





## WU1451H\_HU0150\_METALLIC EFDEDUR-Hydro-Metal Effectcoat

### 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	On blasted steel plate
<b>Structure recommendation</b>	Primer	WE1935MRU124 Mixing ratio 8:1/HE0041 Dry film thickness 60 µm
<b>Structure recommendation</b>	Top coat	WU1451HRA906 Mixing ratio 5:1/ HU0150 Dry film thickness 40 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
<b>Hardener</b>	HU0150 see technical data sheet	
<b>Mixin ratio</b>	Parts by weight 5:1 Volume parts 5,3:1	
<b>Thinning</b>	demineralised water	
<b>Dry film thickness</b>	must not exceed 60 µm – risk of reaction bubbles.	
<b>Object temperature</b>	10-30 °C, minimum +3 °C above dew point temperature	
<b>Processing conditions</b>	Room temperature 18-22 °C Relative humidity 40-60 %	
<b>Processing time</b>	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.	
<b>Airmix spraying</b>	30-60 sec. / 4 mm viscosity cup Nozzle 0,23 mm angle 40° Material pressure 80 bar Atomiser pressure 3 bar	DIN 53211
<b>High pressure spraying</b>	30-50 sec. / 4 mm Flow cup Nozzle 1,5 mm Injection pressure 3 bar	DIN 53211
<b>Rolling/painting</b>	as delivered viscosity	



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<b>Material usage</b>	without application loss 100-110 g/m <sup>2</sup> layer thickness 40 µm after addition of hardener	theoretical
<b>Intermediate drying</b>	60 min. / 20 °C (object temperature)	
<b>Oven drying</b>	up to 80 °C possible	
<b>Air drying</b>	18-22 °C, 40-60 % relative humidity	
<b>Dust drying</b>	after 60 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 8 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 8 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	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.	

### Further processing of coated pieces

<b>Repainting</b>	possible with same quality, dry at the earliest after matting.
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### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 109 + 111.
<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.