

EFDEDUR

Hammer-Finish KE1043

- Solvent contains 2-component hammer effect finish
- Contained silicone
- For the manufacture of hard and tough-elastic industrial coatings
- For indoor usage

Technical / Physical data	Resin/ binder	polyacrylic resins, to be hardened with isocyanat
	Colour	acc. to the colour shade card "Frei-Hammer-Effect-Finish" other colour shades on request
	Gloss value	satin glossy
	Original viscosity without hardener addition	25-45 sec. / 6 mm cup
	Mixing ratio by weight	5 : 1
	Hardener Base	EFDEDUR-Hardener HU0032 Polyisocyanat
	Potlife after hardener addition	max. 6 h / 20 °C
	Density after hardener addition, calculated	1,1 g / m ³ + / - 0,1
	Solid content after hardener addition, calculated	57 % + / - 2
	Solid content in volume after hardener addition, calculated	440 ml / kg + / - 10
	Material usage calculated after hardener addition in original viscosity, without application loss	85 to 100 g / m ² dry film thickness 40 µm see „Special remarks“
Storability	Approx. 9 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	

Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).
after hardener addition spray ample material in one to two cross-coats, whereas a first thin layer will provide a closed film appearance.

Avoid under any circumstances that spraying dust comes into wet surfaces.

airless-spraying: pressure of the material and nozzle size has to be taken into consideration; recommended pressure of material: 100 to 120 bar
nozzle size: 0,33 to 0,38 mm (0,013 to 0,015 inch)
It is eventually necessary to adjust a special effect.

pneumatic-spraying: after hardener addition a medium-sized hammer effect will be obtained, spraying (atomizer) pressure: 4 to 5 bar
nozzle size: 1,8 to 2,0 mm

electrostatic-spraying: possible

Substrates

steel, steel blasting, non ferrous metals

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.

Proposal for a coating system:

primer: recommendation for iron, steel and non ferrous metals
1-component: FREIOPLAST-Reaction GripPrimer KP1619MRU618
2-components: FREOPOX-Primer ER1912M
top coat: EFDEDUR-Hammer-Finish KE1043

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry: after 30 min. (degree of drying 1 / DIN EN ISO 9117-5)
dry to touch: after 24 h (degree of drying 4 / DIN EN ISO 9117-5)
complete dry: after 14 days (swinging beam hardness / DIN EN ISO 1522)

oven drying: to 100°C possible (object temperature)

Repair coating

On totally hardened coating EFDEDUR-Pre Coating UR1900MRU910 should be used as adhesion promotor, if nec. sanding the surface.

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.

Special remarks

Take care of silicone spreading in the other areas.
See: EFD-Tip Nr. 118 „Hammer-Effect and Effect-Finish“

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.