

EFDEDUR

HighSolid-Structure Paint GS1954H

- Two component structure paint with solvent
- Silicone-free
- Fast drying
- In- and outdoor usage
- For structure effects in a processing step orange peeling and two processing steps splatter effect

Technical / physical data	Resin/ binder	acryl resin
	Colour	acc. to RAL 840 HR other colour shades on request
	Gloss value DIN 67530	satin mat 18 to 35 geometry 60°
	Original viscosity	The delivery viscosity is structure dependent 3000 to 8000 mPa.s / Sp. 6
	Mixing ratio by weight	coarse structure= 9 : 1 HU0036 middle structure= 7,5 : 1 HU0436 micro structure = 6 : 1 HU0936
	Hardener-Typ base	coarse structure= EFDEDUR-Hardener HU0036 middle structure= EFDEDUR-Hardener HU0436 micro structure = EFDEDUR-Hardener HU0936 polyisocyanate see „Special remarks“
	Potlife after hardener addition	approx. 2 h / 20 °C
	Thinner	EFD-Thinner 400320 or EFD-Thinner 400500
	Density after hardener addition calculated	1,56 g / ml + / - 0,1
	Solid content after hardener addition calculated	74 % + / - 3
	Solid content in volume after hardener addition calculated	370 ml / kg + / - 20
	Material usage calculated, after hardener addition in original viscosity, without application loss	110 to 180 g / m ² dry film thickness 40 to 60 µm

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.

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.

Following the addition of the curing agent, set the processing viscosity in accordance with the respective application process. Depending on the desired texture, the application takes place in one (self-forming texture) or in two operations (sprinkle effect):

Splatter-effect (two working steps)

spraying-highpressure: e.g. SATA jet®
nozzle: 1,5 to 2,0 mm
cross-layer: 1 to 2

- 1.) smooth surface (atomizer pressure: 3 to 5 bar nozzle)
after a drying time (surface drying) of approx 30 min. / 20 °C
- 2.) splatter the required effect appearance on the painted surface,
for this splattering the spraying pressure has to be reduced
(atomizer pressure: 0,5 to 2 bar nozzle)

Self-creating effect (apply the required structure appearance in one working step)

spraying-highpressure: e.g. SATA jet®
nozzle: 1,5 to 2,0 mm
Atomizer pressure: 3 to 5 bar
cross-layer: 1 to 2

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: e.g. with a short fiber web (microfiber) paint roller.

Substrates

steel: single layer coat
non ferrous metal: lock at Special remarks
plastics, wood: se only with primer 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.

Proposal for a coating system

substrate: non ferrous metal, e.g. Aluminium
primer: FREIOPOX-Primer ER1912
top coat: EFDEDUR- HighSolid Structure Paint GS1954H

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 2 h (degree of drying 4 / DIN EN ISO 9117-5)
complete dry: after 8 days (swinging beam hardness / DIN EN ISO 1522)

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

Cleaning of working equipment

EFD-Thinner 400500

EFDEDUR

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GS1954H

FreiLacke



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**Information about Hardener and Thinner:**

The hardener and the thinner mentioned on page 1 are stated as standard components for this paint system. The standard hardener is also written in the order documents as well as on the label.

Furthermore there are additional hardeners and thinners, which can be used as alternative in case the standard components doesn't meet the requirements. These products are tailor-made e.g. faster or slower hardening.

Hardener are taking influence on the gloss (see page 1).

Test condition

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on GS1954HRA735, light grey in satin mat adjustment and hardening with HU0036.

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.