

FREIOPLAST

Coating

KP1699HL1349

- Solvent-base, acid-hardening paint
- Fast initial and through drying
- Good adhesion on steel
- Temperature stability at short time upto maximally 200°C

Technical / Physical Data

Resin/ binder	mixpolymerisate
Colour	anthracite grey L1349 other colour shades on request
Gloss value DIN 67530 and DIN EN ISO 2813	satın mat 20 to 40 geometry 60°
Original viscosity DIN 53211*	60 to 70 Sek. / 4 mm cup
Mixing ratio	5 %
Hardener base	FREOLUX-Reacton-Hardener HS0917 acid-hardener/ phosphor-acid
Thinner	EFD-Thinner 400424
Density calculated	0,95 g / ml +/- 0,1
Solid content calculated	23 % +/- 2
Solid content in volume calculated	190 ml / kg +/- 10
Consumption calculated, in original viscosity, without application loss	160 m ² / kg dry film thickness 30 µm
Spreading rate calculated, after hardener addition in original viscosity, without application loss	6,3 m ² / kg dry film thickness 30 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 hardener addition and viscosity adjustment to 20 to 30 sec.
(approx. 30% - 400424)
nozzle: 1,5 to 2,0 mm spraying pressure: 5 to 3 bar

Substrates

steel

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-Coating KP1699HL1349

Application temperature

above 10 °C

Drying

air drying at 20 °C

dust dry:	after 20 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 2 h	(degree of drying 4/ DIN 53150)
complete dry:	after 3 days	(swinging beam hardness / ISO 1522)

oven drying: to 150 °C possible (object temperature)
short term exposure up to 200 °C is possible

Repair coating

after sanding with the same system

Cleaning of working equipment

EFD-thinner 400474

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. 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.