

EFDEDUR

System-Structurecoat GS9141H – Trumpf

- Two component structure paint with solvent
- On powder coating co-ordinated system
- 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	GS9141HT2027 = GS9141HT2029 =	after powder-coating sample with desired values blue RDS 250 20 20 white NCS S 0505-R80B other colour shades on request
Colour deviation		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 mat 18 to 33 geometry 60° (structured)
Structure		after sample with desired values
Delivery viscosity = Processing viscosity		4500 +/- 500 mPa.s / Spindel 1
Mixing ratio by weight		10 : 1
Mixing ratio by volume		7,2 : 1
Hardener-Typ base		EFDEDUR-Hardener HU0010 polyisocyanate
Potlife after hardener addition		approx. 6 h / 20 °C
Thinner		see „Processing and application“
Density after hardener addition, calculated		1,4 g / ml +/- 0,1
Solid content after hardener addition, calculated		72 % +/- 3
Solid content in volume after hardener addition, calculated		394 ml / kg +/- 30
Material usage calculated, after hardener addition in original viscosity, without application loss		approx. 254 g / m ² +/- 20 dry film thickness 100 µm see „Special remarks“



Storability Approx. 18 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

Different effects can be achieved by modifying of spraying pressure, viscosities, guns and process, as well as by using different nozzle-sizes.
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 30 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 5 h	(degree of drying 4/ DIN 53150)
dry to assambling:	after 24 h	
complete dry:	after 8 days	(swinging beam hardness/ 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)

Recoatability
after sanding with the same system.
Gloss degree adjustment when rolling GS9141 with
EFDEDUR bonding agent 300470 (for more shining) and
EFDEDUR bonding agent 300425 (for more matte) possible.

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**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, drying and caution labelling depend on colour shade.

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.