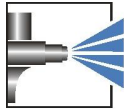




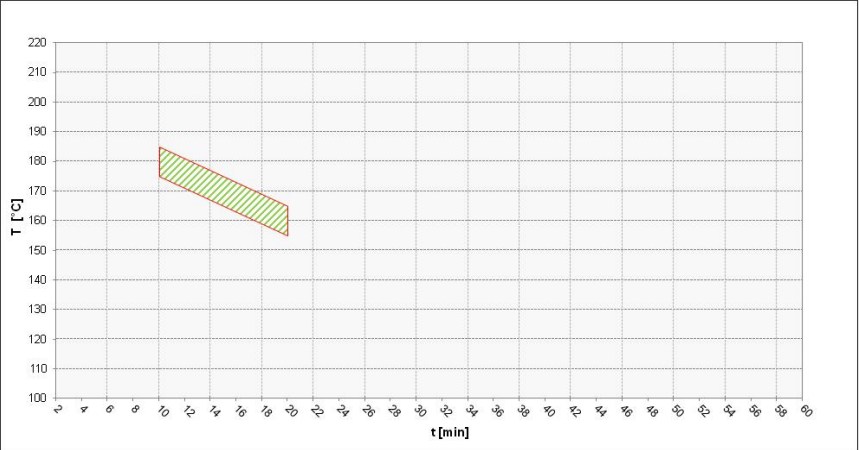
FREIOTHERM-Hydro-Coating WO1800M

Characteristics	- Water-thinnable baking coating - Application, e.g. in the functional furniture and storage technology sector - Good adhesion to steel and non-ferrous metals - For exterior use - Good condensation resistance - Good hardness and elasticity																						
Technical / Physical Data	<table> <tr> <td>Binder-Base</td><td>Combination of acrylate/polyester/amino resin</td></tr> <tr> <td>Colour</td><td>All common colour shades</td></tr> <tr> <td>Gloss value DIN EN ISO 2813</td><td>mat 24-40 Angle 85°</td></tr> <tr> <td>Viscosity DIN 53211 (formerly)</td><td>Flow time 20-25 seconds 4 mm viscosity cup</td></tr> <tr> <td>Thinner</td><td>demineralised water</td></tr> <tr> <td>pH-Value</td><td>8,3-8,7</td></tr> <tr> <td>Density calculated</td><td>1,2-1,3 g/ml</td></tr> <tr> <td>Solid Mass calculated</td><td>43-47 %</td></tr> <tr> <td>Solid content in volume calculated</td><td>240-250 ml/kg</td></tr> <tr> <td>Material usage theoretical, without application loss</td><td>160-180 g/m², Layer thickness 40 µm</td></tr> <tr> <td>Reference colour of the specified values</td><td>Colour of WO1800MB2643</td></tr> </table>	Binder-Base	Combination of acrylate/polyester/amino resin	Colour	All common colour shades	Gloss value DIN EN ISO 2813	mat 24-40 Angle 85°	Viscosity DIN 53211 (formerly)	Flow time 20-25 seconds 4 mm viscosity cup	Thinner	demineralised water	pH-Value	8,3-8,7	Density calculated	1,2-1,3 g/ml	Solid Mass calculated	43-47 %	Solid content in volume calculated	240-250 ml/kg	Material usage theoretical, without application loss	160-180 g/m², Layer thickness 40 µm	Reference colour of the specified values	Colour of WO1800MB2643
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Substrate	Steel, passivated or pretreated substrates																						
Pretreatment	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	<table> <tr> <td>Substrate</td><td>on iron-phosphated steel plate</td></tr> <tr> <td>Top coat</td><td>WO1800MB2643 Dry film thickness 30 µm</td></tr> </table>	Substrate	on iron-phosphated steel plate	Top coat	WO1800MB2643 Dry film thickness 30 µm																		
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Processing and application	- 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 40 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.



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	■ Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	■ Immersing	16-25 Sec/ 4 mm Viscosity cup (DIN 53211)
	■ 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	■ Oven drying	20 min./ 160 °C - 10 min./ 180 °C
	■ Object temperature	green cross-hatching = baking conditions with good final properties
		
Resistance to storage	■	Approx. 9 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	■ 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.