

FREIOPLAST

Coating KP1613L

- Coating with solvent
- For coating in thick layer possible
- For one or multicoat suitably
- Corrosion protection
- Adhesion on different substrates

Technical / Physical Data	Resin/ binder	Acryl-Copolymerisat
	Colour	acc. to RAL 840 HR FREIOPLAST-Conatiner-Colour map other colour shades on request
	Gloss value DIN 67530 and DIN EN ISO 2813	mat 31 to 56 geometry 85°
	Original viscosity DIN 53211*	60 to 65 Sek./ 4 mm cup
	Thinner	EFD-Thinner 400320
	Density calculated	1,25 g / ml +/- 0,1
	Solid content calculated	54 % +/- 2
	Solid content in volume calculated	295 ml / kg +/- 20
	Consumption calculated in original viscosity, without application loss	160 to 180 g / m ² 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

Stir up before the use carefully (e.g. with high-speed mixer).
 spraying-pneumatic: after viscosity adjustment to 30 to 60 sec.
 nozzle: 1,4 mm spraying pressure: 5 bar
 nozzle: 2,0 mm spraying pressure: 3 bar

Substrates

steel, aluminium, stainless steel, , zinc coated surfaces
 When coating zinc surfaces and aluminium 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	
primer:	FREOPOX-Primer	ER1912V or FREOLUX-Primer KL1709
top coat:	FREIOPLAST-Coating	KP1613L

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 80°C possible	(object temperature)

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

*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.
 The statements concerning efficiency, drying and caution labelling depend on colour shade.
 The values mentioned in this data sheet are based on KP1613LRA910, RAL 9010 pure white, mat.
 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.