

# FREIOTHERM

## Hydro-Basecoat WO1838V

V = Modification of the standard system

- Water-thinnable, baking coating, metall effect
- Multilayer for car parts, for example light alloy wheels
- Special colour adjustment

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	combination of acrylat- / aminoresin
	<b>Colour</b>	metall effect colour from the assortment of the car-industry other colour shades on request
	<b>Gloss value</b> visual	mat
	<b>Original viscosity</b> DIN 53211*	20 to 25 Sek. / 4 mm cup
	<b>Thinner</b>	demineralised water
	<b>pH-value</b>	7,9 to 8,1
	<b>Density</b> calculated	1,01 g / ml + / - 0,05
	<b>Solid content</b> calculated	13 % + / - 2
	<b>Solid content in volume</b> calculated	100 ml / kg + / - 20
	<b>Consumption</b> calculated in original viscosity, without application loss	120 to 190 g / m <sup>2</sup> dry film thickness 15 µm see „Special remarks“
<b>Storability</b>	Approx. 6 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	

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**Processing and application**

**Application**

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

spraying-high-pressure: in original viscosity  
nozzle: 1,2 mm spraying pressure: 4 bar  
spraying-low-pressure: in original viscosity  
nozzle: 1,2 mm spraying pressure: 4 bar  
ESTA-high rotation. in original viscosity

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**Substrates**

aluminium chromated

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**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.

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**Proposal for a coating system**

substrates:	aluminium chromated	
primer:	FREOPOX-Powder coating	PB1605AB0892
Basecoat:	FREIOTHERM-Hydro-Basecoat	WO1838V
Topcoat:	FREIOTHERM-HighSolid-Clearcoat	KO1853VRA999 or acryl-powder coating, colourless

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**Application temperature**

above 10 °C

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**drying**

oven drying: 10 min. / 170 °C (substrate temperature)

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**Cleaning of working equipment**

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

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**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.

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**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 WO1838VB2340, brilliant silver. 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.