



KL1022H FREOLUX-Coating

Product description

Product technology	solvent-based 1K coating
Application area	e.g. in the mechanical engineering and plant construction sector
Application	For interior and exterior applications
Resistance to light and weather	Good weather resistance
Yellowing	low
Substrate	Steel

General product properties

Binder-Base	Alkyd resin
Colour	All common colour shades
Gloss value	satin mat 30-50 GU, Angle 60° DIN EN ISO 2813
Viscosity	Flow time 120-200 sec., 4 mm flow cup DIN 53211
Density	1,1-1,3 g/ml theoretical
Solid mass	61-65 % theoretical
Solid content in volume	41-51 % theoretical
Reference product	The specified values refer to the product KL1022HRA705.
Resistance to storage	approx. 18 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time. The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.

Application and processing

Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.
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Structure recommendation	Substrate	Steel
	Primer	KL1712M Dry film thickness 50-70 µm
	Top coat	KL1022H Dry film thickness 40-60 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Thinning	EFD dilution 400011	
Processing conditions	from 10 °C to 25 °C	
Airless spraying	70-110 sec. / 4 mm viscosity cup Nozzle 0,28-0,33 mm angle 40° Material pressure 80-150 bar	DIN 53211
High pressure spraying	25-30 sec. / 4 mm Flow cup Nozzle 1,2-1,5 mm Injection pressure 4 bar	DIN 53211
Rolling/painting	rolling/painting	as delivered viscosity Add 0,3 to 0,5% by wight EFD-Relaxation agent 300807 for roller and brush application in case of bubble formation.
Material usage	without application loss 95-115 g/m² layer thickness 40 µm	theoretical
Air drying	20 °C, 50 % relative humidity	
Oven drying	up to 70 °C possible (object temperature)	
Cleaning of equipment	EFD dilution 400500	

Further processing of coated pieces

Repainting	"Up to 21 days ageing: possible with same quality, do not grind first coating layer. After 21 days ageing: with FREOLUX coating systems, grind first coating layer."
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 170.
Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information. The information provided here contains reference values and does not constitute a specification.