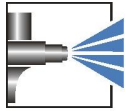


FREIOTHERM-Hydro-Clearcoat

WO1858GRA999

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 exterior 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>colourless</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>glossy</td> </tr> <tr> <td>■ Viscosity <small>DIN 53211 (formerly)</small></td> <td>Flow time 16-18 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 <small>calculated</small></td> <td>1,00-1,10 g/ml</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>37-40 %</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>340-370 ml/kg</td> </tr> <tr> <td>■ Material usage <small>theoretical, without application loss</small></td> <td>80-100 g/m², Layer thickness 40 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1858GRA999</td> </tr> </table>	■ Binder-Base	Combination of acrylate/amino resin	■ Colour	colourless	■ Gloss value <small>visual</small>	glossy	■ Viscosity <small>DIN 53211 (formerly)</small>	Flow time 16-18 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,5-9,0	■ Density <small>calculated</small>	1,00-1,10 g/ml	■ Solid Mass <small>calculated</small>	37-40 %	■ Solid content in volume <small>calculated</small>	340-370 ml/kg	■ Material usage <small>theoretical, without application loss</small>	80-100 g/m ² , Layer thickness 40 µm	■ Reference colour of the specified values	Colour of WO1858GRA999
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Substrate	<ul style="list-style-type: none"> ■ Steel 																						
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>WO1858GRA999 Dry film thickness 30 µm</td> </tr> </table>	■ Substrate	on bare steel plate	■ Top coat	WO1858GRA999 Dry film thickness 30 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> </table>	■ Cross-cut-test <small>DIN EN ISO 2409</small>	Gt 0																				
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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. Dry film thickness must not exceed 40 µm - risk of reaction bubbles. <table border="1"> <tr> <td>■ Object temperature</td> <td>10-30 °C</td> </tr> </table>	■ Object temperature	10-30 °C																				
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	■ Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	■ Immersing	16-18 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	<ul style="list-style-type: none"> ■ 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. <p>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.</p>
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Specific comments	<ul style="list-style-type: none"> ■ Test conditions <p>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.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>
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