FreiLacke

Technical Data Sheet

FREOLUX

Metal-Effectcoat
KL1022

- Alkyd resins, air drying
- Inside and outside application
- Industrial´s application
- Weather-resisting
- Small yellowness
- Accelerated drying is possible

Technical / Physical Data	**Resin/ binder**			medium oillength, low yellowing alkyd resins
	Colour			acc. to RAL 840 HR other colour shades on request
	Gloss value visuell	**KL1022G** **KL1022H**	**=** **=**	metallic - glossy metallic - satin mat
	Original viscosity DIN 53211*			40 to 80 Sek. / 4 mm cup
	Thinner			EFD-Thinner 400011 EFD-Thinner 400432
	Density calculated			1,0 g / ml + / - 0,1
	Solid content calculated			49 % + / - 3
	Solid content in volume calculated	**KL1022G** **KL1022H**	**=** **=**	380 ml / kg + / - 10 310 ml / kg + / - 10
	Consumption calculated in original viscosity, without application loss	**KL1022G** **KL1022H**	**=** **=**	100 to 110 g / m² 125 to 135 g / m² dry film thickness 40 µm see „Special remarks“
	Spreading rate calculated in original viscosity, without application loss	**KL1022G** **KL1022H**	**=** **=**	9,0 to 10 m² / kg 7,5 to 8,0 m² / kg dry film thickness 40 µm see „Special remarks“
Storability	Approx. 9 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			

DIN EN ISO 9001
VDA 6.1
EMAS II

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Processing and application

Application

spraying-high-pressure: after viscosity adjustment to 25 to 30 sec.
nozzle: 1,2 to 1,5 mm spraying pressure: 4 bar
spraying-low-pressure: after viscosity adjustment to 25 to 30 sec.

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	KL1712
top coat:	FREOLUX-Metal-Effectcoat	KL1022

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 1 h. 40 min.	(degree of drying 1	/ DIN 53150)
dry to touch:	after 7 h .	(degree of drying 4	/ DIN 53150)
complete dry:	after 20 days	(swinging beam hardness	/ ISO 1522)
oven drying:	to 70°C possible	(object temperature)	

Repair coating

up to an ageing of 3 weeks: with the same system, no sanding, use only EFD-Thinner 400011 as cleaning agent
after an ageing of 3 weeks: after slight sanding with FREOLUX-paint systems, sanding

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, sayfety 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 RAL 9006, white aluminium and RAL 9007, grey aluminium in glossy and semi glossy adjustment.

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.