

FREIOTHERM

Adhesion Coating KO1837GR999A

- Solvent containing coating
- Ready to use
- Good mechanical resistance
- Especially suited to motor-car accessories, e.g. light alloy wheels

Technicalb / Physical data	Resin/ binder	Polyester
	Colour	colourless
	Gloss visually	satin glossy
	Original viscosity DIN 53211*	12 to 18 sec. / 4 mm cup
	Thinner	use without thinner - do not thin the coating !
	Density calculated	1,0 g / ml + / - 0,1
	Solid content calculated	17 % + / - 2
	Solid content in volume calculated	175 ml / kg + / - 5
	Object temperatue	40 to 70 °c
	Spreading rate calculated in original viscosity, without application loss	60 to 120 g / m ² dry film thickness 5 to 20 µm see „Special remarks“

Storability Approx. 9 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 usage is essential due to quality guaranty reasons.

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Processing and application

Application

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

pneumatic-spraying:	in original viscosity nozzle: 1,2 to 1,8 mm	spraying pressure: 3 to 4 bar
low pressure spraying (HVLP):	in original viscosity nozzle: 1,2 to 1,8 mm	spraying pressure: 2 to 3 bar
electrostatic-spraying:	e-g-high-rotation process, bell-type equipment, in original viscosity	

Substrates

light metal 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 1

KSL:	FREIOTHERM-Adhesion Coating	KO1837GR999A
Transparentpulver:	FREOCRYL-Powder Coating	PY1005B

Proposal for a coating system 2

KSL:	FREIOTHERM-Adhesion Coating	KO1837GR999A
Transparentpulver:	FREIOTHERM-Powder Coating	PT1005B
Clear coat:	FREIOTHERM-HighSolid-Clearcoat	KO1853

Application temperature

above 15 °C

Drying

Intermediate drying KSL : 10-20 Min. / 150-200°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.