

FREOLUX

Structure Coating KL1780H

- Structure paint with solvent
- Silicone-free
- Air drying
- Industrial application
- For structure effects in a processing step orange peeling and two processing steps splatter effect
- Fast drying

Technical / Physical Data	Resin/ binder	short oil, modified alkyd resins	
	Colour	acc. to RAL 840 HR other colour shades on request	
	Gloss value DIN 67530 and DIN EN ISO 2813	satin glossy 30 to 65 geometry 60° (smooth, without effect)	
	Original viscosity	3000 to 4000 mPa.s / Sp. 5	
	Thinner	EFD-Thinner 400500	
	Density calculated	1,3 g / ml	+ / - 0,2
	Solid content calculated	66 %	+ / - 2
	Solid content in volume calculated	380 ml / kg	+ / - 20
	Consumption calculated in original viscosity, without application loss	200 to 220 g / m² dry film thickness 80 µm see „Special remarks“	
Spreading rate in original viscosity, without application loss	4,5 to 5,0 m² / kg dry film thickness 80 µm see „Special remarks“		
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

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

Depending on the desired texture, the application takes place in one (self-forming texture) or in two operations (sprinkle effect):

spraying-aimix:	in original viscosity nozzle: 15/40 spraying pressure: 120 - 160 bar atomizer pressure: 2 to 3 bar
spraying-highpressure:	in original viscosity nozzle: 1,2 to 1,7 mm atomizer pressure: 2 to 4 bar
by roller/ brush:	in original viscosity, e.g. with a short fiber web (microfiber) paint roller.

By changing the spray pressure, nozzle diameter, coating viscosity, pistols and process different surface structures can be achieved

Substrates

steel, stainless steel

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

substrate:	steel	
Primer:	FREOLUX-Primer	KL1712M
top coat:	FREOLUX-Structure Coating	KL1780H

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry:	after 15 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 4 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 15 days	(swinging beam hardness/ DIN EN ISO 1522)
oven drying:	to 80°C possible	(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 KL1780HU1193, goldyellow.
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.

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