

FREIOTHERM

HighSolid-Base laquer
KO1811MD1748

- Solvent contains, High-Solid Base laquer
- For multi-coat system
- Wet on wet application
- Suited to motor-car accessories e.g. light metal wheels

Technicalb / Physical data	Resin/ binder	acylate - melamin resin	
	Colour	strato-silver D1748	
	Gloss visually	semi mat	
	Original viscosity DIN 53211*	25 to 35 sec. / 4 mm cup	
	Thinner	EFD-Thinner 400190 - long or EFD-Thinner 400198 - short	
	Density calculated	1,0 g / ml	+ / - 0,1
	Solid content calculated by weight	35 %	+ / - 2
	Solid content in volume calculated by weight	290 ml / kg + / - 10	
	Spreading rate calculated in original viscosity, without application loss	50 to 70 g / m ² dry film thickness 15 to 20 µm see „Special remarks“	
	Spez. Widerstand	500 to 1000 K-Ohm Ransburg-Prüfgeräte	

Storability	<p>Approx. 9 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.</p>
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Processing and application	Application Components are to be mixed homogeneously (e.g. with high-speed mixer).		
	pneumatic-spraying:	after viscosity adjustment to 16 to 18 sec. nozzle: 1,2 mm spraying pressure: 3 to 4 bar	
	low pressure spraying (HVLP):	after viscosity adjustment to 16 sec.	
	electrostatic-spraying:	e.g. high-rotation process, bell-type equipment after viscosity adjustment to 16 sec.	
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	Substrates light metal wheels		
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	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.		
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	Proposal for a coating system		
	primer:	FREOPOX-Powder coating	PB1605AB0892
	base laquer:	FREIOTHERM-HighSolid-Base laquer	KO1811MD1748
	clear laquer:	FREIOTHERM-HighSolid-clear laquer	KO1853VRA999
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	Application temperature above 15 °C		
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	Drying		
	oven drying:	minimum 5 min. / 150 °C to 10 min. / 170 °C	(object temperature)
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	Cleaning of working equipment EFD-Thinner 400500		
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	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	<hr/>		
	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. 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.		