

Starting Point Formulation No: 3.4045-2

Water thinnable, air drying „one coat system“,
 based on WorléeSol 61E & WorléeSol E 330 W

WorléeSol 61E	75% ethoxy propanol	11.80 (Worlée)
Ammonia	25%	0.40
Butyl glycol		1.00
Water		14.10
Kronos 2190		25.50 (Kronos)
Zinc phosphate ZP10		6.50 (Heubach)
Alcophor 827		0.70 (Cognis)
30 min Pearlmill		
Water (for rinsing)		1.40
WorléeSol E 330 W	42% water	35.10 (Worlée)
Additol VXW 4940	1:1 in water	1.60 (Cytec)
DSX 1514		0.10 (Cognis)
DSX 2000		0.30 (Cognis)
WorléeAdd 458	38% water	1.00 (Worlée)
WorléeAdd 340	100%	<u>0.50 (Worlée)</u>
		<u>100.00</u>

pH-value (adjust with ammonia if necessary)		7.5 – 8.5
Viscosity DIN4/53211 4mm		approx. 100s
VOC	excl. water	112 g/l
	incl. water	54 g/l
100 µm on glass		
dust free		approx. 20 min
tack free		approx. 120 min
Gloss < 60°		80 GU