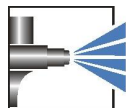


EFDEDUR-hydro Farba struktur WU1017M/HU0117

Characteristics	<ul style="list-style-type: none"> ■ Water-thinnable 2C coating ■ Application, e.g. in the mechanical engineering and plant construction sector ■ Structure effect ■ Fast initial drying ■ Forced drying possible ■ Good chemical resistance ■ Good adhesion to steel and non-ferrous metals ■ Good stability 																																
Technical / Physical Data	<table> <tr> <td>■ Binder-Base</td><td>Acrylate resin crosslinked with polyisocyanate</td></tr> <tr> <td>■ Colour</td><td>All common colour shades</td></tr> <tr> <td>■ Gloss value visual</td><td>satin mat</td></tr> <tr> <td>■ Viscosity</td><td>1300-2000 mPa.s/ Spindle 5 60 revolution/ min.</td></tr> <tr> <td>■ Hardener</td><td>HU0117 See technical data sheet</td></tr> <tr> <td>■ Mixing ratio</td><td>Parts by weight 6:1</td></tr> <tr> <td>■ Thinner</td><td>demineralised water</td></tr> <tr> <td>■ pH-Value</td><td>8-9</td></tr> <tr> <td>■ Density calculated</td><td>1,25-1,45 g/ml</td></tr> <tr> <td>■ Density calculated</td><td>1,2-1,4 g/ml after adding hardener</td></tr> <tr> <td>■ Solid Mass calculated</td><td>62-67 %</td></tr> <tr> <td>■ Solid Mass calculated</td><td>64-69 % after adding hardener</td></tr> <tr> <td>■ Solid content in volume calculated</td><td>370-390 ml/kg</td></tr> <tr> <td>■ Solid content in volume calculated</td><td>380-430 ml/kg after adding hardener</td></tr> <tr> <td>■ Material usage theoretical, without application loss</td><td>150-160 g/m², Layer thickness 60 µm</td></tr> <tr> <td>■ Reference colour of the specified values</td><td>Colour of WU1017MRA819</td></tr> </table>	■ Binder-Base	Acrylate resin crosslinked with polyisocyanate	■ Colour	All common colour shades	■ Gloss value visual	satin mat	■ Viscosity	1300-2000 mPa.s/ Spindle 5 60 revolution/ min.	■ Hardener	HU0117 See technical data sheet	■ Mixing ratio	Parts by weight 6:1	■ Thinner	demineralised water	■ pH-Value	8-9	■ Density calculated	1,25-1,45 g/ml	■ Density calculated	1,2-1,4 g/ml after adding hardener	■ Solid Mass calculated	62-67 %	■ Solid Mass calculated	64-69 % after adding hardener	■ Solid content in volume calculated	370-390 ml/kg	■ Solid content in volume calculated	380-430 ml/kg after adding hardener	■ Material usage theoretical, without application loss	150-160 g/m ² , Layer thickness 60 µm	■ Reference colour of the specified values	Colour of WU1017MRA819
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Substrate	<ul style="list-style-type: none"> ■ Steel, passivated or pretreated substrates ■ Primer 																																
Pretreatment	<ul style="list-style-type: none"> ■ The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. 																																

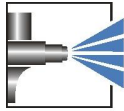
Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms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



EFDEDUR-hydro Farba struktur WU1017M/HU0117

	For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding	
Structure recommendation	■ Substrate	on iron-phosphated steel plate
	■ Top coat	WU1017MRA819 Mixing ratio 6:1/ HU0117 Dry film thickness 60 µm
Mechanical Test	■ Cross-cut-test DIN EN ISO 2409	Gt 0
	■ Temperature resistance	Short time loading 120°C
	■ Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.
Processing and application	■ Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water. Dry film thickness must not exceed 100 µm - risk of reaction bubbles.	
	■ Object temperature	10-30 °C
	■ Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %
	■ Processing time	max. 5 hrs./ 20 °C The processing time can decrease at higher temperatures and/or under pressure.
	■ Airmix spraying	30-60 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 0,33 mm Angle 30° Material pressure 100 bar Atomiser pressure 2
	■ High pressure spraying	30-60 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 2 mm Spray pressure 3 bar
	■ Rolling / painting	as delivered viscosity
	■ Electrostatic	possible, system-specific
	■ Over-coating capability	possible with same quality, dry at the earliest after matting
	■ 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.
Curing	■ Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.	
	■ Air drying	at 20°C, 50% relative humidity with air movement
	■ Dust drying	after 15 min. (degree of drying 1/ DIN EN ISO 9117-5)
	■ Dry to the touch	after 4 hrs. (degree of drying 4/ DIN EN ISO 9117-5)

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	■ Full drying	after 8 days (pendulum damping/DIN EN ISO 1522)
	■ Oven drying	possible to 80°C
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>	
Specific comments	<p>■ EFD-info Refer to the EFD information for further technical information. Nr. 111 + 510</p> <p>■ 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.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>	