## **Technical Datasheet**





| wax and separating agent residue. Preliminary tests are recommended for assurthe suitability of coating qualities on the substrate.  Structure recommendation  Substrate  on bare steel plate  Primer  WL1621HRU999  Dry film thickness 120 μm  Cross-cut-test DIN EN ISO 2409  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C   |                            |  |  |  |
|--|----------------------------|--|--|--|
| Fast initial drying Suitable for various substrates Good flexibility    Binder-Base  | Characteristics            | ■ Water-thinnable 1C coating   |  |  |
| Suitable for various substrates Good flexibility  Technical / Physical Data    Binder-Base   |                            | Application, e.g. in the mechanical engineering and plant construction sector  |  |  |
| Good flexibility   Technical / Physical Data   Binder-Base   Polymerisation resin  |                            | ■ Fast initial drying  |  |  |
| Binder-Base   Polymerisation resin   |                            | <ul><li>Suitable for various substrates</li></ul>  |  |  |
| Colour colourless  |                            | ■ Good flexibility   |  |  |
| Gloss value visual   Satin glossy  | Technical / Physical Data  | ■ Binder-Base  | Polymerisation resin                                   |  |
| Viscosity   4500-5500 mPa.s/ Spindle 5 60 revolution/ min.   |                            | Colour   | colourless   |  |
| Fretreatment  Pretreatment  This substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assurtive suitability of coating qualities on bare steel plate  Primer  Substrate Trimer  Processing and application  Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prelim thickness must not exceed 2000 µm - risk of reaction bubbles.  Object temperature  Poly film thickness must not exceed 2000 µm - risk of reaction bubbles.  Object temperature  10-30 °C  |                            |  | satin glossy   |  |
| PH-Value   7-9     Density calculated   1,06-1,07 g/ml     Solid Mass calculated   48-52 %     Solid content in volume calculated   350-450 ml/kg     Material usage theoretical, without application loss   250-350 g/m², Layer thickness 120 µm     Material usage theoretical, without application loss   250-350 g/m², Layer thickness 120 µm     Reference colour of the specified values   Colour of WL1621HRU999     Substrate   Aluminium   Stainless steel   Steel     Pretreatment   The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assur the suitability of coating qualities on the substrate.    Structure recommendation   Substrate   on bare steel plate     Primer   WL1621HRU999   Dry film thickness 120 µm     Mechanical Test   Cross-cut-test DIN EN ISO 2409   Gt 5     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 2000 µm - risk of reaction bubbles.     Object temperature   10-30 °C |                            | Viscosity  |  |  |
| Density calculated   1,06-1,07 g/ml  |                            | Thinner  | demineralised water                                    |  |
| Solid Mass calculated  Solid Content in volume 350-450 ml/kg  Material usage theoretical, without application loss  Reference colour of the specified values  Substrate  Aluminium  Stainless steel Steel  Pretreatment  The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assur the suitability of coating qualities on the substrate.  Structure recommendation  Substrate  Primer  WL1621HRU999 Dry film thickness 120 μm  Mechanical Test  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C  |                            | ■ pH-Value   | 7-9  |  |
| Solid content in volume calculated  Solid content in volume calculated  Material usage theoretical, without application loss  Reference colour of the specified values  Aluminium  Stainless steel Steel  The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assurthe suitability of coating qualities on the substrate.  Structure recommendation  Substrate  Primer  WL1621HRU999 Dry film thickness 120 μm  Mechanical Test  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C   |                            |  | 1,06-1,07 g/ml   |  |
| Material usage theoretical, without application loss   250-350 g/m², Layer thickness 120 μm  |                            |  | 48-52 %  |  |
| Reference colour of the specified values   |                            |  | e 350-450 ml/kg  |  |
| Substrate  Aluminium  Stainless steel Steel  The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assure the suitability of coating qualities on the substrate.  Structure recommendation  Substrate  Primer  WL1621HRU999 Dry film thickness 120 μm  Mechanical Test  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C   |                            |  |  |  |
