

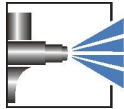


FREIOTHERM-Hydro-Refill-Paste

WO1826H

Characteristics	<ul style="list-style-type: none">Water-thinnable baking coatingApplication, e.g. in the construction and sanitary sectorVery good mechanical resistanceGood condensation resistanceGood adhesion to steel and non-ferrous metalsCan be coated over with powder coatingsFor interior use	
Technical / Physical Data	<ul style="list-style-type: none">Binder-Base	Combination of acrylate/amino resin
	<ul style="list-style-type: none">Colour	All common colour shades
	<ul style="list-style-type: none">Gloss value visual	satin glossy
	<ul style="list-style-type: none">Viscosity	3500-5500 mPa.s/ Spindle 5 60 revolution/ min.
	<ul style="list-style-type: none">Thinner	demineralised water
	<ul style="list-style-type: none">pH-Value	8,7-9,2
	<ul style="list-style-type: none">Density calculated	1,20-1,25 g/ml
	<ul style="list-style-type: none">Solid Mass calculated	67-69 %
	<ul style="list-style-type: none">Solid content in volume calculated	450-480 ml/kg
	<ul style="list-style-type: none">Material usage theoretical, without application loss	110-130 g/m², Layer thickness 60 µm
	<ul style="list-style-type: none">Reference colour of the specified values	Colour of WO1826HRU916
Substrate	<ul style="list-style-type: none">Steel	
	<ul style="list-style-type: none">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	<ul style="list-style-type: none">Substrate	on iron-phosphated steel plate
	<ul style="list-style-type: none">Primer	WO1826HRU916 Dry film thickness 15 µm
	<ul style="list-style-type: none">Top coat	PB6704ARG916 Dry film thickness 60 µm
Mechanical Test	<ul style="list-style-type: none">Cross-cut-test DIN EN ISO 2409	Gt 0

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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Resistance Test

- Condensate constant climate 540 hours
DIN EN ISO 6270-2 (CH) Degree of blistering 0 (S 0)
DIN EN ISO 4628-2

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 50 µm - risk of reaction bubbles.
- Object temperature 10-30 °C
- Processing conditions Room temperature 18-25 °C
Relative humidity 40-60 %
- Immersing 14-20 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.

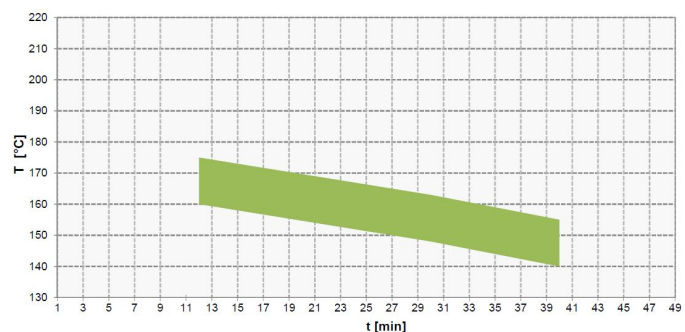
Health & Safety at Work guidelines

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 - 15 min./ 170 °C
- Object temperature**
green cross-hatching = baking conditions with good final properties

Objekt Temperatur °C Object Temperature °C	150	160	170
Haltezeit Minimum Minuten Holding time minimum Minutes	45	20	15
Haltezeit Maximum Minuten Holding time maximum Minutes	90	60	30

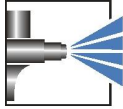


Resistance to storage

- 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.

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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.