FreiLacke

FREIOTHERM-System-HydroStruct.
WO9191H

Characteristics	■ Water-thinnable baking coating ■ Application, e.g. in the functional furniture and storage technology sector ■ Good adhesion to steel and non-ferrous metals ■ Good condensation resistance ■ Good hardness and elasticity ■ Can be coated over with powder coatings ■ For interior use	
System Coating	■ System Liquid Coating For various applications, there are coatings available, whose optical appearance regarding colour, gloss degree and surface is in optimum balance.	
Technical / Physical Data	■ Binder-Base	Combination of acrylate/amino resin
	■ Colour	All common colour shades
	■ Gloss value DIN EN ISO 2813	satin mat 25-35 Angle 60°
	■ Viscosity DIN 53211 (formerly)	Flow time 50-60 seconds 4 mm viscosity cup
	■ Thinner	demineralised water
	■ pH-Value	8,5-8,7
	■ Density calculated	1,20-1,40 g/ml
	■ Solid Mass calculated	45-58 %
	■ Solid content in volume calculated	270-350 ml/kg
	■ Material usage theoretical, without application loss	230-280 g/m², Layer thickness 80 µm
	■ Reference colour of the specified values	Colour of WO9191HC1628
Substrate	■ ATL-primed ■ Steel ■ 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	■ Substrate	on bare steel plate
	■ Top coat	WO9191HC1628 Dry film thickness 30 µm

DIN EN ISO 9001
IATF 16949
EMAS

Emil Frei GmbH & Co. KG
Döggingen
Am Bahnhof 6
78199 Bräunlingen | GERMANY
Phone +49 [0] 7707.151-0
Fax +49 [0] 7707.151-238
www.freilacke.de
info@freilacke.de

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Mechanical Test	Cross-cut-test DIN EN ISO 2409	Gt 0
Resistance Test		
	Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2
	Salt spray test (NSS) DIN EN ISO 9227	240 hours Water ingress Wb < 4 mm DIN EN ISO 4628-8
	Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.
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 45 µm - risk of reaction bubbles.	
	Object temperature	18-25 °C
	Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	High pressure spraying	as delivered viscosity Nozzle: 1,2 mm Spray pressure 4 bar
	Over-coating capability	possible based on pre-test
	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	25 min./ 150 °C - 10 min./ 170 °C
	Object temperature green cross-hatching = baking conditions with good final properties	

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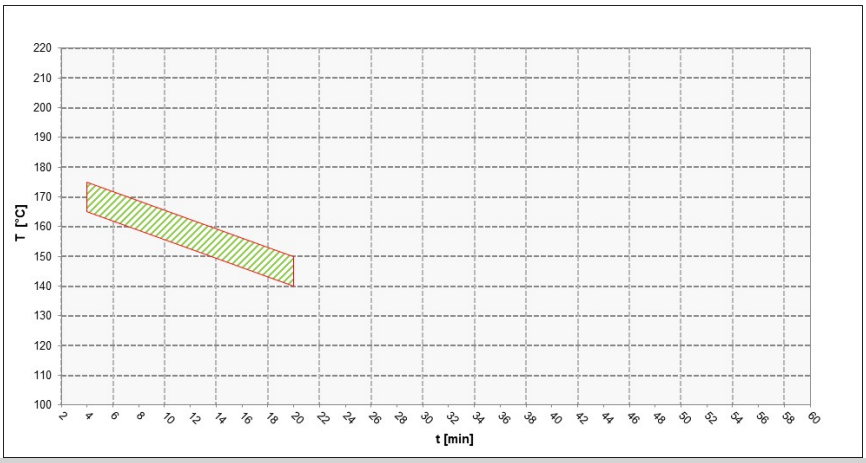

Resistance to storage

- 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.

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