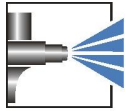


FREIOTHERM-Hydro-Refill-Paste

WO1823M

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the construction and sanitary sector ■ Good corrosion protection ■ Very good mechanical resistance ■ Good condensation resistance ■ Good adhesion to steel and non-ferrous metals ■ Can be coated over with powder coatings ■ For interior use 																						
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Acrylate/polyester resin combination crosslinked with polyisocyanate</td> </tr> <tr> <td>■ Colour</td> <td>All common colour shades</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>mat</td> </tr> <tr> <td>■ Viscosity</td> <td>3500-5500 mPa.s/ Spindle 5 60 revolution/ min.</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,7-9,2</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,30-1,40 g/ml</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>70-73 %</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>420-440 ml/kg</td> </tr> <tr> <td>■ Material usage <small>theoretical, without application loss</small></td> <td>200-220 g/m², Layer thickness 60 µm</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WO1823MRU910</td> </tr> </table>	■ Binder-Base	Acrylate/polyester resin combination crosslinked with polyisocyanate	■ Colour	All common colour shades	■ Gloss value <small>visual</small>	mat	■ Viscosity	3500-5500 mPa.s/ Spindle 5 60 revolution/ min.	■ Thinner	demineralised water	■ pH-Value	8,7-9,2	■ Density <small>calculated</small>	1,30-1,40 g/ml	■ Solid Mass <small>calculated</small>	70-73 %	■ Solid content in volume <small>calculated</small>	420-440 ml/kg	■ Material usage <small>theoretical, without application loss</small>	200-220 g/m ² , Layer thickness 60 µm	■ Reference colour of the specified values	Colour of WO1823MRU910
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Substrate	<ul style="list-style-type: none"> ■ Steel ■ 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>WO1823MRU910 Dry film thickness 15 µm</td> </tr> <tr> <td>■ Top coat</td> <td>PB6704ARG916 Dry film thickness 60 µm</td> </tr> </table>	■ Substrate	on iron-phosphated steel plate	■ Primer	WO1823MRU910 Dry film thickness 15 µm	■ Top coat	PB6704ARG916 Dry film thickness 60 µm																
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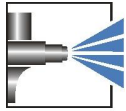
Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms of business and delivery.



FREIOTHERM-Hydro-Refill-Paste
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	DIN EN ISO 2409
Resistance Test	<ul style="list-style-type: none"> Condensate constant climate 540 hours DIN EN ISO 6270-2 (CH) Degree of blistering 0 (S 0) DIN EN ISO 4628-2
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 50 µm - risk of reaction bubbles. Object temperature 10-30 °C Processing conditions Room temperature 18-25 °C Relative humidity 40-60 % Immersing 14-18 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	<ul style="list-style-type: none"> Oven drying 10 min./ 160 °C - 15 min./ 170 °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</p>

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.



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	suitable for the intended application.
Specific comments	<ul style="list-style-type: none"> ■ 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. <p>The information provided here contains reference values and does not constitute a specification.</p>