

**Starting Point Formulation No: 3.3894-2**

Water thinnable, air drying topcoat , orange,  
 based on WorléeSol E 330 W

<b>WorléeSol E 330 W</b>	42 % water	26,40 (Worlée)
Butyl glycol		5,00
Disperbyk 190		2,80 (Byk)
Tego Airex 902 W		0,50 (Evonik Tego Chemie)
DSX 2000/1514*	1,00 : 0,30	0,60 (Cognis)
Paliotol yellow L 2140 HD		2,80 (BASF)
Paliogen red L 3910		0,60 (BASF)
Kronos 2190		1,90 (Kronos)

-- 45 min pearl mill ,

Water ( for rinsing ) 3,00

<b>WorléeSol E 330 W</b>	42 % water	56,10 (Worlée)
Additol VXW 4940*	1:1 water	2,30 (Cytec)
<b>WorléeAdd 340</b>		0,60 (Worlée)
DSX 2000/1514*	1,00 : 0,30	<u>0,10</u> (Cognis)

102,70

\*Add under agitation

pH-value	7,0 - 8,0
Viscosity Krebs Stormer ( adjust with water)	~ 100 KU
VOC	incl. water 53 g/l excl. water 121 g/l
100 µm on glass	
dustfree	approx. 30 min
tackfree	approx. 2 h
Gloss < 20°/ 60°	86 / 93 GU
Pendulum hardness König after 24 h / 7 d	56 / 105 s
Water resistance after 24 h	very good

**Worlée - Chemie G.m.b.H.**

ATA - 3 - water thinnable systems  
 update: September 2008