

KLEIBERIT 657.0.15

UV curing top coat for roller application, Supermatt

Fields of Use

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

Characteristics of 657.0.15

Base:	UV curing acrylates
Specific weight (at 20 °C):	approx. 1.07 g/cm ³
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/cm ² (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 657.0.15

Sheet steel planer, 23kg net
 Tinplate planer, 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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