

KLEIBERIT 657.0.13

UV curing top coat for roller application

Fields of Use

- Photosensitive UV top coat for the KLEIBERIT HotCoating® technology for high scratch resistance and gloss levels of < 5 units.

Characteristics of 657.0.13

Base: UV curing acrylates

Specific weight

(at 20 °C): approx. 1.07 g/cm³

Solids: 99 ± 1 %

Colour: uncolored, typical

Gloss level < 60°: < 5 units
The gloss level depends on the processing parameters.

Viscosity at delivery (at 20 °C)

6mm DIN cup: 25 - 35 seconds

Identification: See our safety data sheet

Processing

Ambient and substrate processing
temperature: 22 - 28 °C

Application with roller applicator: 7 - 40 g/m²

Application viscosity: viscosity at delivery

Stir well before use.

All process relevant properties must be checked before processing.

Drying / UV-Curing

Pre-curing: excimer

Curing: 10 m/min

UV-Dosage*: 800 - 1200 mJ/cm² (Hg)

* The stated UV dosages are empirical values based on measurements with „UV-Disc A002400 (Full-UV: 250 – 410 nm)“ by UV-Technique

It is absolutely necessary to determine the processing conditions for optimal result before starting production.

These depend on the equipment technology as well as on the substrate to be coated.

The final characteristics like adhesion, scratch resistance and sandability have to be monitored continuously.

Cleaning

Soiled application tools and machinery parts to be cleaned immediately with KLEIBERIT 820.0.

Packaging

KLEIBERIT 657.0.13

metal pail, 30 kg net

plastic canister, 20 kg net

IBC container, 1.000 kg net

Cleaner

KLEIBERIT 820.0

metal can, 22 kg net

Additional packaging sizes available upon request.

Storage

Shelf life in factory sealed containers (at 5 - 25°C) is at least 9 months.

Storage at high temperatures can shorten the shelf life.

Recommended transport temperature
-10 up to +35 °C.

Protect from light, heat and frost.

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