

EFDEDUR

System-HS-Structurecoat GS9180H - Trumpf

- Two component system structure paint with solvent
- On powder coating co-ordinated system
- Standard-System: GS1080 EFDEDUR-Structure Paint
- 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	after powder-coating sample with desired values
	GS8180HT2027 =	blue RDS 250 20 20
	GS9180HT2029 =	white NCS S 0505-R80B
		other colour shades on request
	Farbtonabweichung to powder-coating master sample	max. dE 1,5 with main colours with other colours: according to DIN 6175, T1x factor 4
	Gloss value DIN 67 530 and DIN EN ISO 2813	satin matt 8 to 33 geometry 60° (structured)
	Structure	After sample with desired values
	Delivery viscosity = Processing viscosity	4000 to 6000 mPa.s / Spindel 5
	Mixing ratio by weight	10 : 1
	Mixing ratio by volume	6,5 : 1
	Hardener-Typ base	EFDEDUR-Hardener HU0140 polyisocyanate
	Potlife after hardener addition	approx. 2 h / 20 °C
	Thinner	see „Processing and application“
	Density after hardener addition, calculated	1,5 g / ml + / - 0,1
	Solid content after hardener addition, calculated	80 % + / - 1
	Solid content in volume after hardener addition, calculated	410 ml / kg + / - 30
	Material usage calculated after hardener addition in original viscosity, without application loss	240 g / m ² + / - 20 dry film thickness 100 µm see „Special remarks“

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FreiLacke



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.

Delivery viscosity = Processing viscosity.
If necessary to diluted the material for the processing, take:

EFD-Thinner 400320 (fast) or
EFD-Thinner 400474 (slowly)

The application has to done in one processing step (self-creating structure)

spraying-highpressure: e.g. SATA jet®
nozzle: 1,5 to 2,0 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 20 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 6 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 14 days	(swinging beam hardness/ DIN EN ISO 1522)

With forced drying process and a dry film thickness of over 60 µm a minimum ventilating time of 15 min. 20°C is to be kept. This indication can change due to different climatic conditions.

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

Recoatibility

after sanding with the same system.

Cleaning of working equipment

EFD-Thinner 400312

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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**Resistance**

In accordance with customer specification company Trumpf RL 40.G016 and HM 40.G025. In connection with suitable pretreatment and additional priming the lacquer for the external use is suitable.

Test condition

The statements concerning efficiency and drying on colour shade.

The values mentioned in this data sheet are based on GS9180HT2027, blue and hardening with HU0140.

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.