



WU1403G_HU0060_METALLIC EFDEDUR-Hydro-Metal Effectcoat

Product description

Product technology	water-thinnable 2C coating	
Application area	e.g. in the mechanical engineering and plant construction sector	
Surface finish	Metallic effect	
Application	for exterior use	
Substrate	Plastic, not defined in more detail, according to customer requirements	

General product properties

Binder-Base	Acrylic Resin	
Colour	Metallic colour shades	
Viscosity	Flow time 60-66 sec. 4 mm flow cup	DIN 53211
pH-Value	7,5-8,0	DIN 19260
Solid mass	47-49 % after addition of hardener	theoretical
Solid content in volume	42-44 % after addition of hardener	theoretical
Reference product	The values given refer to the product with the shade WU1403GR2358.	
Resistance to storage	<p>approx. 6 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. Open packages are to be used within a short time.</p> <p>The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.</p>	

Application and processing

Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.	
Structure recommendation	Substrate	According to customer requirements
	Top coat	WU1403GR2358 Mixing ratio 3:1/ HU0060 Dry film thickness 20 µm



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Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
Hardener	HU0060 see technical data sheet	
Mixin ratio	Parts by weight 3:1	
	Volume parts 2,8:1	
Thinning	demineralised water	
Dry film thickness	must not exceed 60 µm – risk of reaction bubbles.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	
Processing conditions	Room temperature 18-22 °C	
	Relative humidity 40-60 %	
Processing time	max. 2 hrs. / 22 °C	
	End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.	
High pressure spraying	15-20 sec. / 4 mm Flow cup	DIN 53211
	Nozzle 1,4 mm	
	Injection pressure 4 bar	
Material usage	without application loss 40-50 g/m ²	theoretical
	layer thickness 20 µm after addition of hardener	
Air drying	18-22 °C, 40-60 % relative humidity	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 4 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 8 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916, dried-on equipment with org. solvents, e.g. EFD thinner 400424.	

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 111.
Work-and Healthprotection	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.



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System Coating

Can be integrated into the system coating concept as a horizontal system coating (different coatings with the same look) or vertical system coating (part of a multi-layer structure). For more information, see www.freilacke.de/systemlacke.

Test conditions

All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge and experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.

The information provided here contains reference values and does not constitute a specification.