

# FREIOTHERM

## Apply-Coating KO1810

- Transparent baking coating with solvent
- In processing viscosity
- Oven drying at 150 °C object temperature possible
- For multi-coat system, "wet on wet" application, especially suited to motor-car accessories, e.g. light alloy wheels

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	acylate - melamin resin
	<b>Colour</b>	different colour transparent
	<b>Gloss</b> visual	satin glossy
	<b>Original viscosity</b> DIN 53211*	14 to 18 sec. / 4 mm cup
	<b>Density</b> calculated	1,0 g / ml + / - 0,1
	<b>Solid content</b> calculated	28 % + / - 3
	<b>Solid content in volume</b> calculated	245 ml / kg + / - 5
	<b>Spec. resistance</b> „Ransburg“ - testing tool	300 to 600 K-Ohm
	<b>Spreading rate</b> calculated in original viscosity, without application loss	30 to 50 g / m <sup>2</sup> dry film thickness 20 to 30 µm see „Special remarks“

**Storability**      Approx. 18 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective

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**Processing and application**

**Application**

Stir up before the use carefully (e.g. with high-speed mixer).

electrostatic-spraying: e.g. high-rotation process, bell-type equipment, in original viscosity

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**Substrates**

light alloy wheels

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**Pretreatment**

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

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**Proposal for a coating system**

primer:	FREOPOX-Powder Coating	PB6405B
clear laquer:	FREOPOX-Powder Coating	PT1005BRA999
apply-Coating:	FREIOTHERM- Apply-Coating	KO1810
clearcoat	FREIOTHERM-HighSolid-Clearcoat	KO1853VRA999

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**Application temperature**

above 15 °C

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**Drying**

oven drying: minimum 5 min. / 150 °C (object temperature)

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**Cleaning of working equipment**

EFD-Thinner 400320

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**Advise for safety protection and protection of health**

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

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**Special remarks**

**Test condition**

\*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered. Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please do not hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.