

FREIOPLAST

paint
KP1014

- Solvent-based paint
- For coating in thick layer possible
- For one or multicoat suitably

Technical Physical data	Resin/ binder	mix polymerisat		
	Colour	acc. to RAL 840 HR other colour shades on request		
	Gloss value DIN 67530	semi mat	30 to 50	geometry 85°
	Original viscosity „Haake-Viskostester“	1300 to 1800 mPa.s / spindle 1		
	Thinner	EFD-thinner	400320	
	Density calculated	1,15 g / ml	+ / - 0,1	
	Solid content calculated	52 %	+ / - 2	
	Solid content in volume calculated	310 ml / kg	+ / - 20	
	Consumption calculated in original viscosity, without application loss	150 to 170 m ² / kg dry film thickness 50 µm		

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

spraying-airless: after viscosity adjustment to 60 to 120 sec. / 4mm cup DIN 53211
nozzle: 0,33 to 0,45 mm spraying pressure: 120 to 150 bar

spraying-pneumatic: after viscosity adjustment to 30 to 60 sec. / 4mm cup DIN 53211
nozzle: 1,4 to 2,0 mm spraying pressure: 3 to 5 bar

by brush: in original viscosity

by dipping: after viscosity adjustment to 20 to 50 sec. / 4mm cup DIN 53211

Substrates

aluminium, stainless steel, steel, zinc coated surfaces
When coating plastics, e.g.: ABS, polystyrene and zinc we recommend preliminary tests (e.g. adhesion)

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: steel
top coat: FREIOPLAST-paint KP1014 2x

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 30 to 40 min.	(degree of drying 1	/ DIN 53150)
dry to touch:	after 2 to 4 h	(degree of drying 4	/ DIN 53150)
complete dry:	after 2 to 4 days	(swinging beam hardness	/ ISO 1522)

oven drying:	to 50°C possible	(object temperature)
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Repair coating

after sanding with the same system

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

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on white paint.

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 don't hesitate to contact us.

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