



## ZK1650H EFDEZELL-Gear-Coating

### Product description

<b>Product technology</b>	Solvent-based air-drying coating
<b>Application area</b>	For the internal coating of gears
<b>Substrate</b>	Steel

### General product properties

<b>Binder-Base</b>	Combination of nitrocellulose-/alkyd resin		
<b>Colour</b>	All common colour shades		
<b>Gloss value</b>	satin glossy	45-65 GU, Angle 60°	DIN EN ISO 2813
<b>Viscosity</b>	Flow time 90-110 sec., 4 mm flow cup		DIN 53211
<b>Density</b>	1,0-1,1 g/ml	theoretical	
<b>Solid mass</b>	44-46 %	theoretical	
<b>Solid content in volume</b>	30-32 %	theoretical	
<b>Reference product</b>	The specified values refer to the product ZK1650HRU309.		
<b>Resistance to storage</b>	<p>approx. 18 month in original packagings at an ambient temperature of 5 to 25 °C. 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>		

### Application and processing

<b>Pretreatment</b>	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.		
<b>Structure recommendation</b>	Substrate	Steel	
	Top coat	ZK1650H Dry film thickness 20-30 µm	
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).		
<b>Thinning</b>	EFD dilution 400500		



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<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>High pressure spraying</b>	22-26 sec. / 4 mm Flow cup Nozzle 1,7 mm Injection pressure 3-5 bar	DIN 53211
<b>Material usage</b>	without application loss 90-100 g/m <sup>2</sup> layer thickness 25 µm	theoretical
<b>Oven drying</b>	up to 80 °C possible (object temperature)	
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Dust drying</b>	after 15 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 20 minutes (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 14 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	EFD dilution 400500	

### Further processing of coated pieces

<b>Repainting</b>	after 24 hours / room temperature approx. 20 °C.
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### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 170.
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	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.