

### **Technical Data Sheet**

# **EFDEDUR**

## System-Fine-Structure GS9107M-Trumpf

- Two component structure paint with solvent
- On powder coating co-ordinated system
- For indoor and outdoor usage
- Silicone-free
   Self-creating pearl structure in one layer
- Checked according to Trumpf RL 40.G016 "Oberflächenschutz an Produkten" (surface protection of products)

Technical / physical data	Resin/ binder		polyacrylic to be hardened with isocyanate
	Colour		between powder coating and RAL-Colour, (RAL 840 HR), other colour shade cards as well as customer sample
		T2029= T2034= T2033=	e.g. white NCS S 0505-R80B jet black ca. RAL 9005 white aluminium ca. RAL 9006
	Gloss value visual		mat
	Original viscosity DIN 53211*	T2029 + T2034 =	110 to 150 Sec. / 4 mm cup
	without hardener	T2033 =	60 to 90 Sec. / 4 mm cup
	Mixing ratio by weight		5:1
	Hardener base		EFDEDUR-Hardener HU0001 polyisocyanate
	Potlife after hardener addition		approx. 6 h / 20 °C
	Thinner		EFD-Thinner 400320 or EFD-Thinner 400500
	<b>Density</b> after hardener addition	T2029 + T2034 =	1,3 g / ml + / - 0,1
	calculated	T2033 =	1,1 g / ml + / - 0,1
	Solid content after hardener addition	T2029 + T2034 =	68 % + / - 2
	Solid content in volume	T2033 = T2029 + T2034 =	55 % + / - 2 360 ml / kg + / - 10
	after hardener addition calculated	T2033 =	400 ml / kg + / - 10
	Material usage calculated,	T2029 + T2034 =	110 to 160 g / $m^2$ dry film thickness 40 to 60 $\mu m$
	after hardener addition in original viscosity, without application loss	T2033 =	120 to 130 g / m² dry film thickness 40 to 60 $\mu m$

business and delivery.

DIN EN ISO 9001 VDA 6.1 EMAS II

Page 1 from 2 Emil Frei GmbH & Co.

Lackfabrik Döggingen Am Bahnhof 6 Am Bannhof 6
D- 78195 Bräunlingen
Phone: +49 (0)7707 151-0
Fax: +49 (0)07707 151-238
info@freilacke.de,

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#### Storability

Approx. 24 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective.

## Processing and application

#### **Application**

Components are to be mixed homogeneously (e.g. with high-speed mixer).

spraying-highpressure: after hardener addition and viscosity adjustment to 20 to 30 sec.

nozzle: 1,2 to 1,8 mm spraying pressure: 3 to 5 bar

#### **Substrates**

steel, non ferrous metals, different plastics

#### **Pretreatment**

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

#### Proposal for a coating system

substrate: steel

primer: FREIOPOX-Primer ER1912 top coat: EFDEDUR-System-Fine-Structure GS9107M

#### **Application temperature**

above 10 °C

**Drying** air drying at 20°C

dust dry:after 30 min.(degree of drying 1 / DIN EN ISO 9117-5)dry to touch:after 1,5 h(degree of drying 4 / DIN EN ISO 9117-5)complete dry:after 5 days(swinging beam hardness / DIN EN ISO 1522)

oven drying: to 100°C possible (object temperature)

#### Cleaning of working equipment

EFD-Thinner 400500

#### Advise for safety protection and protection of health

The usual precautionery measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailled information about dangerous goods, sayfety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

#### Special remarks

#### Resistance

In accordance with customer specification company Trumpf RL 40.G016 "Oberflächenschutz an Produkten" (surface protection of products) and HM 40.G025 "Anforderungen an die lackierte Oberfläche" (requirements to the coated surface).

#### **Test condition**

\*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered. Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.

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