EFDESILK

Metal Effectcoat
KT1815M

➢ Solvent containing metal effectcoat
➢ Air drying
➢ Heat resistant:
  - blasted sheet: dry film thickness < 20 µm to 600°C (object temperature)
  - smooth steelsheet: dry film thickness < 20 µm to 300°C (object temperature)
  (see „Special remarks")

Technical / Physical Data		
	Resin/ binder	silicon resin
	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value visual	mat
	Original viscosity DIN 53211*	18 to 22 sec. / 4 mm cup
	Density calculated	0,9 g / ml + / - 0,1
	Solid content calculated	17 % + / - 2
	Solid content in volume calculated	110 ml / kg + / - 5
	Consumption calculated in original viscosity, without application loss	175 to 190 g / m² dry film thickness 20 µm see „Special remarks"
	Spreading rate calculated in original viscosity, without application loss	5,2 to 5,7 m² / kg dry film thickness 20 µm see „Special remarks"
Storability	Approx. 12 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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Metal Effectcoat
KT1815MRA906

FreiLacke

Processing and application	**Application** Before the use carefully stir up (e.g. with high-speed mixer). spraying-high-pressure: in original viscosity nozzle: 1,3 to 1,5 mm spraying pressure: 3 to 5 bar

Substrates
steel blasted, 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
subtrate: steel blasted
top coat: EFDESILK-Metal Effectcoat   KT1815M

Application temperature
above 10 °C

Drying   air drying at 20°C

dust dry:	after 30 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 8 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 3 days	(swinging beam hardness / DIN EN ISO 1522)

Cleaning of working equipment
With EFD-Thinner 400500

Advise for safety protection and protection of health
The usual precautionery 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 and drying depend on colour shade.
The values mentioned in this data sheet are based on KT1815MRA906, white aluminium an mat.

In case of smooth (not roughened) substrates adhesion test as well as the applicability of the
coating has to be performed for the respective usage. Higher temperatures as 300°C can lead to
loss of adhesion.

The best quality of the coating, the complete hardening and the mechanical working stress will
be achieved after the first heating (approx. 1 hour at 250°C)

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.