DW1155M_DU0127
EFDEDUR-Hydro-Top-Coat

Product description

Product technology	water-thinnable 2C coating
Application area	Application: Rail vehicles and components
Resistance to light and weather	very good
Substrate	Primers and fillers for rail vehicles and components

General product properties

Binder-Base	Acrylic Resin	
Colour	All common colour shades	
Gloss visually	matt	
Viscosity	1300-1700 mPa*s, spindle 4, 60 revolutions/min.	DIN EN ISO 2555
Solid mass	50-55 % after addition of hardener	theoretical
Solid content in volume	40-45 % after addition of hardener	theoretical
Resistance to storage	approx. 12 month in original packagings at an ambient temperature of 18 to 25 °C. Protect from frost. Open packages are to be used within a short time. The minimum storage stability of each batch is stated on the product label. The material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.	

Application and processing

Pretreatment	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.	
Structure recommendation	Substrate	Steel blasted to Sa 2.5
	Primer	DW1202U Mixing ratio 3:1 DU0121 Dry film thickness 80-90 µm
	Filler	DW1110D Mixing ratio 6:1 DU0750 Dry film thickness 60-70 µm
	Top coat	DW1155M Mixing ratio 3:1 DU0127 Dry film thickness 50-60 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de

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Hardener	DU0127
Mixin ratio	Parts by weight 3:1
Thinning	demineralised water
Dry film thickness	must not exceed 100 µm – risk of reaction bubbles.
Object temperature	10-30 °C, minimum +3 °C above dew point temperature
Processing conditions	Room temperature 18-28 °C Relative humidity 30-80 %
Processing time	max. 3 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.
Airmix spraying	20-30 sec. / 4 mm viscosity cup DIN 53211 Nozzle 0,28 mm angle 30° Material pressure 160 bar Atomiser pressure 2-3 bar
High pressure spraying	20-30 sec. / 4 mm Flow cup DIN 53211 Nozzle 1,6 mm Injection pressure 2-2,5 bar
Oven drying	up to 80 °C possible
Cleaning of equipment	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. Do not mix curing agent with water! The cleaning must be carried out with organic solvents.

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.

Comments

Work-and Healthprotection	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.
EFD info	Further technical information can be found in the EFD Info. No. 111+510
Test conditions	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.

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