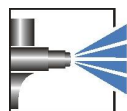


Hydro-Basecoat
WO1840M

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the automotive sector ■ Metallic effect ■ Good stone chip resistance ■ Good sanding mark coverage ■ Can be coated over with powder coatings 																				
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Polyurethane resin dispersion</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>7,9-8,1</td> </tr> <tr> <td>■ Density calculated</td> <td>0,99-1,01 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>4-6 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>40-50 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>100-125 g/m², Layer thickness 5 µm</td> </tr> </table>	■ Binder-Base	Polyurethane resin dispersion	■ 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	7,9-8,1	■ Density calculated	0,99-1,01 g/ml	■ Solid Mass calculated	4-6 %	■ Solid content in volume calculated	40-50 ml/kg	■ Material usage theoretical, without application loss	100-125 g/m ² , Layer thickness 5 µm
■ Binder-Base	Polyurethane resin dispersion																				
■ 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	7,9-8,1																				
■ Density calculated	0,99-1,01 g/ml																				
■ Solid Mass calculated	4-6 %																				
■ Solid content in volume calculated	40-50 ml/kg																				
■ Material usage theoretical, without application loss	100-125 g/m ² , Layer thickness 5 µm																				
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 W04 Dry film thickness 5 µm</td> </tr> <tr> <td>■ Clear coat</td> <td>RRS CLEARCOAT AC / PE Dry film thickness 70 µm</td> </tr> </table>	■ Substrate	on light alloy wheels	■ Primer	RRS PRIMER Dry film thickness 90 µm	■ Base coat	RRS W04 Dry film thickness 5 µm	■ Clear coat	RRS CLEARCOAT AC / PE Dry film thickness 70 µm												
■ Substrate	on light alloy wheels																				
■ Primer	RRS PRIMER Dry film thickness 90 µm																				
■ Base coat	RRS W04 Dry film thickness 5 µm																				
■ Clear coat	RRS CLEARCOAT AC / PE Dry film thickness 70 µm																				
Mechanical Test	<table border="1"> <tr> <td>■ Cross-cut-test DIN EN ISO 2409</td> <td>Gt 0</td> </tr> <tr> <td>■ Stone chipping test DIN EN ISO 20567-1</td> <td>Characteristic value <2</td> </tr> </table>	■ Cross-cut-test DIN EN ISO 2409	Gt 0	■ Stone chipping test DIN EN ISO 20567-1	Characteristic value <2																
■ Cross-cut-test DIN EN ISO 2409	Gt 0																				
■ Stone chipping test DIN EN ISO 20567-1	Characteristic value <2																				
Resistance Test																					

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

WO1840M / RRS W04

	<ul style="list-style-type: none"> ■ 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 (CASS) DIN EN ISO 9227 240 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8
Processing and application	<ul style="list-style-type: none"> ■ 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-onequipment with 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	<ul style="list-style-type: none"> ■ 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	<ul style="list-style-type: none"> ■ 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. <p>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.</p>
Specific comments	<ul style="list-style-type: none"> ■ 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. <p>The information provided here contains reference values and does not constitute a specification.</p>