FreiLacke

Technical Data Sheet

FREOLUX

Primer
KL1709M

- Primer, with solvent
- Air-drying
- Forced drying possible
- Contains corrosion inhibitor

Technical / Physical Data	**Resin/ binder**	Alkyd / polymer resins
	Colour	grey following RAL 840 HR other colour shades on request
	Gloss value visuell	mat
	Original viscosity DIN 53211*	95 to 105 Sek. / 4 mm cup
	Thinner	EFD-Thinner 400320
	Density calculated	1,3 g / ml + / - 0,1
	Solid content calculated	62 % + / - 1
	Solid content in volume calculated	310 ml / kg + / - 10 415 ml / kg + / - 10
	Consumption calculated in original viscosity, without application loss	156 to 166 g / m² dry film thickness 50 µm see „Special remarks“
	Spreading rate calculated in original viscosity, without application loss	6,0 to 6,4 m² / kg dry film thickness 50 µm see „Special remarks“
Storability	Approx. 18 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
VDA 6.1
EMAS II

Emil Frei GmbH & Co.
Lackfabrik Döggingen
Am Bahnhof 6
D- 78195 Bräunlingen
Phone: +49 (0)7707 151-0
Fax: +49 (0)07707 151-238
info@freilacke.de,
www.freilacke.de

Processing and application

Application
Stir up before the use carefully (e.g. with high-speed mixer).

spraying-airless:	in originsl viskosity nozzle: 0,013 inch	spraying pressure: 150 bar
spraying-high-pressure:	after viscosity adjustment to 30 to 40 sec. nozzle: 1,4-1,8 mm	spraying pressure: 3-5 bar
by roller/ brush:	in original viscosity	

Substrates
steel

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:	FREOLUX-Primer	KL1709M
top coat:	FREOLUX-Paint	KL1022

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 2 h	(degree of drying 4	/ DIN 53150)
complete dry:	after 12 days	(swinging beam hardness	/ ISO 1522)
oven drying:	to 70°C possible	(object temperature)	

Cleaning of working equipment
EFD-Thinner 400500

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 KL1709MRU700, grey, mat.

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.