

# FREIOTHERM

## HighSolid-clear laquer KO1853VRA999

(V = Variation to the existing standard system)

- Solvent-based clear laquer
- High solid state 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>	colourless
	<b>Gloss</b> visually	high gloss
	<b>Original viscosity</b> DIN 53211*	24 to 30 sec. / 4 mm cup
	<b>Thinner</b>	EFD-Thinner 400198 "short" or EFD-Thinner 400190 "long"
	<b>Density</b> calculated	1,00 g / ml + / - 0,1
	<b>Solid content</b> calculated by weight	51 % + / - 2
	<b>Solid content in volume</b> calculated by weight	455 ml / kg + / - 5
	<b>Spec. resistance</b> „Ransburg“ – testing tool	300 bis 600 K Ohm
	<b>Spreading rate</b> calculated in original viscosity, without application loss	45 to 65 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 15 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 usage is essential due to quality guaranty reasons.

## Processing and application

### Application

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

pneumatic-spraying:	after viscosity adjustment to 18 to 22 sec. nozzle: 1,2 to 1,8 mm spraying pressure: 3 to 4 bar
low pressure spraying (HVLP):	after viscosity adjustment to 18 to 22 sec. nozzle: 1,2 to 1,8 mm spraying pressure: 3 to 4 bar
electrostatic-spraying:	e.g. high-rotation process, bell-type equipment after viscosity adjustment to 16 to 20 sec.

### Substrates

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

primer:	FREOPOX-Powder coating	PB6005AS2125
base laquer:	FREIOTHERM-Metallic-Base laquer	KO1805 / KO1806 / KO1807 or
	FREIOTHERM-HighSolid-Base laquer	KO1808
clear laquer:	FREIOTHERM-HighSolid-clear laquer	KO1853VRA999

### Application temperature

above 15 °C

### Drying

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

### Cleaning of working equipment

EFD-Thinner 400320

### 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.