

Technical Data Sheet

KO1808S / RRS S04

S= different colours

Ready for application!

- coloured baking base coat with solvent
- 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	different colours shades acc. to the automobile industrie other colour shades on request
	Gloss visually	semigloss to gloss
	Original viscosity DIN 53211*	16 to 22 sec. / 4 mm cup
	Thinner	RRS SOLV 4320
	Density calculated	1,1 g / ml + / - 0,20
	Solid content calculated	35 % + / - 15
	Solid content in volume calculated	300 ml / kg + / - 50
	Spreading rate calculated in original viscosity, without application loss	70 to 130 g / m ² dry film thickness 20 to 30 µm see „Special remarks“
	Electrical resistance of paint acc. to "Ransburg-methode" acc. to "Sames-methode"	10 to 60 M-Ohm x cm

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 usage is essential due to quality guaranty reasons.

Processing and application**Application**

Components are to be mixed homogeneously (e.g. with high-speed mixer).

pneumatic-spraying:	after viscosity adjustment to 18 to 20 sec. nozzle: 1,2 mm spraying pressure: 3 to 4 bar
low pressure spraying (HVLP):	after viscosity adjustment to 16 to 18 sec.
electrostatic-spraying:	e.g. high-rotation process, bell-type equipment after viscosity adjustment to 16 sec.

Substrates

light metal weels

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 S04
clear laquer:	RRS CLEARCOAT

Application temperature

above 15 °C

Drying

oven drying: minimum 10 min. / 150 °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 and drying depend on colour shade.
The values mentioned in this data sheet are based on RRS S04, cristal white MB 9-797.

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.