

# FREIOPLAST

## Metallic-Basecoat KP1645

- Metallic-Basecoat with solvent
- Air drying
- For multi-coat system
- „Wet on wet“ application
- Suited to motor-car accessories e.g.: wheel cover consisting of ABS

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	combination of acrylic and polymeric resin	
	<b>Colour</b>	metallic colour shades acc. to the automobile industrie other colour shades on request	
	<b>Gloss value</b> visual	satin mat	
	<b>Original viscosity</b> DIN 53211*	25 to 29 Sek. / 4 mm cup	
	<b>Thinner</b>	EFD-Thinner	400320 or 400500
	<b>Density</b> calculated	1,0 g / ml	+ / - 0,1
	<b>Solid content</b> calculated	25 %	+ / - 5
	<b>Solid content in volume</b> calculated	190 ml / kg	+ / - 20
	<b>Spreading rate</b> calculated in original viscosity, without application loss	70 to 95 m <sup>2</sup> / kg dry film thickness 15 to 20 µm see „Special remarks“	

**Storability**      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 usage is essential due to quality guaranty reasons.

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**Processing and application**

**Application**

Stir up before the use carefully (e.g. with high-speed mixer).

spraying-high-pressure: after viscosity adjustment to 16 to 18 sec.  
nozzle: 1,2 mm spraying pressure: 3 to 4 bar  
low pressure spraying (HVLV): after viscosity adjustment to 16 sec.

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**Substrates**

Different plastics e.g. ABS, PA  
Primer is absolutely necessary

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**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.

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**Proposal for a coating system**

primer:	EFDEDUR-Filler	UR1911MRU910
apply coat:	FREIOPLAST-Metallic-Basecoat	KP1645
protection coat:	EFDEDUR-Clearcoat	UR1929GRA999

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**Application temperature**

above 15 °C

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**Drying**

air drying at 20°C

dust dry:	after 15 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 1 h	(degree of drying 4/ DIN 53150)
complete dry:	after 2 days	(swinging beam hardness/ ISO 1522)

oven drying: to 70 °C possible (object temperature)

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**Cleaning of working equipment**

EFD-Thinner 400500

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**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.

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**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 KP1645MR1868, RIAL silver and satin mat.

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.