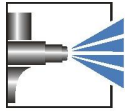


FREIOTHERM-Hydro-Primer WO1870H

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the automotive sector ■ Good stone chip resistance ■ Can be coated over with powder coatings 																						
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of acrylate/polyester/amino resin</td> </tr> <tr> <td>■ Colour</td> <td>All common colour shades</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>satın mat</td> </tr> <tr> <td>■ Viscosity <small>DIN 53211 (formerly)</small></td> <td>Flow time 30-40 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,0-9,0</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,18-1,20 g/ml</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>37-43 %</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>220-240 ml/kg</td> </tr> <tr> <td>■ Material usage <small>theoretical, without application loss</small></td> <td>80-90 g/m², Layer thickness 20 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1870HRU740</td> </tr> </table>	■ Binder-Base	Combination of acrylate/polyester/amino resin	■ Colour	All common colour shades	■ Gloss value <small>visual</small>	satın mat	■ Viscosity <small>DIN 53211 (formerly)</small>	Flow time 30-40 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,0-9,0	■ Density <small>calculated</small>	1,18-1,20 g/ml	■ Solid Mass <small>calculated</small>	37-43 %	■ Solid content in volume <small>calculated</small>	220-240 ml/kg	■ Material usage <small>theoretical, without application loss</small>	80-90 g/m ² , Layer thickness 20 µm	■ Reference colour of the specified values	Colour of WO1870HRU740
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Substrate	<ul style="list-style-type: none"> ■ Aluminium 																						
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. Chromating or corresponding chrome-free conversion coatings. 																						
Structure recommendation	<table border="1"> <tr> <td>■ Substrate</td> <td>Aluminium</td> </tr> <tr> <td>■ Primer</td> <td>WO1870H Dry film thickness 20 µm</td> </tr> <tr> <td>■ Base coat</td> <td>WO1869H Dry film thickness 20 µm</td> </tr> <tr> <td>■ Clear coat</td> <td>PY1005BRA999 Dry film thickness 90 µm</td> </tr> </table>	■ Substrate	Aluminium	■ Primer	WO1870H Dry film thickness 20 µm	■ Base coat	WO1869H Dry film thickness 20 µm	■ Clear coat	PY1005BRA999 Dry film thickness 90 µm														
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Mechanical Test	<table border="1"> <tr> <td>■ Cross-cut-test <small>DIN EN ISO 2409</small></td> <td>Gt 0</td> </tr> <tr> <td>■ Stone chipping test <small>DIN EN ISO 20567-1</small></td> <td>Characteristic value <2</td> </tr> </table>	■ Cross-cut-test <small>DIN EN ISO 2409</small>	Gt 0	■ Stone chipping test <small>DIN EN ISO 20567-1</small>	Characteristic value <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. ■ Object temperature 15-35 °C 																						

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.



FREIOTHERM-Hydro-Primer
WO1870H

	■ Processing conditions	Room temperature 15-25 °C Relative humidity 50-70 %
	■ Electrostatic	possible, system-specific
	■ ESTA high rotation	as delivered viscosity
	■ 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		
	■ Intermediate drying	10 min./ 120 °C
	■ Oven drying	10 min./ 180 °C - 20 min./ 160 °C
	■ Object temperature	Baking window on request
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.
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.