Technical Data Sheet





Product description

Product technology	solvent-based 2-component coating
Surface finish	Hammer effect
Application	for interior use
Content	Silicone
Substrate	Non-ferrous metals, Steel, Steel, blasted

General product properties

Binder-Base	Acrylic Resin	
Colour	Based on "Frei-Hammerschlag" finish colour card other colours on request	
Gloss visually	Satin gloss	
Viscosity	Flow time 25-45 sec. 6 mm flow cup	DIN 53211
Density	1,0-1,2 g/ml after addition of hardener	theoretical
Solid mass	55-59 % after addition of hardener	theoretical
Solid content in volume	42-52 % after addition of hardener	theoretical
Reference product	The specified values refer to the product KE1043HHS002.	
Resistance to storage	approx. 9 month in original packagings at an ambient temper packages are to be used within a short time.	erature of 5 to 25 °C. Open
	The minimum storage stability of each batch is stated on the does not necessarily become unusable if stored for longer t quality assurance purposes, an inspection of these material they are still suitable for the intended application.	han this period. However, for

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	Steel

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications.

The sale of our products is in accordance with our terms of business, delivery and payment.

DIN EN ISO 9001 | IATF 16949 | EMAS

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6 78199 Bräunlingen-Döggingen | Deutschland +49 77071510 www.freilacke.de | info@freilacke.de

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KE1043H_HU0032 EFDEDUR-Hammer Finish

	Primer	ER1912M Mixing ratio 5:1 HE0052 Dry film thickness 70-90 μm	
	Top coat	KE1043H Mixing ratio 5:1 HU0032 Dry film thickness 60-80 μm	
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).		
Hardener	HU0032		
Mixin ratio	Parts by weight 5:1		
Processing conditions	from 10 °C to 25 °C		
Processing time	max. 6 hrs. / 20 °C The processing time can dec	crease at higher temperatures a	and/or under pressure.
Airless spraying	as delivered viscosity after c Nozzle 0,33-0,38 mm Angle Material pressure 100-120 b	40°	
High pressure spraying	as delivered viscosity after a nozzle 1,8-2,0 mm spray pressure 4-5 bar	dding curing agent	
Electrostatic	possible, system-specific		
Material usage	without application loss 85-1 layer thickness 40 µm after a	-	theoretical
Air drying	20 °C, 50 % relative humidity	/	
Oven drying	up to 100 °C possible (objec	t temperature)	
Dust drying	after 30 minutes (degree of o	tryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 24 hours (degree of dry	ness 4)	DIN EN ISO 9117-5
Full drying	after 14 day/s (pendulum da	mping)	DIN EN ISO 1522
Cleaning of equipment	EFD dilution 400500		

Further processing of coated pieces

Repainting	Use solvent-based FreiLacke primer on fully
	cured coatings as an adhesion promoter;
	grind substrate if necessary.

Comments

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EFD info	Further technical information can be found in the EFD Info. No. 118 und 170.
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.
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an 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.

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