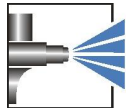


Hydro-Clearcoat

WO1868MRA999 / RRS W CLEARCOAT M

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable baking coating ■ Application, e.g. in the automotive sector ■ Good mechanical resistance ■ Good light and weather resistance ■ Good chemical resistance ■ Good scratch resistance 																				
Technical / Physical Data	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Combination of acrylate/amino resin</td> </tr> <tr> <td>■ Colour</td> <td>colourless</td> </tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td> <td>mat 20-26 Angle 60°</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>8,2-8,5</td> </tr> <tr> <td>■ Density calculated</td> <td>1,01-1,03 g/ml</td> </tr> <tr> <td>■ Solid Mass calculated</td> <td>25-27 %</td> </tr> <tr> <td>■ Solid content in volume calculated</td> <td>220-240 ml/kg</td> </tr> <tr> <td>■ Material usage theoretical, without application loss</td> <td>125-135 g/m², Layer thickness 30 µm</td> </tr> </table>	■ Binder-Base	Combination of acrylate/amino resin	■ Colour	colourless	■ Gloss value DIN EN ISO 2813	mat 20-26 Angle 60°	■ Viscosity DIN 53211 (formerly)	Flow time 14-16 seconds 4 mm viscosity cup	■ Thinner	demineralised water	■ pH-Value	8,2-8,5	■ Density calculated	1,01-1,03 g/ml	■ Solid Mass calculated	25-27 %	■ Solid content in volume calculated	220-240 ml/kg	■ Material usage theoretical, without application loss	125-135 g/m ² , Layer thickness 30 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 120 µm</td> </tr> <tr> <td>■ Base coat</td> <td>RRS W / S Dry film thickness 20 µm</td> </tr> <tr> <td>■ Top coat</td> <td>RRS CLEARCOAT AC Dry film thickness 80 µm</td> </tr> <tr> <td>■ Clear coat</td> <td>RRS W CLEARCOAT M Dry film thickness 30 µm</td> </tr> </table>	■ Substrate	on light alloy wheels	■ Primer	RRS PRIMER Dry film thickness 120 µm	■ Base coat	RRS W / S Dry film thickness 20 µm	■ Top coat	RRS CLEARCOAT AC Dry film thickness 80 µm	■ Clear coat	RRS W CLEARCOAT M Dry film thickness 30 µm										
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Mechanical Test	<ul style="list-style-type: none"> ■ Cross-cut-test DIN EN ISO 2409 <p>Gt 0</p>																				

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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WO1868MRA999 / RRS W CLEARCOAT M

	<ul style="list-style-type: none"> Stone chipping test DIN EN ISO 20567-1 	Characteristic value 1
	<ul style="list-style-type: none"> 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. 	
	<ul style="list-style-type: none"> Object temperature 	40-60 °C
	<ul style="list-style-type: none"> Processing conditions 	Room temperature 15-25 °C Relative humidity 50-70 %
	<ul style="list-style-type: none"> High pressure spraying 	as delivered viscosity Nozzle: 1,3 mm Spray pressure 3 bar
	<ul style="list-style-type: none"> Electrostatic 	possible, system-specific
	<ul style="list-style-type: none"> ESTA high rotation 	as delivered viscosity
	<ul style="list-style-type: none"> 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
	<ul style="list-style-type: none"> 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"> Oven drying 	10 min./ 170 °C
	<ul style="list-style-type: none"> Object temperature Baking window on request 	
Resistance to storage	<ul style="list-style-type: none"> Approx. 9 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	<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. 	
		The information provided here contains reference values and does not constitute a specification.