

KLEIBERIT 653.1.33

UV curing sealer for roller application

Fields of Use

- Photosensitive UV base coat for the KLEIBERIT HotCoating® technology with very good sandability.

Characteristics of 653.1.33

Base:	UV curing acrylates
Specific weight (at 20°C):	approx 1.4 g/cm ³
Solids:	> 99 % (theoretical value)
Colour:	027
Gloss level:	typical for the material, matte, not determined
Viscosity at delivery (at 20°C)	
6mm DIN cup:	60 - 70 seconds
Identification:	Identification is required according to EU regulations (See our safety data sheet)

Processing

Ambient and substrate processing temperature: 22 – 28 °C
 Application with roller applicator: 10-55g/m²
 Application viscosity: viscosity at delivery

Stir well by machine before use.

All process relevant properties must be checked before processing.

Drying / UV-Curing

Gelling:	10 m/min
UV-Dosage*:	100 - 200 mJ/cm ² (Ga)
Curing:	10 m/min
UV-Dosage*:	450 - 500 mJ/cm ² (Hg) and 250 - 300 mJ/cm ² (Ga)

* 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 Cleaner 820.0 toluene-free.

Packaging

KLEIBERIT 653.1.33
 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 5 – 25°C) is at least 9 months.

Recommended storage and transport temperature 0 – 35 °C.

Storage at high temperatures can shorten the shelf life.

Protect from light, heat and frost.

Version 22/11/2019 xv; replaces previous versions

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Adhesive and Waste 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.