

FREIOPLAST

Hydro-Coating WL1688

- Water dilutable corrosion protection system
- Air-drying
- One- and multi-coat system for steel construction and container
- Volatile organic compound is lower than 5% per weight

Technical / Physical Data	Resin/ binder	combination of oxidativ dry, water based alkydresin-emulsion and acrylate-dispersion	
	Colour	acc. to RAL 840 HR other colour shades on request	
	Gloss value visual	satin mat	
	Original viscosity	1,6 to 1,8 Pa.s / Spindel 1 Haake-Viscotester VT02	
	Thinner	demineralised water	
	pH-value	9,0	+ / - 0,2
	Density calculated	1,3 g / ml	+ / - 0,1
	Solid content calculated	60 %	+ / - 2
	Solid content in volume calculated	370 ml / kg 480 ml / l	+ / - 15 or + / - 20
	Consumption calculated in original viscosity, without application loss	340 to 370 g / m ² dry film thickness 130 µm see „Special remarks“	
	Spreading rate calculated in original viscosity, without application loss	260 to 280 ml / m ² dry film thickness 130 µm see „Special remarks“	

Storability Approx. 9 month in original packings at an ambient temperature of 15 to 25 °C, in case the original packings are tightly closed. Protect from frost. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective.

Processing and application

Application

Stir up before the use carefully (e.g. with high-speed mixer).

spraying-high-pressure: after viscosity adjustment to 60 to 80 sec./ 4 mm cup DIN 53211*
 spraying-airless: in original viscosity
 by roller/ brush: in original viscosity

Substrates

steel, with non-ferrous metals

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. If necessary sand or blast cleaning, purity at least SA 2 (SIS 055 900), steeldensity > 20 %, depth of surface 20 to 40 µm

Proposal for a coating system

substrates: steel or stainless steel, about blast cleaning rough up
 primer: FREIOPLAST-Hydro-Coating WL1688
 top coat: FREIOPLAST-Hydro-Coating WL1688
 dry film thickness: 130 to 150 µm

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry: after 30 min (degree of drying 1/ DIN 53150)
 dry to touch: after 3 h (degree of drying 4/ DIN 53150)
 complete dry: after 3 days (swinging beam hardness/ ISO 1522)

oven drying: up to 50°C possible (object temperature)

Repair coating

With itself: after 24 Std. Drying process at ambient temperature, necessarily sanding.

Cleaning of working equipment

immediately after use: water, lightly dried material on the surface of working tools:
 organic cleaners, e.g. EFD-Thinner 400424

Advice for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Test condition

*Indication of the delivery viscosity according to DIN 53211:
 DIN 53211 was withdrawn in October 1996.
 On request the value is available according to DIN EN ISO 2431.

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on WL1688HRU910, white.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered. Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us. The information mentioned herein are reference values and are not given as specification.