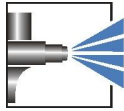


FREOLUX-Hydro-Welding Primer

WL1764L

Characteristics	<ul style="list-style-type: none">■ Water-thinnable 1C coating■ Application, e.g. in the vehicle construction sector■ Forced drying possible■ Good adhesion to steel and non-ferrous metals■ Good weldability	
Technical / Physical Data	■ Binder-Base	Combination of special binders
	■ Colour	All common colour shades
	■ Gloss value visual	mat
	■ Viscosity DIN 53211 (formerly)	Flow time 25-30 seconds 6 mm viscosity cup
	■ Thinner	demineralised water
	■ pH-Value	8,8-9,0
	■ Density calculated	1,2-1,3 g/ml
	■ Solid Mass calculated	40-44 %
	■ Solid content in volume calculated	210-230 ml/kg
	■ Material usage theoretical, without application loss	260-285 g/m², Layer thickness 60 µm
	■ Reference colour of the specified values	Colour of WL1764LRU309
Substrate	■ Steel, passivated or pretreated substrates	
Pretreatment	<ul style="list-style-type: none">■ The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding	
Structure recommendation	■ Substrate	on iron-phosphated steel plate
	■ Primer	WL1764LRU309 Dry film thickness 30 µm
	■ Top coat	WL1557MRU711 Dry film thickness 60 µm
Mechanical Test	■ Cross-cut-test DIN EN ISO 2409	Gt 0
Processing and application	<ul style="list-style-type: none">■ 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 70 µm - risk of reaction bubbles.	
	■ Object temperature	10-30 °C

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.



FREOLUX-Hydro-Welding Primer

WL1764L

	■ Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %
	■ High pressure spraying	as delivered viscosity Nozzle: 1,4 mm Spray pressure 3-4 bar
	■ Rolling / painting	as delivered viscosity
	■ Over-coating capability	possible with same quality, dry at the earliest after matting
	■ Cleaning of equipment	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.
	■ Health & Safety at Work guidelines	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.
Curing	■ Air drying	at 18-22 °C, 40-60 % relative humidity with air movement
	■ Dust drying	after 75 min. (degree of drying 1/ DIN EN ISO 9117-5)
	■ Dry to the touch	after 6 hrs. (degree of drying 4/ DIN EN ISO 9117-5)
	■ Full drying	after 7 days (pendulum damping/DIN EN ISO 1522)
	■ Oven drying	possible to 80°C
Resistance to storage		
	■	Approx. 12 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		
	■ EFD-info	Refer to the EFD information for further technical information. Nr. 111
	■ Test conditions	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 provided here contains reference values and does not constitute a specification.