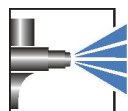


Hydro-Basecoat

WO1828M / RRS W03

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the automotive sector ■ Metallic effect ■ Good stone chip resistance ■ Can be coated over with powder coatings 																				
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of acrylate/polyester/amino resin</td> </tr> <tr> <td>■ Colour</td> <td>Metallic colour shades</td> </tr> <tr> <td>■ Gloss value visual</td> <td>mat</td> </tr> <tr> <td>■ Viscosity DIN 53211 (formerly)</td> <td>Flow time 14-16 seconds 4 mm viscosity cup</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,2-8,4</td> </tr> <tr> <td>■ Density calculated</td> <td>1,00-1,02 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>6-10 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>50-70 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>140-170 g/m², Layer thickness 10 µm</td> </tr> </table>	■ Binder-Base	Combination of acrylate/polyester/amino resin	■ Colour	Metallic colour shades	■ Gloss value visual	mat	■ Viscosity DIN 53211 (formerly)	Flow time 14-16 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,2-8,4	■ Density calculated	1,00-1,02 g/ml	■ Solid Mass calculated	6-10 %	■ Solid content in volume calculated	50-70 ml/kg	■ Material usage theoretical, without application loss	140-170 g/m ² , Layer thickness 10 µm
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Substrate	<ul style="list-style-type: none"> ■ Light alloy wheels 																				
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. Chromating or corresponding chrome-free conversion coatings. 																				
Structure recommendation	<table border="1"> <tr> <td>■ Substrate</td> <td>on light alloy wheels</td> </tr> <tr> <td>■ Primer</td> <td>RRS PRIMER Dry film thickness 90 µm</td> </tr> <tr> <td>■ Base coat</td> <td>RRS W03 Dry film thickness 10 µm</td> </tr> <tr> <td>■ Clear coat</td> <td>RRS CLEARCOAT AC / PR Dry film thickness 70 µm</td> </tr> </table>	■ Substrate	on light alloy wheels	■ Primer	RRS PRIMER Dry film thickness 90 µm	■ Base coat	RRS W03 Dry film thickness 10 µm	■ Clear coat	RRS CLEARCOAT AC / PR Dry film thickness 70 µm												
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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.



Hydro-Basecoat WO1828M / RRS W03

	DIN EN ISO 6270-2 (CH)	Degree of blistering 0 (S 0) DIN EN ISO 4628-2
	■ Salt spray test (CASS) DIN EN ISO 9227	240 hours Water ingress Wb < 1 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	60 °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-onequipmentwith org. solvents, e.g. RRS SOLV 4320
	■ 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	■ Intermediate drying	10 min./ 120 °C
	■ Oven drying	10 min./ 170 °C - 20 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.	