

KLEIBERIT 657.1.04

UV curing roller top coating, super matt

Fields of Use

- UV-TopCoat for the KLEIBERIT HotCoating® technology for a high scratch resistance and gloss rates of approx. 6 units

Characteristics of 657.1.04

Base:	UV curing acrylates
Specific weight (at 20°C):	approx. 1.15 g/cm ³ ± 0,05 g/cm ³
Color:	uncolored
Gloss Rate < 60°:	approx. 6 units the gloss rate depends on the coat weight.

Viscosity at delivery (at 20°C)	1.350 ± 100 mPa·s
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Identification: See our safety data sheet.

Processing

Ambient and substrate processing
 temperature: 18 - 22° C
 Application with roller applicator: 10-25 g/m² (max)
 Application viscosity: viscosity at delivery

Stir well before processing.
 All the conditions relevant for processing have to be checked before starting the process.

Drying / UV-Curing

Curing: 10 -20 m/min
 UV-Dosage*: 400 - 600 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

Clean soiled application tools and machinery parts immediately with KLEIBERIT 820.0.

Packaging

KLEIBERIT 657.1.04 UV-TopCoat
 metal pail, 25 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 15 - 25°C) minimum 6 months.
 Storage at high temperatures can shorten the shelf life.

Recommended transport temperature 5 - 25 °C
 Protect from light, heat and frost.

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