FreiLacke

FREIOTHERM-Hydro-Coating
WO1800M

Characteristics	Water-thinnable baking coating	
	Application, e.g. in the functional furniture and storage technology sector	
	Good adhesion to steel and non-ferrous metals	
	For exterior use	
	Good condensation resistance	
	Good hardness and elasticity	
Technical / Physical Data	Binder-Base	Combination of acrylate/polyester/amino resin
	Colour	All common colour shades
	Gloss value DIN EN ISO 2813	mat 24-40 Angle 85°
	Viscosity DIN 53211 (formerly)	Flow time 20-25 seconds 4 mm viscosity cup
	Thinner	demineralised water
	pH-Value	8,3-8,7
	Density calculated	1,2-1,3 g/ml
	Solid Mass calculated	43-47 %
	Solid content in volume calculated	240-250 ml/kg
	Material usage theoretical, without application loss	160-180 g/m², Layer thickness 40 µm
	Reference colour of the specified values	Colour of WO1800MB2643
Substrate	Steel, passivated or pretreated substrates	
Pretreatment	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	Substrate	on iron-phosphated steel plate
	Top coat	WO1800MB2643 Dry film thickness 30 µm
Mechanical Test	Cross-cut-test DIN EN ISO 2409	Gt 0
Processing and application	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 40 µm - risk of reaction bubbles.	
	Object temperature	10-30 °C

DIN EN ISO 9001
IATF 16949
EMAS

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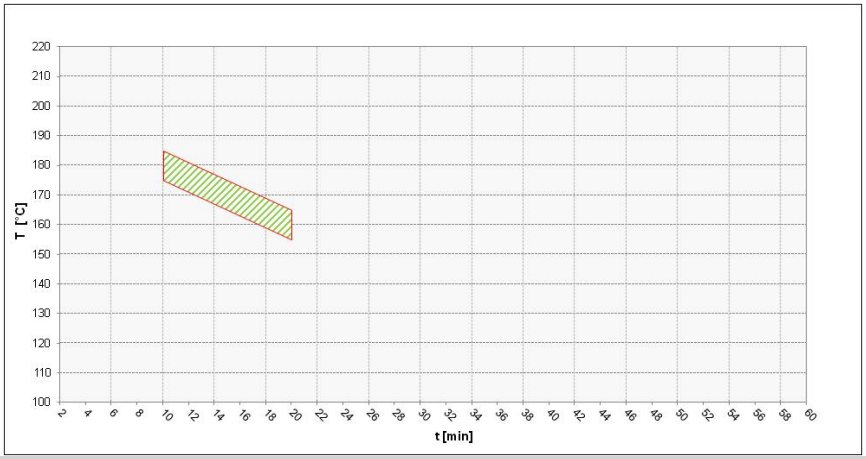
	Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	Immersing	16-25 Sec/ 4 mm Viscosity cup (DIN 53211)
	Cleaning of equipment	Immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916. Dried-on equipment with org. solvents, e.g. EFD thinner 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	20 min./ 160 °C - 10 min./ 180 °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.

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

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