

FREIOTHERM

Hydro-Coating WO1854

- Water-thinnable baking coating
- Good hardness and elasticity
- Good weather resistance

Technical / Physical Data	Resin/ binder	acrylate-aminoresin- combination	
	Colour	according to RAL 840 HR or 841 GL other colour shades on request	
	Gloss value	UR1040G = gloss	85 to 95 geometry 60°
	DIN 67530 and	UR1040H = satin glossy	55 to 65 geometry 60°
	DIN EN ISO 2813	UR1040M = mat	20 to 30 geometry 60°
		UR1040Z = acc. to customer's requirement	
	Original viscosity	50 to 70 Sek. / 4 mm cup	
	DIN 53211*		
	Thinner	VE – water	
	pH-value	8,5 to 8,7	
	Density	1,1 g / ml	+ / - 0,15
	calculated		
	Solid content	43 %	+ / - 8
	calculated		
	Solid content in volume	330 ml / kg	+ / - 20
	calculated		
	Consumption	80 to 100 g / m ²	
	calculated	dry film thickness 30 µm	
	in original viscosity,	see „Special remarks“	
	without application loss		

Storability Approx. 9 month in original packings at an ambient temperature of 5 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

Air-Mix: in original viscosity
nozzle: 0,011 inch spraying pressure: 55 to 60 bar
spraying (atomizer) pressure: 4 to 5 bar

ESTA: in original viscosity
nozzle: 1,2 mm spraying pressure: 2 to 2,5 bar
spraying (atomizer) pressure: 3 to 3,5 bar

Substrates

steel, galvanized steel

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: steel, zinc phosphatized
primer: FREIOTHERM-ATL-CorrosionResist
base laquer: FREIOTHERM-Hydro-Coating WO1854

substrates: steel, zinc phosphatized
primer: FREIOTHERM-KTL-Automotive
base laquer: FREIOTHERM-Hydro-Coating WO1854

Application temperature

Application temperature: 15 to 35 °C
air humidity: 40 to 70%

Drying

oven drying: 20 min. / 140C° (object temperature)

Recoatibility

The surface (which will be recoated) has to be free of any contamination. In this case FREIOTHERM – Hydro-Coat WO1854 can be recoated with itself or with EFDEDUR-Coating UR1040. Other coating systems have to be tested before usage.

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 WO1854GRA721, black grey RAL 7021. 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.