

EFDEDUR

Structure Paint FS1046

- Two component structured paint with solvent
- With self forming effect
- Silicone oil contains
- Industrial lacquer finish for in outdoor usage
- Processing after hardener addition without thinner addition

Technical / Physical Data	Resin/ binder	acryl resin, silicone oil contains	
	Colour	acc. to RAL 840 HR other colour shades on request	
	Gloss value	FS1046G =	glossy 70 to 80 geometry 60°
	DIN 67530	FS1046H =	satin mat 20 to 30 geometry 60°
	DIN EN ISO 2813	(smooth, without effect)	
	Original viscosity	600 to 800 mPa.s / Spindel 3	
	Mixing ratio	FS1046G =	4 : 1
		FS1046H =	5 : 1
	Hardener	EFDEDUR-Hardener HU0032	
	Base	polyisocyanate	
	Potlife	4 to 6 h / 20 °C	
	after hardener addition		
	Density	1,20 g / ml + / - 0,15	
after hardener addition, calculated			
Solid content	62 % + / - 4		
after hardener addition, calculated			
Solid content in volume	FS1046G =	470 ml / kg + / - 20	
after hardener addition, calculated	FS1046H =	370 ml / kg + / - 20	
Material usage	FS1046G =	80 to 130 g / m ²	
after hardener addition	FS1046H =	100 to 170 g / m ²	
calculated, without application loss	dry film thickness 40 to 60 µm		

Storability

Approx. 12 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).

after hardener addition spray ample material in one to two cross-coats, whereas a first thin layer will provide a closed film appearance.

airless-spraying: in original viscosity after hardener addition
pressure of the material and nozzle size has to be taken into consideration; recommended pressure of material: 100 to 120 bar
nozzle size: 0,33 to 0,38 mm (0,013 to 0,015 inch)
It is eventually necessary to adjust a special effect.

pneumatic-spraying: in original viscosity after hardener addition
spraying (atomizer) pressure: 4 to 5 bar nozzle size: 1,8 to 2,0 mm

electrostatic-spraying: in original viscosity after hardener addition
by roller: in original viscosity after hardener addition

Substrates

steel: single layer coat

non ferrous metals, different plastics, wood: primer is absolutely necessary

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- Structure Paint FS1046

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry: after 30 min. (degree of drying 1/ DIN 53150)

dry to touch: after 5 h (degree of drying 4/ DIN 53150)

complete dry: after 8 days (swinging beam hardness/ ISO 1522)

oven drying: to 70°C possible (object temperature)

Repair coating

EFDEDUR-Pre-Coatinf UR1900MRU910, white applied on totally hardened coating should be used as adhesion promotor if nec. sanding the surface.

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

Take care of silicone spreading in the other areas.

Information about Hardener:

The hardener 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, 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).

Resistance**EFDEDUR-Hardener HU0032:**

Indoor usage, good mechanical and chemical resistance, fast initial drying

In case of any requirements to resistance against yellowing and UV-resistance use EFDEDUR-Härter HU0001 (MR 5:1).

EFDEDUR-Hardener HU0001:

Outdoor usage, good weather resistance and light fastness, good adhesion as single layer coating on aluminum, finer structure, longer pot life, gloss value is reduced by 10 to 20 units geometry 60°; special effect has to be adjusted ex works.

Test condition

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on FS1046GRA910, pure white RAL 9010 and hardening with EFDEDUR-Hardener HU0032

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.