

FREIOPLAST

Paint KP1516

- Single coat paint with solvent
- Weather-resisting
- Very good adhesion characteristics on steel sheet and galvanized sheet

Technical / Physical Data	Resin/ binder	mix polymerisates
	Colour	pebble grey RAL 7032 light grey RAL 7035 acc. to RAL 840 HR other colour shades on request
	Gloss value DIN 67530 and DIN EN ISO 2813	satin mat 10 to 30 geometry 60°
	Original viscosity DIN 53211*	100 to 130 Sek. / 4 mm cup
	Thinner	EFD-Thinner 400500
	Density calculated	1,15 g / ml +/- 0,15
	Solid content calculated	48 % +/- 2
	Solid content in volume calculated	285 ml / kg +/- 10
	Spreading rate in original viscosity, without application loss	200 to 220 m ² / kg dry film thickness 60 µm see „Special remarks“

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-high-pressure:	after viscosity adjustment to 40 to 60 sec.	
	nozzle: 1,4 to 1,7 mm	spraying pressure: 3,5 to 4 bar
spraying-airless:	in original viscosity	
	nozzle: 0,33 to 0,38 mm	spraying pressure: 100 to 150 bar
by roller/ brush:	in original viscosity	

Substrates

steel, galvanized substrates

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-Paint	KP1516

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 15 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 45 min.	(degree of drying 4/ DIN 53150)
complete dry:	after 1 day	(swinging beam hardness/ ISO 1522)
oven drying:	to 80°C possible	(object temperature)

Cleaning of working equipment

EFD-Cleaner 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.

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.