



WO1839L

FREIOTHERM-Hydro-Coating

Product description

Product technology	water-thinnable single-layer coating
Application area	e.g. in the mechanical engineering and plant construction sector
Over-coating capability	possible with powder coatings
Substrate	Steel, Aluminium

General product properties

Binder-Base	Combination of polyester/amino resin		
Colour	All common colour shades		
Gloss value	mat	30-50 GU, angle 85°	DIN EN ISO 2813
Viscosity	Flow time 45-55 sec. 4 mm flow cup		DIN 53211
pH-Value	8,7-9,0		DIN 19260
Solid mass	45-46 %		theoretical
Solid content in volume	31-33 %		theoretical
Reference product	The values given refer to the product with the shade WO1839LH1938.		
Resistance to storage	<p>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> <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>		

Application and processing

Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.		
Structure recommendation	Substrate	On iron-phosphated steel plate	
	Top coat	WO1839LH1938 Dry film thickness 30 µm	
Note before use	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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Thinning	demineralised water	
Dry film thickness	must not exceed 35 µm – risk of reaction bubbles.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	
Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %	
High pressure spraying	as delivered viscosity nozzle 1,5 mm spray pressure 3-4 bar	
Electrostatic	possible, system-specific	
Material usage	without application loss 325-355 g/m ² layer thickness 80 µm	theoretical
Oven drying	30 min. / 140 °C - 15 min. / 160 °C (object temperature)	
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.	

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 111.
Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an 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.