



## KL1022G FREOLUX-Coating

### Product description

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

### General product properties

<b>Binder-Base</b>	Alkyd resin
<b>Colour</b>	All common colour shades
<b>Gloss value</b>	glossy >70 GU, angle 20° DIN EN ISO 2813
<b>Viscosity</b>	Flow time 120-200 sec., 4 mm flow cup DIN 53211
<b>Density</b>	1,0-1,2 g/ml theoretical
<b>Solid mass</b>	56-60 % theoretical
<b>Solid content in volume</b>	40-50 % theoretical
<b>Reference product</b>	The specified values refer to the product KL1022GRA916.
<b>Resistance to storage</b>	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

<b>Pretreatment</b>	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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<b>Structure recommendation</b>	Substrate	Steel
	Primer	KL1712M Dry film thickness 50-70 µm
	Top coat	KL1022G Dry film thickness 40-60 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
<b>Thinning</b>	EFD dilution 400011	
<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>Airless spraying</b>	70-110 sec. / 4 mm viscosity cup Nozzle 0,28-0,33 mm angle 40° Material pressure 80-150 bar	DIN 53211
<b>High pressure spraying</b>	25-30 sec. / 4 mm Flow cup Nozzle 1,2-1,5 mm Injection pressure 4 bar	DIN 53211
<b>Rolling/painting</b>	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.
<b>Material usage</b>	without application loss 90-110 g/m² layer thickness 40 µm	theoretical
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Oven drying</b>	up to 70 °C possible (object temperature)	
<b>Dust drying</b>	after 2,5 hours (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 15 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 20 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500	

### Further processing of coated pieces

<b>Repainting</b>	"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

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 170.
<b>Work-and Healthprotection</b>	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.



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### Test conditions

All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge and 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.