



## KL1780H FREOLUX-Structure Coating

### Product description

<b>Product technology</b>	solvent-based 1K coating
<b>Surface</b>	Different structures are possible depending on application and viscosity.
<b>Property</b>	Silicone-free
<b>Drying</b>	quickly
<b>Substrate</b>	Steel, Steel, blasted

### General product properties

<b>Binder-Base</b>	Alkyd resin		
<b>Colour</b>	in accordance with RAL 840 HR other colours on request		
<b>Gloss value</b>	Satin gloss	30-50 GU, Angle 60° The degree of gloss is strongly dependent on the structure. The given value refers to a smooth, weakly structured surface.	DIN EN ISO 2813
<b>Viscosity</b>	3000-4000 mPa*s, spindle 5, 60 revolutions/min.		DIN EN ISO 2555
<b>Density</b>	1,1-1,5 g/ml		theoretical
<b>Solid mass</b>	64-68 %		theoretical
<b>Solid content in volume</b>	360-400 ml/kg		theoretical
<b>Reference product</b>	The specified values refer to the product KL1780HU1193.		
<b>Resistance to storage</b>	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

<b>Pretreatment</b>	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.		
<b>Structure recommendation</b>	Substrate	Steel	
	Primer	KL1712M	Dry film thickness 50-70 µm



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	Top coat	KL1780H	
		Dry film thickness 70-90 µm	
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).		
<b>Thinning</b>	EFD dilution 400500		
<b>Processing conditions</b>	from 10 °C to 25 °C		
<b>Airmix spraying</b>	as delivered viscosity Nozzle 0,38 mm angle 40° Material pressure 120-160 bar Atomiser pressure 2-3 bar		
<b>High pressure spraying</b>	as delivered viscosity nozzle 1,2-1,7 mm spray pressure 2-4 bar		
<b>Rolling/painting</b>	rolling/painting	e.g. with microfibre roll	
<b>Material usage</b>	without application loss 200-220 g/m <sup>2</sup> layer thickness 80 µm		theoretical
<b>Air drying</b>	20 °C, 50 % relative humidity		
<b>Oven drying</b>	up to 80 °C possible (object temperature)		
<b>Dust drying</b>	after 15 minutes (degree of dryness 1)		DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 4 hours (degree of dryness 4)		DIN EN ISO 9117-5
<b>Full drying</b>	after 15 day/s (pendulum damping)		DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500		

### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 170.
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	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.