

# KLEIBERIT 657.4.02

**UV-curing roller top coating, super matt, colour 102, for KLEIBERIT HotCoating®**

## Fields of Use

- Photosensitive UV top coat for the KLEIBERIT HotCoating® technology in colour 102 and a gloss level of < 5 units.

## Characteristics of 657.4.02

**Base:** UV curing acrylates

**Specific weight (at 20 °C):** approx. 1,34 g/cm<sup>3</sup>

**Solids:** 99 ± 1 %

**Colour:** 102

**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 - 23 °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 657.4.02 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 - 35 °C

The product is not frost sensitive to 0 °C.

Protect from light and heat.

Version 13\03\25 ga; replaces previous version