



## KT1815L\_METALLIC EFDESILK-Metal Effectcoat

### Product description

<b>Product technology</b>	solvent-based 1K coating	
<b>Heat resistance</b>	Blasted sheet: Dry film thickness <20 µm to 600 °C (object temperature) Smooth sheet metal: Dry film thickness <20 µm to 300 °C (object temperature)	
<b>Substrate</b>	Steel, Steel, blasted	

### General product properties

<b>Binder-Base</b>	Silicone resin	
<b>Colour</b>	in accordance with RAL 840 HR other colours on request	
<b>Gloss visually</b>	matt	
<b>Viscosity</b>	Flow time 30-35 sec., 4 mm flow cup	DIN 53211
<b>Density</b>	0,9-1,1 g/ml	theoretical
<b>Solid mass</b>	16-20 %	theoretical
<b>Solid content in volume</b>	7-17 %	theoretical
<b>Reference product</b>	The specified values refer to the product KT1815LRA906.	
<b>Resistance to storage</b>	approx. 12 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.	
<b>Structure recommendation</b>	Substrate	On blasted steel plate
	Top coat	KT1815L Dry film thickness 15-30 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	



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<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>High pressure spraying</b>	as delivered viscosity nozzle 1,3-1,5 mm spray pressure 3-5 bar	
<b>Material usage</b>	without application loss 155-165 g/m <sup>2</sup> layer thickness 20 µm	theoretical
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Dust drying</b>	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 8 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 3 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500	

### Climatic tests

<b>Temperature resistance</b>	Optimum film properties, full chemical- and mechanical resilience are achieved after first heat exposure:	approx. [variable 1] minutes at minimum [variable 2] °C
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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.
<b>Test conditions</b>	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.