

Technical Data Sheet

Metallic-Base laquer KO1807 / RRS S01

- Baking metallic base coat, with solvent
- For multi-coat system
- Wet on wet application
- Suited to motor-car accessories e.g. light metal wheels

Technical / Physical Data	Resin/ binder	Acrylat-Aminoresin
	Colour	metallic colour shades acc. to the automobile industrie other colour shades on request
	Gloss visually	semi mat to semi gloss
	Original viscosity DIN 53211*	25 to 35 sec. / 4 mm cup
	Thinner	RRS SOLV 4320
	Density calculated	1,0 g / ml + / - 0,1
	Solid content calculated	28 % + / - 6
	Solid content in volume calculated	245 ml / kg + / - 35
	Spreading rate calculated in original viscosity, without application loss	50 to 100 m ² / kg dry film thickness 15 to 20 µm see „Special remarks“
	Spec. resistance „Ransburg“ – testing tool	200 to 700 K Ohm

Storability 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

Processing and application

Application

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

spraying-high-pressure: after viscosity adjustment 16 to 18 sec.
nozzle: 1,2 mm spraying pressure: 3 to 4 bar
low pressure spraying (HVL P): after viscosity adjustment to 16
electrostatic-spraying: e.g. high-rotation process, bell-type equipment
after viscosity adjustment to 16 sec.

Substrates

light metal wheels

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

primer:	RRS PRIMER
base laquer:	RRS S05
clear laquer:	RRS CLEARCOAT

Application temperature

above 15 °C

Drying

oven drying: minimum 5 min. / 150 °C to 10 min. / 170 °C (object temperature)

Cleaning of working equipment

Thinner RRS SOLV 4320

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 RRS S01, "avus silver". 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.