ES1919H

FREODUR-UV-Primer

Product description

Product technology	UV coating
Application	for interior use
Substrate	Aluminium

General product properties

Binder-Base	Urethane acrylate UV curing		
Gloss value	satin glossy	55 - 70 GU, Angle 60°	DIN EN ISO 2813
Viscosity	500 - 1000 mPa*s		
Density	1,4 +-0,2 g/ml		theoretical
Solid mass	99,8 %		theoretical
Resistance to storage	approx. 6 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

Structure recommendation	Substrate	Aluminium
	Primer	ES1919H 13:1 300020 Coating thickness 60 - 80 µm
	Intermediate layer	UV-Digitaldruck Coating thickness 10 µm
	Clearcoat	ES1903GRA999 Coating thickness 60 - 80 µm
Mixin ratio	Products ES1919H : UV-Haftvermittler 300020 Parts by weight 13:1	
Processing conditions	10 °C. The paint must be protected from light.	

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Airmix spraying	as delivered viscosity Nozzle 0,12 mm angle 150° Material pressure 100 bar
Hot spray process	in delivery viscosity temperature bis 60 °C
Industrial roller coating	as delivered viscosity Roller type gerillt 64 Number of grooves Belt v= 10 m/min Application roller v= 10 m/min Metering roller v= 2 m/min Direction of rotation revers Gap 999,8+-0,2 mm Offset - 1,0 mm
Curing	max. DFT 80µm Belt v= 4 - 6m/min Heater type Ga-Strahler Heater output 55W/cm min. UV dose 1000mJ/cm²
Cleaning of equipment	EFD dilution 400064

Comments

Work-and Healthprotection	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.
Test conditions	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.

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