



KL1022H_METALLIC FREOLUX-Metal Effectcoat

Product description

Product technology	solvent-based 1K coating	
Application area	e.g. in the mechanical engineering and plant construction sector	
Application	For interior and exterior applications	
Resistance to light and weather	Good weather resistance	
Yellowing	low	
Substrate	Steel	

General product properties

Binder-Base	Alkyd resin	
Colour	Metallic colour shades	
Gloss visually	satin mat	
Viscosity	Flow time 40-80 sec., 4 mm flow cup	DIN 53211
Density	1,05-1,15 g/ml	theoretical
Solid mass	52-55 %	theoretical
Solid content in volume	34-40 %	theoretical
Reference product	The specified values refer to the product KL1022HRA906.	
Resistance to storage	<p>approx. 9 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time.</p> <p>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.</p>	

Application and processing

Pretreatment	<p>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.</p>	
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Structure recommendation	Substrate	Steel
	Primer	KL1712M Dry film thickness 50-70 µm
	Top coat	KL1022HRA906 Dry film thickness 15-25 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Thinning	EFD dilution 400011	
Processing conditions	from 10 °C to 25 °C	
High pressure spraying	25-30 sec. / 4 mm Flow cup Nozzle 1,2-1,5 mm Injection pressure 4 bar	DIN 53211
Material usage	without application loss 100-110 g/m ² layer thickness 40 µm	theoretical
Oven drying	up to 70 °C possible (object temperature)	
Air drying	20 °C, 50 % relative humidity	
Dust drying	after 100 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 7 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 20 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	EFD dilution 400500	

Further processing of coated pieces

Repainting	"Up to 21 days ageing: possible with same quality, do not grind first coating layer. After 21 days ageing: with FREOLUX coating systems, grind first coating layer."
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 170.
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.