FreiLacke

Technical Data Sheet

EFDESILK

Coating
KT1817M

- Solvent-based lacquer
- Air drying
- Heat resistant:
  blasted steelsheet
  dry film thickness 60 µm to 450°C (object temperature) duration of heat test: 60 min.

Technical / Physical Data	**Resin/ binder**	silicon resins
	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value visual	tuff mat
	Original viscosity	700 bis900 mPa.s / Sp.3
	Thinner	EFD-Thinner 400009 or EFD-Thinner 400320
	Density calculated	1,5 g / ml + / - 0,1
	Solid content calculated	64 % + / - 1
	Solid content in volume calculated	270 ml / kg + / - 5
	Consumption calculated in original viscosity, without application loss	210 to 230 m² / kg dry film thickness 60 µm see „Special remarks“
	Spreading rate calculated in original viscosity,	4 to 5 m² / kg dry film thickness 60 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.	

DIN EN ISO 9001
ISO/TS 16949
EMAS

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Processing and application

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

spraying-high-pressure:	in original viscosity
spraying airless:	in original viscosity
	nozzle: 13/30 spraying pressure: 60 to 100 bar

Substrates
steel, blasted

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.

Proposal for a coating system

subtrate:	steel	
Primer:	EFDESILK-Primer	KT1809M
top coat:	EFDESILK-Coating	KT1817M

Application temperature
above 10 °C

Drying air drying at 20°C

dust dry:	after 20 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 24 h	(degree of drying 4/ DIN 53150)
complete dry:	after 5 days	(swinging beam hardness/ ISO 1522)

Recoatability
after sanding with the same system.

Cleaning of working equipment
EFD-Thinner 400320

Advise for safety protection and protection of health
The usual precautionery measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailled 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, drying and caution labelling depend on colour shade.
The values mentioned in this data sheet are based on KT1817MRA907, grey aluminium RAL 9007

The optimum film properties and the full chemical and mechanical resistance are achieved after the first heat load (approx. 1 h at at least 250 ° C).

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.