



EFDEDUR

System-Structurecoat

GS9141MT1753 – Trumpf

- Two component structure paint with solvent
- On powder coating co-ordinated system
- Silicone-free
- Fast drying
- In- and outdoor usage
- For structure effects in a processing step
- Checked after Trumpf RL 40.G016

Technical / physical data	Resin/ binder	acryl resin to be hardened with isocyanate
	Colour	jet black approx. RAL 9005 acc. to RAL 840 HR
	Colour deviation to RAL 840 HR	max. dE 2,5
	Gloss value DIN 67 530 and DIN EN ISO 2813	mat approx.. 13 geometry 60° (structured)
	Structure	After sample with desired values
	Delivery viscosity = Processing viscosity	3500 to 4500 mPa.s / Spindel 1
	Mixing ratio by weight	10 : 1
	Hardener-Typ base	EFDEDUR-Hardener HU0010 polyisocyanate
	Potlife after hardener addition	approx. 6 h / 20 °C
	Thinner	EFD-Thinner 400320 (fast) or EFD-Thinner 400474 (slowly)
	Density after hardener addition, calculated	1,24 g / ml + / - 0,1
	Solid content after hardener addition, calculated	66 % + / - 3
	Solid content in volume after hardener addition, calculated	420 ml / kg
	Material usage calculated, after hardener addition in original viscosity, without application loss	approx. 170 g / m ² dry film thickness 70 µm see „Special remarks“

Storability

Approx. 24 month in original packings at an ambient temperature of 5 to 25 °C, in case the original packings are tightly closed. Opened packing must be used very shortly. The minimum storage stability of each batch is mentioned on the product label. A storage time beyond the mentioned date doesn't necessarily mean that the material is unusable. In this case a check of the qualities which are important for the respective.

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FreiLacke



Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).
Suited application methods are: high pressure and low pressure.
Other application methods must be tested.

After hardener addition adjust the processing viscosity, dependent on Application procedure.
The application has to done in one processing step (self-creating structure)

spraying-highpressure: e.g. SATA jet®
nozzle: 1,5 to 2,5 mm
Atomizer pressure: 2 to 3 bar
cross-layer: 1 to 1,5

By changing the spray pressure, nozzle diameter and coating viscosity, pistol and process different surface structures can be achieved. Nozzle- and plant wear are to be considered

electrostatic-spraying: possible
by roller/ brush: in original viscosity after hardener addition

Substrates

steel, non ferrous metal: single layer coat

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

Application temperature

above 10 °C

Drying

air drying at 20°C / 100 µm dry film thickness

dust dry:	after 30 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 5 h	(degree of drying 4/ DIN 53150)
dry to assembling:	after 24 days	
complete dry:	after 8 days	(swinging beam hardness/ ISO 1522)
oven drying:	to 100°C possible	(object temperature)

Recoatability

after sanding with the same system.

Gloss degree adjustment when rolling GS9141 with
EFDEDUR bonding agent 300470 (for more shining) possible.

Cleaning of working equipment

EFD-Thinner 400500

Advise for safety protection and protection of health

The usual precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

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Special remarks**Resistance**

In accordance with customer specification company Trumpf RL 40.G016.

Test condition

All information is based on a standard climate 20/65 DIN 50014.

For the calculation of the practical consumption loss additions have to be considered.
Indications to this are the practical experience and advices given in DIN 53220.

All information are based on our product knowledge and experience. To the application we have no direct influence. For further information please don't hesitate to contact us.

The information mentioned herein are reference values and are not given as specification.