FreiLacke

Technical Data Sheet

FREIOPLAST

Primer
KP1622M

- Primer containing solvents
- Fast drying
- Universal re-coatability
- Good corrosion protection
- Good adhesion

Technical / Physical Data	**Resin/ binder**	polyvinyl resin combination
	Colour	to RAL 840 HR other colour shades on request
	Gloss value vusual	mat
	Original viscosity without hardener	1000 bis 1600 mPa.s / Sp.1
	Thinner	EFD-Thinner 400320
	Density calculated	1,25 g / ml + / - 0,1
	Solid content calculated	55 % + / - 3
	Solid content in volume calculated	280 ml / kg + / - 10
	Consumption calculated in original viscosity, without application loss	170 to 185 g / m² dry film thickness 50 µm see „special remarks“
	Spreading rate calculated in original viscosity, without application loss	5,4 to 5,8 m² / kg dry film thickness 50 µm see „special remarks“
Storability	Approx. 24 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.	

DIN EN ISO 9001
ISO/TS 16949
EMAS

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Processing and application

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

Spraying airless:	in original viscosity nozzle: 1,5 mm spraying pressure: 3 bar
Spraying pneumatic:	after viscosity adjustment to 30 to 50 sec according to DIN 53211* nozzle: 1,5 - 1,8 mm spraying pressure: appr. 4 bar
by roller / brush:	in original viscosity

Substrates
Steel, aluminium, zinc, zincor

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

subtrate:	steel	
primer:	FREIOPLAST-Primer	KP1622M
top coat:	EFDEDUR-Coating	UR1044

Application temperature
above 10 °C

Drying air drying at 20°C

dust dry:	after 20 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 3 h	(degree of drying 4/ DIN 53150)
complete dry:	after 2 days	(swinging beam hardness/ ISO 1522)
oven drying:	to 80°C possible	(object temperature)

Repair coating
after sanding with the same system (after 20 – 30 minuts)

Cleaning of working equipment
EFD-thinner 400320

Advise for safety protection and protection of health
The usual precautionery measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailled 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

Resistance
Excellent corrosion protection in an industrial climate for the corresponding overall structure.
For the coating of zinc/zincor and aluminium, we recommend that adhesion tests are carried out.

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 KP1622MRU910, white.
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.