WU1488G_HU0444_CLEARCOAT

EFDEDUR-Hydro-Clearcoat

Product description

Product technology	water-thinnable 2C coating
Application area	e.g. in the vehicle construction sector
Surface	smooth
Application	for exterior use

General product properties

Binder-Base	Acrylic Resin		
Colour	colourless		
Gloss value	glossy	80-90 GU, Angle 60°	DIN EN ISO 2813
Viscosity	Flow time 35-45 sec. 4 mm flow cup		DIN 53211
pH-Value	8,2-8,6		DIN 19260
Solid mass	42-45 % after addition of hardener		theoretical
Solid content in volume	38-40 % after addition of hardener		theoretical
Reference product	The values given refer to the product with the shade WU1488GRG999.		
Resistance to storage	approx. 12 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. 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.		

FreiLacke | Emil Frei GmbH & Co. KG

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

WU1488G_HU0444_CLEARCOAT
EFDEDUR-Hydro-Clearcoat

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	On blasted steel plate
	Primer	WE1935MRU124 Mixing ratio 8:1 /HE0041 Dry film thickness 60 µm
	Top coat	WU1488GK3957 Mixing ratio 4:1 /HU0444 Dry film thickness 40 µm
	Clearcoat	WU1488GRG999 Mixing ratio 3:1 /HU0444 Dry film thickness 40 µm
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	HU0444 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 70 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. 1,5 hrs. / 20 °C End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.	
Airmix spraying	30-60 sec. / 4 mm viscosity cup Nozzle 0,23 mm angle 40° Material pressure 80 bar Atomiser pressure 3 bar	DIN 53211
High pressure spraying	30-50 sec. / 4 mm Flow cup Nozzle 1,5 mm Injection pressure 3 bar	DIN 53211
Rolling/painting	as delivered viscosity	
Material usage	without application loss 130-135 g/m² layer thickness 50 µm after addition of hardener	theoretical
Oven drying	up to 80 °C possible	

FreiLacke | Emil Frei GmbH & Co. KG

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

WU1488G_HU0444_CLEARCOAT
EFDEDUR-Hydro-Clearcoat

Intermediate drying	60 min. / 20 °C (object temperature)	
Air drying	18-22 °C, 40-60 % relative humidity	
Dust drying	after 60 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 10 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 12 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 based on pre-test

Comments

EFD info	Further technical information can be found in the EFD Info. No. 109 + 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.
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.

FreiLacke | Emil Frei GmbH & Co. KG

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