



dipping



flow coating



for windows



limited dimension  
stable wooden  
constructions



stir before use



water thinnable



store and transport  
in a frost free area



store in a cool place



cleaning of  
equipment with  
water

**sikkens**  
WOOD COATINGS

## Cetol WM 665

**Product description** Waterborne, highly transparent mid coat for wooden constructions interior and exterior

- ready to use
- good run-off properties
- good pore wetting
- high transparency

**Colour** Colorless

**Binder type** pure acrylic dispersion

**Packaging** 20 L, 120 L

**Processing** dipping, flow-coating

Working viscosity is approx. 12 seconds in a DIN cup 4 mm i.e. approx. 28 - 32 seconds in a ISO cup 3 mm at 20° C material temperature.

**Consumption** 80 - 120 ml/m<sup>2</sup>, depending on application method, type and absorption of timber (exact values must be established via sample).

**Thinning** If necessary with max. 10% water.

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

**Drying times** Drying at 23 °C / 50 % R.H.

Dust dry: after approx. 30 minutes

Sandable: after approx. 4 hours

Recoatable: after approx. 4 - 6 hours waterborne

The drying process of the coating depends on the applied wet film thickness and can extend when using timber with a high extract contents or drying in damp/cold conditions. During the drying process one should ensure for adequate temperature and ventilation.

If the drying conditions are not upheld, damages within the coating cannot be warranted.

**Cleaning of equipment** Clean directly after use with water, if needed with washing up liquid or with ST 830.

**Storage** A dipping tank containing material must be covered correctly and stirred or circulated regularly.

The minimum storage stability of sealed containers is 2 years.

Storage temperature: +5 - +30 °C.

After ending of the storage time the product still can be usable, but some attributes may vary from new product.

Therefore such over-stored product has to be applied with special attention.

Opened cans must be sealed correctly! Store in a cool but frost-protected area.

**Disposal** Only residue emptied cans can be disposed via recycling. Liquid wastes must be disposed of according to national regulations or according to EU-disposal key 08 01 12.

**Hazard identification** In accordance with EC guide lines - Material safety data sheet, point 15.

**Warning** Dipping tanks or reservoirs: when using metal reservoirs, we recommend using None rusting steel i.e. V2A, the use of other materials can lead to corrosion.

Before use, read the identification and product information. Even when working with low emission products one should take care of the customary protection measures.

**General instructions** The wood moisture content for the application of Sikkens coating systems should be between 12 % and 15 %.

According to the guidelines for window coating systems, published by the Federal German Committee for Paint and Material Value Protection (Instruction Leaflet No. 18), of VOB, Part C, DIN 18363, and the recommendations of the German Institute for Window Technology e.V. in Rosenheim, all wooden constructions in buildings must be coated on all sides with at least one primer and one intermediate coat (minimum dry film thickness 30 µm) before they are incorporated in buildings. The choice and use of the coating system, especially the colour shade, should also be taken into account. Darker shades can increase the surface temperature (up to 80 C).

For use in a technical industrial companies and exclusively released for Sikkens systems recommendations.

To ensure a correct adhesion of the following coating system, the paint system should not be sanded down to the substrate.

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

**Relevant information** The here mentioned coating system is only an example, other systems are possible.

All external materials (i.e. fillers, tapes, sealing compounds, cleaners) must be checked for compatibility with the coating system before use.

Please observe the relevant Technical Data Sheets or seek advice from the Sikkens sales representative or contact the technical centre.

Foam formation during application can be reduced by using defoamer WV 890.

For information concerning the dosage, please see the relevant Technical Data Sheet.

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**System structure: Dimensional stable wooden constructions**

Impregnation	Impregnation for the wood resistance class 3-5. Do not use more than one BPD-product in ONE system. Cetol WV 885 BPD+ Cetol WV 880 BPD
Primer	Rubbol WP 194 Cetol WP 566
Mid coat	Cetol WM 665
Top coat	Rubbol WF 382 Rubbol WF 380 Rubbol WF 378 Cetol WF 980 Cetol WF 965 Cetol WF 960 Cetol WF 957 Cetol WF 952 Cetol WF 945 Rubbol WF 387

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