| Stainless steel  Steel  Pretreatment  The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assure the suitability of coating qualities on the substrate.  Structure recommendation  Substrate  On bare steel plate  Primer  WL1621HRU999  Dry film thickness 120 μm  Mechanical Test  Cross-cut-test DIN EN ISO 2409  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C  |                            |  | e Colour of WL1621HRU999                               |  |
| Steel  | Substrate                  | Aluminium  |  |  |
| Pretreatment  The substrate must be free of adhesion-impairing substances such as oil, grease wax and separating agent residue. Preliminary tests are recommended for assurthe suitability of coating qualities on the substrate.  Structure recommendation  Substrate  on bare steel plate  Primer  WL1621HRU999  Dry film thickness 120 μm  Mechanical Test  Processing and application  Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). The prevent skin formation, over-coat with water.  Dry film thickness must not exceed 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C   |                            | ■ Stainless steel  |  |  |
| wax and separating agent residue. Preliminary tests are recommended for assurthe suitability of coating qualities on the substrate.  Structure recommendation  Substrate  on bare steel plate  Primer  WL1621HRU999  Dry film thickness 120 μm  Cross-cut-test DIN EN ISO 2409  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C   |                            | ■ Steel  |  |  |
| Primer WL1621HRU999 Dry film thickness 120 μm  Cross-cut-test DIN EN ISO 2409  Processing and application  Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). The prevent skin formation, over-coat with water. Dry film thickness must not exceed 2000 μm - risk of reaction bubbles.  Object temperature 10-30 °C   | Pretreatment               | The substrate must be free of adhesion-impairing substances such as oil, grease, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. |  |  |
| Dry film thickness 120 μm  Cross-cut-test DIN EN ISO 2409  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 2000 μm - risk of reaction bubbles.  Object temperature  10-30 °C  | Structure recommendation   | Substrate  | on bare steel plate                                    |  |
| Processing and application  Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). T prevent skin formation, over-coat with water.  Dry film thickness must not exceed 2000 μm - risk of reaction bubbles.  Object temperature 10-30 °C   |                            | Primer   |  |  |
| prevent skin formation, over-coat with water.  Dry film thickness must not exceed 2000 μm - risk of reaction bubbles.  Object temperature 10-30 °C   | Mechanical Test            |  | Gt 5   |  |
| Object temperature 10-30 °C  | Processing and application |  |  |  |
| , · ·  |                            | Dry film thickness must not exceed 2000 µm - risk of reaction bubbles.   |  |  |
| Processing conditions Room temperature 18-22 °C  |                            | Object temperature   | 10-30 °C   |  |
| Relative humidity 40-60 %  |                            | Processing conditions  | Room temperature 18-22 °C<br>Relative humidity 40-60 % |  |

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.



## FREIOPLAST-HydroStrippableCoat WL1621HRU999

|                       | Airless spraying  | as delivered viscosity<br>Nozzle 0,15 mm angle 30°<br>Material pressure 150 bar   |
|-----------------------|---|---|
|                       | Rolling / painting  | as delivered viscosity  |
|                       | Over-coating capabili   | ty possible with same quality,<br>dry at the earliest after matting   |
|                       | ■ Cleaning of equipmen  | 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.  |
|                       | painting materials. De data and recommend   | Vork guidelines al safety precautions must be observed when handling etailed information about dangerous substances, safety ations concerning Health & Safety at Work and tion can be found in the corresponding safety data sheet. |
| Curing                | Air drying  | at 20 °C, 50 % relative humidity with air movement  |
|                       | Dust drying   | after 30 min.<br>(degree of drying 1/ DIN EN ISO 9117-5)  |
|                       | ■ Dry to the touch  | after Min.<br>(degree of drying 4/ DIN EN ISO 9117-5)   |
|                       | Full drying   | after 2 days<br>(pendulum damping/DIN EN ISO 1522)  |
| 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     | To do a sudidion s  |   |
|                       | ■ <b>Test conditions</b> 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 provi specification.  | ded here contains reference values and does not constitute a  |