FreiLacke

Technical Data Sheet

FREIOPLAST

Coating
KP1610M

- Top-Coating with solvent
- For multicoat suitably on steel
- Good sagging limit

Technical / Physical Data	**Resin/ binder**	Alkydmodified Vinylresin
	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value DIN 67530 and DIN EN ISO 2813	tuffmat <15 geometry 85°
	Original viscosity DIN 53211*	100 to 110 Sek./ 4 mm cup
	Thinner	EFD-Thinner 400009 or EFD-Thinner 400320
	Density calculated	1,2 g / ml + / - 0,1
	Solid content calculated	58 % + / - 2
	Solid content in volume calculated	320 ml / kg + / - 10
	Consumption calculated in original viscosity, without application loss	155 to 165 g / m² dry film thickness 50 µm see „special remarks“
	Spreading rate calculated, in original viscosity, without application loss	6,0 to 6,5 m² / kg dry film thickness 50 µm see „special remarks“
Storability	Approx. 24 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

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Processing and application

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

spraying airless (cold / hot):	in original viscosity
spraying-pneumatic:	after viscosity adjustment to 40 to 60 sec.
by roller	in original viscosity
by brush:	in original viscosity

Substrates
iron, steel, galvanized substrate

Proposal for a coating system

primer:	FREIOPLAST-Primer	KP1609 or
	FREOPOX-Primer	ER1912
top coat:	FREIOPLAST-Coating	KP1610M

Application temperature
above 10 °C

Drying air drying at 20°C

dust dry:	after 30 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 2 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 4 days	(swinging beam hardness/ DIN EN ISO 1522)
oven drying:	to 80°C possible	(object temperature)

Repair coating
possible with physically drying systems, application by brush, roller or spray application

Cleaning of working equipment
EFD-thinner 400320

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

Resistance
In conjunktions with FREOPOX-Primer ER1912 or FREIOPLAST-Primer KP1609 very good corrosion protection, with good light and weather resistance in all climates .

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 KP1610MRA910.

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.