FreiLacke

FREIOTHERM-Hydro-Metallic
WO1875H-Met.

Characteristics	Water-thinnable baking coating Application, e.g. in the automotive sector Metallic effect Good mechanical resistance Good condensation resistance	
Technical / Physical Data	Binder-Base	Combination of acrylate/amino resin
	Colour	Metallic colour shades
	Gloss value DIN EN ISO 2813	satin glossy 55-65 Angle 60°
	Viscosity DIN 53211 (formerly)	Flow time 40-50 seconds 4 mm viscosity cup
	Thinner	demineralised water
	pH-Value	7,9-8,1
	Density calculated	1,02-1,04 g/ml
	Solid Mass calculated	22-26 %
	Solid content in volume calculated	190-210 ml/kg
	Material usage theoretical, without application loss	95-105 g/m², Layer thickness 15 µm
	Reference colour of the specified values	Colour of WO1875HK2442
Substrate	KTL primed	
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. Chromating or corresponding chrome-free conversion coatings.	
Structure recommendation	Substrate	on chromated aluminium plate
	Primer	KTL-Grundierung Dry film thickness 20-30 µm
	Top coat	WO1875HK2442 Dry film thickness 20 µm
Mechanical Test	Cross-cut-test DIN EN ISO 2409	Gt 0
	Stone chipping test DIN EN ISO 20567-1	Characteristic value <2
Resistance Test	Condensate constant climate DIN EN ISO 6270-2 (CH)	120 hours Degree of blistering 0 (S 0)

DIN EN ISO 9001
IATF 16949
EMAS

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		DIN EN ISO 4628-2
	Salt spray test (CASS) DIN EN ISO 9227	96 hours Water ingress Wb < 2 mm DIN EN ISO 4628-8
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.	
	Object temperature	10-30 °C
	Processing conditions	Room temperature 15-25 °C Relative humidity 50-70 %
	High pressure spraying	as delivered viscosity Nozzle: 1,2 mm Spray pressure 4 bar
	Electrostatic	possible, system-specific
	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	10 min./ 130 °C - 7 min./ 150 °C
	Object temperature Baking window on request	
Resistance to storage	Approx. 6 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.	

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