KP1631V
FREIOPLAST-Primer

Product description

Product technology	Solvent-based air-drying coating
Application	suitable as adhesion promoter
Drying	quickly
Substrate	Plastic, not defined in more detail, Steel, Stainless steel, Aluminium, Galvanised steel

General product properties

Binder-Base	Combination of Polymerisate resin / co-resin		
Colour	All common colour shades		
Gloss value	tuff mat	<31 GU, Angle 85°	DIN EN ISO 2813
Viscosity	6000-8000 mPa*s, spindle 6, 60 revolutions/min.		DIN EN ISO 2555
Density	1,2-1,3 g/ml		theoretical
Solid mass	57-59 %		theoretical
Solid content in volume	38-39 %		theoretical
Reference product	The specified values refer to the product KP1631VRU312.		
Resistance to storage	approx. 18 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

Pretreatment	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.	
Structure recommendation	Substrate	Steel
	Primer	KP1631V Dry film thickness 40-60 µm
	Top coat	KP1052G Dry film thickness 40-60 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Thinning	EFD dilution 400424	
Processing conditions	from 10 °C to 25 °C	

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de

KP1631V
FREIOPLAST-Primer

Airless spraying	80-100 sec. / 4 mm viscosity cup Nozzle 0,58-0,75 mm angle 40° Material pressure 120-150 bar	DIN 53211
High pressure spraying	40-60 sec. / 4 mm Flow cup Nozzle 1,5 mm Injection pressure 3 bar	DIN 53211
Rolling/painting	as delivered viscosity	
Material usage	without application loss 195-210 g/m² layer thickness 50 µm	theoretical
Air drying	20 °C, 50 % relative humidity	
Oven drying	up to 100 °C possible (object temperature)	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 90 minutes (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 5 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	EFD dilution 400424	

Further processing of coated pieces

Repainting	possible after grinding

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.

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de