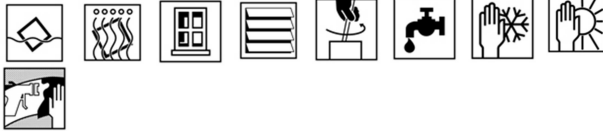


Cetol WM 665



Product description

Waterborne, highly transparent mid coat for wooden constructions, exterior and interior.
- good run-off properties
- good pore wetting
- high transparency

Colour

Colourless

Binder type

Acrylate

Density (specific weight)

approx. 1.00 - 1.03 kg/l

Packaging

20 l, 120 l

Processing

dipping, flow-coating
Processing viscosity is approx. 12 seconds in a DIN cup 4 mm or approx. 28 - 32 seconds in a ISO cup 3 mm at 20 °C material temperature.

Consumption

80 - 120 ml/m², depending on application method, type and absorption of timber (exact values must be established by tests).

Thinning

Ready to use.
If necessary, with 10% of water.

Application temperature

15 - 25 °C for substrate, air and material at approx. 60 % R.H.

Drying time

Drying at:	Standard atmosphere: 23 °C / 50% rel. humidity	Forced at 40 °C
Dust dry	approx. 30 minutes	approx. 30 minutes
Sandable	approx. 4 hours	approx. 60 minutes
Recoatable	approx. 4 - 6 hours	approx. 1 - 2 hours

Drying

The drying process of the coating depends on the applied film thickness and may be delayed when using timber with a high extractive contents or drying in damp/cold conditions. During the drying process, always ensure for adequate temperature and ventilation. If the drying conditions are not met, damages within the coating cannot be excluded.

Cleaning of equipment

Clean with water immediately after use and, if required, add some commercially available washing-up liquid or ST 830.

Storage

The minimum shelf life in the unopened original container is two years; Storage temperature +5 - +30 ° C.
After expiry of the BBD, the product may still be processable, but the product properties may differ from "fresh" material. For that reason, the user must apply expired material with particular attention.
Started containers must be closed carefully! Store in a cool but frost-free place. Dipping tanks containing material must be covered correctly and stirred or circulated regularly.

Disposal

Only empty containers may be recycled. Dispose of material residues according to local regulations. The EC waste code applicable to such material is: 08 01 12

Safety Data Sheet

Further data in the Material Safety Data Sheet according to 91/155/EEC www.sikkens-wood-coatings.com Downloads Safety Data Sheets

Warning

Before use, read the identification and product information. Always follow customary protection measures, even when working with low emission products.
Dipping tanks or reservoirs: when using metal reservoirs, we recommend using stainless steel, e.g., V2A, the use of other materials may cause corrosion.

VOC Directive

EU limit value for this product (cat. A/e): 150 g/l (2007)/130 g/l (2010). This product contains max. 50 g/l VOC.

General instructions

The wood moisture content for the application of Sikkens coating systems should be between 12 % and 15 %. The selected wood, the design and the applied layer thicknesses must comply with current technical standards. All horizontal surfaces shall be bevelled by 15 ° and all edges shall be rounded with a radius of at least 2 mm. Joints and open end grains must be sealed to prevent the ingress of water into the structure. The substrates must be dry, free from dust and grease. The selection and application of the coating, especially the colour shade, is important, too. Dark coatings in the exterior may lead to an elevated surface temperature (up to 80 °C).
To ensure correct adhesion of the following coating system, the paint system should not be sanded down to the substrate.

For use in technical industrial companies. Only to be used in approved and recommended Sikkens Wood Coatings coating systems.

Products from AkzoNobel Wood Coatings are exclusively produced for professional and industrial users, who have a basic knowledge of the handling and application of chemical/technical products for surface design. The processing instructions for reaching the qualities given in the leaflets should be regarded as non-binding recommendations and do not constitute any warranty. These recommendations are based on our experiences, including test series, and should facilitate and promote the work of our clients. Any potential deviation from ideal working conditions is within the responsibility of our clients and may affect the (end) result of the application. The purchaser is not relieved from his duties to inspect the product and its suitability for the surface to be processed, preferably through trial processing. If in any doubt as to the handling or processing of the purchased product, our material experts as well as our application and laboratory technicians will help you to the best of their ability.

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Notes

The coating system mentioned here is only an example; other systems are possible. Please refer to the relevant Technical Data Sheets and ask your Sikkens Wood Coatings Sales Representative or the factory for advice about coating systems.

Foam formation during application can be reduced by using defoamer WV 890. For information concerning the dosage, please see the relevant Technical Data Sheet.

Coating system : Stable wooden constructions

Impregnation	Cetol WV 880 BPD
Primer	Cetol WP 566 Rubbol WP 194
Mid coat	Cetol WM 665
Top coat	Cetol WF 952 / WF 957 Cetol WF 945 / WF 960 / WF 965 Cetol WF 980 Rubbol WF 378 / WF 380 Rubbol WF 382 / WF 387

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