

# EFDEDUR

## In-Mould-Coat UR1455G

- 2-component-polyurethane In-mould-coat for spray application
- For indoor and outdoor use
- For industrial goods e.g. mechanical engineering and vehicle construction
- Self releasing adjusted on metal forms

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	polyacrylic resin to be hardened with isocyanate		
	<b>Colour</b>	accord. to RAL 840 HR other color shades on request		
	<b>Gloss value</b>	depending on the surface of the form		
	<b>Original viscosity</b> DIN 53211* without hardener	30 to 50 sec. / 4 mm cup		
	<b>Mixing ratio</b>			
	by weight	UR1455G	100	
		EFDEDUR-hardener <b>HU0932</b>	33	= Standard-Hardener
		EFD-release agent 300024	20	
		UR1455G	100	
		EFDEDUR-hardener <b>HU0939</b>	33	= flexible Härter
		EFD-release agent 300024	20	
	<b>Hardener</b> Base	EFDEDUR-Hardener EFDEDUR-Hardener polyisocyanate see „Special remarks“	HU0932 Standard-hardener or HU0939 felxible hardener	
	<b>Potlife</b> after hardener addition	<b>HU0932 =</b> <b>HU0939 =</b>	max. 1,5 h / 20°C max. 1,0 h / 20°C	
	<b>Thinner</b>	EFD-release agent 300024 or 300029 (20% addition)		
<b>Density, ready for spraying</b> after hardener and thinner addition calculated	<b>HU0932 =</b> <b>HU0939 =</b>	1,06 g / ml 1,07 g / ml	+ / - 0,15 + / - 0,15	
<b>Solid content, ready for spraying</b> after hardener and thinner addition calculated	43 % + / - 2			
<b>Solid content in volume, ready for spraying</b> after hardener and thinner addition calculated	310 ml / kg + / - 20			
<b>Consumption, ready for spraying</b> after hardener and thinner addition calculated without application loss	160 to 170 g / m <sup>2</sup> dry film thickness 50 µm see „Special remarks“			

**Storability** Approx. 24 month in original package at storage temperature of 5 to 25 °C, in case the original package is tightly closed. Opened package must be used 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 use.

**Processing and application**

**Application**

Components have to be mixed homogeneously (e.g. with high-speed mixer).

spraying-highpressure: after hardener addition  
nozzle: 1,4 mm spraying pressure: 3 to 4 bar

**Substrates**

metal forms

**Pretreatment**

New or cleaned forms need to be treated once before first use with a suitable external release agent..

**Proposal for a coating system**

Substrate: non metal forms e.g. aluminium heated to approx. 60°C  
IMC coat: EFDEDUR-In-Mould-Coat UR1455G  
Carrier material: e.g. 2-components-PUR integral foam and fibre spraying systems

**Application temperature**

Temperature of the form min. 60 °C

**Drying**

air drying in the form 60°C

dust dry: after 5 min. (degree of drying 1/ DIN 9117-5)  
complete dry: after 9 days after demoulding process (swinging beam hardness/ ISO 1522)

**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**

**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 down in the order documents as well as on the product 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.

**Stability**

EFDEDUR-Hardener HU0932 / HU0939

Outdoor use, good light- and weather resistance and indoor use when higher requirements to the light Resistance of brighter color shades.  
Good resistance to alkali and acids.

**Test condition**

\*Indication of the delivery viscosity according to DIN 53211:  
DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

The statements concerning efficiency and drying depend on colour shade.  
The values mentioned in this data sheet are based on UR1455GF2052, Ibiswhite and hardening with HU0932.

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 references 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 not given as a specification.