



## KT1809M EFDESILK-Primer

### Product description

<b>Product technology</b>	solvent-based 1K coating	
<b>Content</b>	Zinc dust proportion in dry film approx. 88 %	
<b>Heat resistance</b>	Blasted sheet metal: Dry film thickness <50 µm to 600 °C (object temperature) Exposure time: 30 minutes	
<b>Substrate</b>	Steel, Grey cast iron, 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>	tuff mat	
<b>Viscosity</b>	1000-2000 mPa*s, spindle 4, 60 revolutions/min.	DIN EN ISO 2555
<b>Density</b>	2,0-2,2 g/ml	theoretical
<b>Solid mass</b>	70-74 %	theoretical
<b>Solid content in volume</b>	27-37 %	theoretical
<b>Reference product</b>	The specified values refer to the product KT1809MRU700.	
<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	Steel blasted to Sa 2.5
	Primer	KT1809M Dry film thickness 25-40 µm



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	Top coat	KT1817M	
		Dry film thickness 50-70 µm	
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).		
<b>Processing conditions</b>	from 10 °C to 25 °C		
<b>Airless spraying</b>	delivery viscosity Nozzle 0,38-0,45 mm Angle 40° Material pressure 120-150 bar		
<b>High pressure spraying</b>	as delivered viscosity nozzle 1,5-1,8 mm spray pressure 3-5 bar		
<b>Rolling/painting</b>	as delivered viscosity		
<b>Material usage</b>	without application loss 190-210 g/m <sup>2</sup> layer thickness 30 µm		theoretical
<b>Air drying</b>	20 °C, 50 % relative humidity		
<b>Dust drying</b>	after 10 minutes (degree of dryness 1)		DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 30 minutes (degree of dryness 4)		DIN EN ISO 9117-5
<b>Full drying</b>	after 1 day/s (pendulum damping)		DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500		

### Further processing of coated pieces

<b>Repainting</b>	after 1 hours / room temperature approx. 20 °C.
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### 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.



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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.