

EFDESILK

Coating KT1802M

- Solvent-based lacquer
- Air drying
- Heat resistant

blasted sheet: dry film thickness: < 30 µm to 350°C (object temperature)
 smooth steel sheet dry film thickness : < 30 µm to 350°C (object temperature)
 see „Special remarks“

Technical / Physical Data	Resin/ binder	silicon resin modified with cellulose-derivate
	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value visual	mat
	Original viscosity DIN 53211	80 to 120 Sek. / 4 mm cup
	Thinner	EFD-Thinner 400320
	Density calculated	1,0 g / ml + / - 0,1
	Solid content calculated	31 % + / - 2
	Solid content in volume calculated	225 ml / kg + / - 5
	Consumption calculated in original viscosity, without application loss	130 to 136 m ² / kg dry film thickness 30 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.

Processing and application

Application

Before the use carefully stir up (e.g. with high-speed mixer).

spraying-highpressure:	after viscosity adjustment to 20 to 30 sec. nozzle: 1,3 to 1,5 mm	spraying pressure: 3 to 5 bar
spraying-airless:	in original viscosity nozzle: 0,28 to 0,33 mm	spraying pressure: 80 to 150 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 mechanical (e.g. shot blasting) pretreatment.

Proposal for a coating system

substrate:	steel blasted
top coat:	EFDESILK-Coating KT1802M

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 15 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 30 min.	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 2 days	(swinging beam hardness/ DIN EN ISO 1522)

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

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 KT1802MRA905, jet black and mat.

With smooth sheet is a own testing for adhesion and suitability of the coating must be carried out for the purpose intended. Temperatures above 350 ° C can contribute to the color change and lose grip.

The optimal film properties and the full chemical and mechanical resistance after the first heat load (approx. 1 hour at least. 250 ° C).

ll 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.