



## KL9193H FREOLUX-System-Coating

### Product description

<b>Product technology</b>	solvent-based one-coat lacquer		
<b>Corrosion protection</b>	good		
<b>Substrate</b>	Steel, Steel, blasted		

### General product properties

<b>Binder-Base</b>	Alkyd resin		
<b>Colour</b>	in accordance with RAL 840 HR other colours on request		
<b>Gloss value</b>	satin glossy	55-70 GU, Angle 60°	DIN EN ISO 2813
<b>Viscosity</b>	Flow time 120-140 sec., 4 mm flow cup		DIN 53211
<b>Density</b>	1,0-1,2 g/ml	theoretical	
<b>Solid mass</b>	49-59 %	theoretical	
<b>Solid content in volume</b>	38-44 %	theoretical	
<b>Reference product</b>	The specified values refer to the product KL9193HP2002.		
<b>Resistance to storage</b>	approx. 18 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time.		
	The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.		

### Application and processing

<b>Pretreatment</b>	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.		
<b>Structure recommendation</b>	Substrate	Steel	
	Top coat	KL1793H	Dry film thickness 70-90 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).		
<b>Thinning</b>	EFD dilution 400500		
<b>Airless spraying</b>	as delivered viscosity		
<b>Electrostatic</b>	possible, system-specific		
<b>Material usage</b>	without application loss	210-250 g/m <sup>2</sup>	theoretical
	layer thickness	80 µm	



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<b>Oven drying</b>	up to 80 °C possible (object temperature)	
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Dust drying</b>	after 90 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 8 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 15 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500	

### Further processing of coated pieces

<b>Repainting</b>	Up to 14 days ageing: possible with same quality, do not grind first coating layer.  After 14 days ageing: with FREOLUX coating systems, grind first coating layer.
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### Comments

<b>Work-and Healthprotection</b>	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.
<b>Test conditions</b>	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.  The information provided here contains reference values and does not constitute a specification.