

FREIOTHERM

Hydro-Coating WO1837

- Water-thinnable baking coating
- Good deaeration resistance (coarsed during baking prozess)

Technical / Physical Data	Resin/ binder	combination of polyester-aminoresin	
	Colour	acc. to RAL 840 HR other colour shades on request	
	Gloss value DIN 67530 and DIN EN ISO 2813	WO1837 G = WO1837 M =	glossy 80 to 95 geometry 60° mat 10 to 25 geometry 85°
	Original viscosity DIN 53211*	50 to 60 Sek. / 4 mm cup	
	Thinner	VE-water	
	pH-value	8,3 to 8,7	
	Density calculated	WO1837 G = WO1837 M =	1,3 g / ml +/- 0,1 1,4 g / ml +/- 0,1
	Solid content calculated	WO1837 G = WO1837 M =	57 % +/- 6 64 % +/- 6
	Solid content in volume calculated	WO1837 G = WO1837 M =	320 ml / kg +/- 20 350 ml / kg +/- 20
	Consumption calculated in original viscosity, without application loss	80 to 100 g / m ² dry film thickness 30 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. 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: in original viscosity
 nozzle: 1,4 mm spraying pressure: 3 to 4 bar

Substrates

steel, aluminium

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

Proposal for a coating system

substrates: aluminium
Topcoat: FREIOTHERM-Hydro-Coating WO1837

Application temperature

above 10 °C

Drying

oven drying: 30 min. / 180 °C (object temperature)

Cleaning of working equipment

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

Advise 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 WO1837G11221, 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.