

# KLEIBERIT 657.4.13

**UV-curing roller top coating, super matt, colour 113 (kumtasi), for KLEIBERIT HotCoating®**

## Fields of Use

- Photosensitive UV top coat for the KLEIBERIT HotCoating® technology in colour 113 and a gloss level of < 5 units.

## Characteristics of KLEIBERIT 657.4.13

<b>Base:</b>	UV curing acrylates
<b>Specific weight (at 20 °C):</b>	approx. 1,23 g/cm <sup>3</sup>
<b>Solids:</b>	99 ± 1 %
<b>Colour:</b>	113
<b>Gloss level 60°:</b>	< 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: 25 - 45 g/m<sup>2</sup>

Application viscosity: viscosity at delivery

## Stir well before use.

**All process relevant properties must be checked before processing.**

## Drying/UV-Curing

Precuring:	excimer
Curing:	10 m/min
UV-Dosis*:	880 - 930 mJ/cm <sup>2</sup> (Hg) and
UV-Dosis*:	350 - 400 mJ/cm <sup>2</sup> (Ga)

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

**It is crucial to determine the processing conditions for optimal results before starting production.**

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

The final properties like adhesion, scratch resistance and sanding properties have to be monitored continuously.

## Cleaning

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

## Packaging

**KLEIBERIT 657.4.13 UV TopCoat**  
metal pail, 30 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 20 - 25°C) is at least 12 months.

Storage at high temperatures can shorten the shelf life.

Recommended transport temperature: -10 to 35 °C  
The product is not frost sensitive to 0 °C.

Protect from light and heat.

Version 17.07.2024 xv; replaces previous versions

## KLEIBERIT 657.4.13

### Adhesives and Packaging Disposal

#### Waste Code 080111

Our containers are made of recyclable material. Well drained containers can be recycled.

### Service

Our application department may be consulted at any time without obligation. The statements made herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service which is rendered free of charge and without obligation.