



WU1425G_HU0150 EFDEDUR-Hydro-Coating

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
Note before use	Top coat	
Hardener	WU1425GRA911	
Mixin ratio	Mixing ratio 6:1/ HU0150	
Thinning	Dry film thickness 80 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	HU0150 see technical data sheet	
Processing conditions	Parts by weight 6:1	
Processing time	Volume parts 5:4	
Airmix spraying	demineralised water	
High pressure spraying	must not exceed 80 µm – risk of reaction bubbles.	
Rolling/painting	10-30 °C, minimum +3 °C above dew point temperature	
Material usage	Room temperature 18-22 °C	
Oven drying	Relative humidity 40-60 %	
Air drying	max. 4 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.	
	30-60 sec. / 4 mm viscosity cup	DIN 53211
	Nozzle 0,23 mm angle 30°	
	Material pressure 80 bar	
	Atomiser pressure 4 bar	
	30-40 sec. / 4 mm Flow cup	DIN 53211
	Nozzle 1,5 mm	
	Injection pressure 4 bar	
	as delivered viscosity	
	without application loss 210-230 g/m ²	theoretical
	layer thickness 80 µm after addition of hardener	
	up to 70 °C possible	
	18-22 °C, 40-60 % relative humidity	

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

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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. Do not mix curing agent with water! The cleaning must be carried out with organic solvents.	

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	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.