



Schilling inc.
INKS & COATINGS

WBC 4000 Hydrodur Gloss Coatings for Glass

TECHNICAL DATA SHEET

Product:

WBC 4000 is a decorative and protective coating for glass and ceramic based on one-component epoxy technology. WBC 4000 is available as a clear base which can be used as a clear coat, tinted with Schilling's WBT Waterborne Tinters, or can be supplied fully formulated in any transparent or opaque color. WBC 4000 is suitable for decorative glassware, art deco tile, ceramic for bath and interior decoration, and as a sublimation base. Notable features of this product include:

- Superior chemical and color bleed resistance, including during water submersion
- Excellent dishwasher resistance
- Low VOC and HAPs Free
- Superior abrasion resistance in filling line applications and transit

Handling and Application:

Store in a cool dry place out of direct sunlight. Do not allow to freeze. Prior to application, mix well, but do not shake. Surfaces to be coated should be clean and dry. Flame treatment may optionally be used on surfaces prior to application, and coating may optionally be flame treated after curing for enhanced inter-coat adhesion between ink and coating film.

Cure Schedule	Flash off then 300-380 for 10-30 minutes convection, 3-5 minutes infrared. Cure schedule may vary with color, glass thickness, coating application thickness, and specific line configuration.
Application	Spray, Air Atomized or HVLP
Reduction	Pure Water
Viscosity @77F	20-25" #4 Ford—Other viscosities available upon request
Substrate	Clean Glass or Ceramic
Film Thickness	0.4-0.7 mil DFT
Coverage	780 square feet per gallon at 0.5 mil DFT
Clean Up	Water Clean Up. Glycol Ether EB or other organic solvents may also be used on dry residue.

Physical Properties

Density	8.5-10.0 lb/gal. Density varies with color.
Solids	24-26% volume solids. 27-29% weight solids. Solids content varies with color.
VOC and HAPs	0.9 lbs/gal as supplied. 2.5 lbs/gal minus exempt. HAPs free.

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