

# FREOLUX

Hammer Finish  
KE1026

- Solvent contains 1-component hammer effect finish
- With silicon
- Fast drying
- Good sagging limit on vertical surfaces

<b>Technical / Physical data</b>	<b>Resin/ binder</b>	nitrocellulose-alcydresins-combination
	<b>Colour</b>	acc. to the colour shade card "Frei-Hammer-Effect-Finish" other colour shades on request
	<b>Gloss value</b> visual	satin glossy
	<b>Original viscosity</b>	4,5 to 5,5 dPa.s / Spindel 3
	<b>Density</b> calculated	1,0 g / m <sup>3</sup> +/- 0,05
	<b>Solid content</b> calculated	40 % +/- 2
	<b>Solid content in volume</b> calculated	300 ml / kg +/- 10
	<b>Material usage</b> calculated in original viscosity, without application loss	100 to 140 g / m <sup>2</sup> dry film thickness 30 to 40 µm see „Special remarks“
<b>Storability</b>	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	

## Processing and application

### Application

Stir up before the use carefully (e.g. with high-speed mixer). Spray ample material in one to two cross-coats, whereas a first thin layer will provide a closed film appearance. Avoid under any circumstances that spraying dust comes into wet surfaces.

spraying-airless: pressure of the material and nozzle size has to be taken into consideration; recommended pressure of material: 100 to 120 bar nozzle size: 0,33 to 0,38 mm (0,013 to 0,015 inch). It is eventually necessary to adjust a special effect. Necessary to adjust a special effect.

spraying-pneumatic: a medium-sized hammer effect will be obtained, spraying (atomizer) pressure: 4 to 5 bar nozzle size: 1,8 to 2 mm

spraying-electrostatic: possible

### Substrates

steel: single layer coat without any requirements to corrosion protection non ferrous metals: use only with primer coat

### 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

substrate: steel  
primer: FREIOPLAST-Primer KP1622  
top coat: FREOLUX-Hammer Finish KE1026

### Proposal for a coating system 2

substrate: non ferrous metals  
primer: FREIOPLAST-Reaction GripPrimer KP1619MRU618 or  
FREOPOX-Primer ER1912  
top coat: FREOLUX-Hammer Finish KE1026

### Application temperature

above 10 °C

### Drying

air drying at 20°C  
dust dry: after 30 min. (degree of drying 1 / DIN 53150)  
dry to touch: after 4 h (degree of drying 4 / DIN 53150)  
complete dry: after 5 days (swinging beam hardness / ISO 1522)  
oven drying: to 50°C possible (object temperature)

### Repair coating

On totally hardened coating EFDEDUR-Pre-Coating UR1900MRU910 should be used as adhesion promotor, if nec. sanding the surface.

### 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

Take care of silicone spreading in the other areas.  
See EFD-Tip No. 118 „Hammer Effect-Finish“

### Test condition

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on KE1026HHS002 silver grey, satin glossy.

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.