

FREIOTHERM

Coating KO1836

- Baking coat with solvent – low temperatur
- Especially suited to motor-car accessories, e.g. light alloy wheels mounting parts for trucks
- Good adhesion to KTL

Technical / Physical data	Resin/ binder	acrylate - melamin resin
Colour	KO1836GK2179 = jet black	DB 9040
	KO1836HK2162 = nova grey	
	KO1836ZK2227 = black	DB 9124
	KO1836ZK2451 = jet black	DB 9120
	other colour shades on request	
Gloss DIN 67530 and DIN EN ISO 2813	KO1836G = glossy	> 70 geometry 20°
	KO1836H = satin glossy	70 to 85 geometry 60°
	KO1836Z = acc. to customer's requirement	
Original viscosity DIN 53211*	30 to 400 sec. / 4 mm cup	
Thinner	EFD-Thinner 400320 EFD-Thinner 400474	
Density calculated	1,05 g / ml + / - 0,05	
Solid content calculated	42 % + / - 5	
Solid content in volume calculated	390 ml / kg + / - 10	
Consumption calculated in original viscosity, without application loss	70 to 130 g /m ² dry film thickness 30 - 50 µm see „Special remarks“	
Electrical resistance of paint	300 - 500 K Ohm	

Storability

Approx. 18 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

Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).

spraying-high-pressure: in original viscosity
 nozzel: 1,8 to 1,5 mm spraying pressure: 3 to 4 bar
 electrostatic-sprying: e.g. high-rotation process
 after viscosity adjustment 16 to 25 sec.

Substrates

steel sheet, primer required: use a KTL Coating

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

Proposal for a coating system

primer: FREIOTHERM-KTL-Automotive, - thick layer, black
 basecoat: FREIOTHERM-Coating KO1836

Application temperature

above 10 °C

Drying

oven drying: 30 min. / 130 °C (object temperature)

Cleaning of working equipment

EFD-Thinner 400500

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed 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

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 KO1836HK2162, nova grey, satin glossy.

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 do not hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.