

FREIOTHERM

Coating KO1835PP1957

P= Custom specific attitudes for PT Pakoakuina

- Solvent borne metallic top coat resistance
- For high surface demand (high scratching resistance)
- Good chemical resistance
- For motorcycle-light alloy wheels

Technical / Physical data	Resin/ binder	acylate - melamin resin
	Colour	white
	Gloss DIN 67530 and DIN EN ISO 2813	glossy 70 to 80 geometry 20°
	Original viscosity DIN 53211*	50 to 60 sec. / 4 mm cup
	Spec. resistance „Ransburg“ – testing tool In spraying viscosity	400 to 800 k Ohm
	Thinner	long attitude = EFD-Thinner 400190 or short attitude = EFD-Thinner 400198
	Density calculated	1,30 g / ml +/- 0,1
	Solid content calculated	65 % +/- 5
	Solid content in volume calculated	375 ml / kg +/- 10
	Consumption calculated in original viscosity, without application loss	80 to 85 g /m ² dry film thickness 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

Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).

spraying-high-pressure: after viscosity adjustment 20 to 22 sec.
nozzle: 1,2 to 1,5 mm spraying pressure: 3 to 5 bar

Substrates

motorcycle-light alloy wheels

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.

Proposal for a coating system

substrate:	pretreated aluminium	
topcoat	FREIOTHERM-Coating	KO1835PP1957

Application temperature

above 10 °C

Drying

oven drying: 15 min. / 150 °C or 10 min. / 160 °C or 5 min. / 170 °C (object temperature)

Cleaning of working equipment

EFD-Thinner 400500

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.

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.