

FREIOPLAST

Primer KP1631L

L= Variant of the standard-system regarding delivery viscosity

- Adhesion promoting corrosion protection primer containing solvents
- Fast drying
- Good adhesion on different substrates
- Adjusting to spraying Airless- and Airmix application

Technical / Physical Data	Resin/ binder	polymerisat / epoxy - combination	
	Colour	agate grey ca. RAL 7038 acc. to RAL 840 HR other colour shades on request	
	Gloss value DIN 67530 and DIN EN ISO 2813	tuffmat	< 31 geometry 85°
	Original viscosity DIN 53211*	70 to 80 Sek./ 4 mm cup	
	Thinner	EFD-Thinner	400424 or EFD-Thinner 400320
	Density calculated	1,1 g / ml	+ / - 0,1
	Solid content calculated	44 %	+ / - 2
	Solid content in volume calculated	225 ml / kg 25 Vol. %	+ / - 10 + / - 1
	Consumption calculated in original viscosity, without application loss	210 to 230 g / m² dry film thickness 50 µm	
	Spreading rate calculated in original viscosity, without application loss	4,3 to 4,7 m² / kg dry film thickness 50 µm	
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 usage is essential due to quality guaranty reasons.		

Processing and application
Application

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

spraying-highpressure:	after viscosity adjustment to 40 to 60 sec nozzle: 1,5 mm spraying pressure: 3 bar
spraying airless:	in original viscosity nozzle: 0,58-0,75 mm spraying pressure: 120 to 150 bar
by roller / brush:	in original viscosity

Substrates

aluminium, stainless steel, steel, plastics, zinc coated steel

When coating aluminium, plastics and zinc we recommend preliminary tests (e.g. adhesion).

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:	iron	
primer:	FREIOPLAST-Primer	KP1631L
top coat:	FREIOPLAST-Coating	KP1610 or
	FREIOPLAST-Coating	KP1613

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 5 days	(swinging beam hardness/ DIN EN ISO 1522)
oven drying:	to 100°C possible	(object temperature)

Repair coating

after sanding with the same system.

Cleaning of working equipment

EFD-thinner 400424

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

The statements concerning efficiency and drying depend on colour shade.

The values mentioned in this data sheet are based on KP1619LRU738, agate grey.

*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.

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