KO1846MAU10A
FREIOTHERM-Metallic-Basecoat

Product description

Product technology	solvent-based stoving enamel
Application area	e.g. in the automotive sector
Surface finish	Metallic effect
Over-coating capability	"Wet on wet" method

General product properties

Binder-Base	Combination of polyester/amino resin	
Colour	high gloss L.1H7	
Viscosity	Flow time 13 - 15 sec., 4 mm flow cup	DIN 53211
Density	0,9 - 1,1 g/ml	theoretical
Solid mass	4 - 8 %	theoretical
Solid content in volume	50 - 70 ml/kg	theoretical
VOC value	See safety data sheet	
Resistance to storage	approx. 9 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. 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, chromating) according to the requirements. For this we refer to the guidelines of Qualicoat, GSB and Qualisteelcoat.
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).
Thinning	EFD dilution 400198 EFD dilution 400190
Recommended coating thickness	10 - 15 µm
Processing conditions	Room temperature 15 - 25 °C Relative humidity 40-80 %
High pressure spraying	as delivered viscosity
Electrostatic	possible, system-specific
ESTA high rotation	as delivered viscosity

Our technical data sheets are to provide you with advice based on our latest state of knowledge.
This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications.
The sale of our products is in accordance with our terms of business, delivery and payment.

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de

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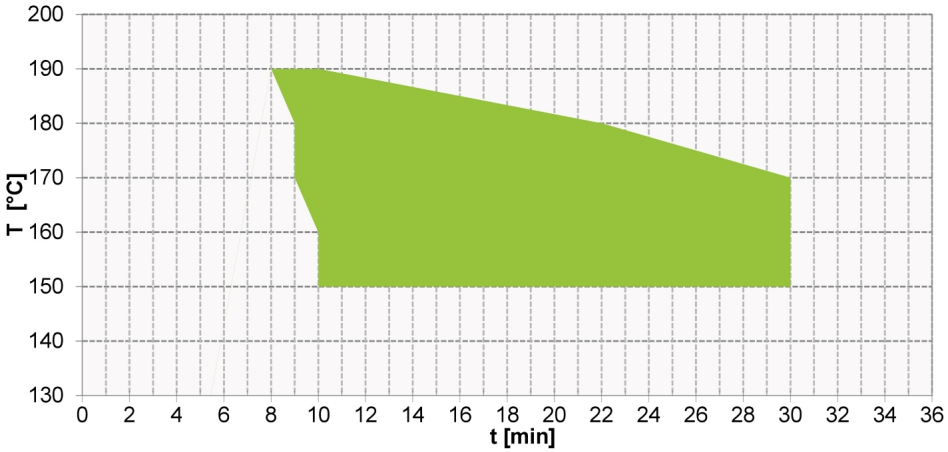
Curing

Baking window tested in colour shade KO1846MAU10A



Objekt Temperatur in °C Object Temperature in °C	150	160	170	180	190
Haltezeit Minimum in Minuten Holding time minimum in minutes	10	10	9	9	8
Haltezeit Maximum in Minuten Holding time maximum in minutes	30	30	30	22	10

Note on curing

Coloured area = stoving conditions with good end properties

The displayed baking conditions are based on results from laboratory tests and therefore merely serve as a guideline when configuring the processing company's coating systems. The processing company is responsible for ensuring that the coating is fully cured. The complete curing of the coating must be checked by means of additional analytical and resistance tests using representative original parts under production conditions. Please do not hesitate to contact us if you require consultation.

Cleaning of equipment

EFD dilution 400500

Comments

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.

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DIN EN ISO 9001 | IATF 16949 | EMAS

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