



WU1017M_HU0117

EFDEDUR-Hydro-Structure Coating

Product description

Product technology	water-thinnable 2C coating
Application area	e.g. in the mechanical engineering and plant construction sector
Surface	Different structures are possible depending on application and viscosity.
Stability	good
Drying	quickly
Substrate	Non-ferrous metals, Steel, Primer

General product properties

Binder-Base	Acrylic Resin
Colour	All common colour shades
Gloss visually	mat The gloss level is mainly depending on the layering as well as ist application- and baking conditions.
Viscosity	1300-2000 mPa*s, spindle 5, 60 revolutions/min. DIN EN ISO 2555
pH-Value	8-9 DIN 19260
Solid mass	63-67 % after addition of hardener theoretical
Solid content in volume	52-55 % after addition of hardener theoretical
Reference product	The values given refer to the product with the shade WU1017MRA819.
Resistance to storage	<p>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.</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>



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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 iron-phosphated steel plate
Note before use	Top coat	
Hardener	WU1017MRA819	
Mixin ratio	Mixing ratio 6:1/ HU0117	
Thinning	Dry film thickness 60 µm	
Dry film thickness	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
Object temperature	HU0117 see technical data sheet	
Processing conditions	Parts by weight 6:1	
Processing time	demineralised water	
Airmix spraying	must not exceed 100 µm – risk of reaction bubbles.	
High pressure spraying	10-30 °C, minimum +3 °C above dew point temperature	
Rolling/painting	Room temperature 18-22 °C	
Electrostatic	Relative humidity 40-60 %	
Material usage	max. 5 hrs. / 20 °C	
Air drying	The processing time can decrease at higher temperatures and/or under pressure.	
Oven drying	30-60 sec. / 6 mm viscosity cup	
	Nozzle 0,33 mm angle 30°	
	Material pressure 100 bar	
	Atomiser pressure 2 bar	
	30-60 sec. / 6 mm Flow cup	
	Nozzle 2 mm	
	Injection pressure 3 bar	
	as delivered viscosity	
	possible, system-specific	
	without application loss 150-160 g/m ²	theoretical
	layer thickness 60 µm	
	18-22 °C, 40-60 % relative humidity	
	up to 70 °C possible	



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Dust drying	after 15 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 + 510.
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	<p>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.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>