

EFDEDUR

System-Structurecoat FS9115V

V = Variation to the existing standard system

- Two component structured paint with solvent
- On powder coating co-ordinated system
- With self forming effect
- Silicone oil contains
- Fast drying
- For indoor usage
- For structure effects in a processing step (orange peeling)
- Processing after hardener addition without thinner addition
- Very good sagging limit and hiding power

Technical / Physical Data	Resin/ binder	alkyd resin, silicone oil contains
	Colour	between powder coating and RAL-Colour or customers sample and/or customer specification
	Gloss value visuell	satin glossy
	Original viscosity	4000 to 5000 mPa.s / Spindel 5
	Mixing ratio by weight	6 : 1
	Mixing ratio by volume	4,4 : 1
	Hardener Base	EFDEDUR-Hardener HU0180 polyisocyanate see „Special remarks“
	Spec. resistance after hardener addition „Ransburg“ – testing tool	500 to 1000 k Ohm
	Potlife after hardener addition	approx. 4 h / 20 °C
	Thinner	EFD-Thinner 400320 or EFD-Thinner 400500
	Density after hardener addition, calculated	1,35 g / ml + / - 0,1
	Solid content after hardener addition, calculated	74 % + / - 1
	Solid content in volume after hardener addition, calculated	440 ml / kg + / - 5
	Material usage calculated, after hardener addition in original viscosity, without application loss	105 to 115 g / m ² dry film thickness 50 µm
	Consumption Calculated, after hardener addition in original viscosity, without application loss	8,5 to 9,5 m ² / kg dry film thickness 50 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).
As application possibilities that is suitable high pressure-, low pressure-
as well as the airless-spraying.

The application has to done with 1 to 2 cross coats (self-creating structure/orange peel structure)
recommendet dry film thickness: 50 to 70 microns
The surface structures of the coating can be altered
by varying of spraying pressure, size of spraying nozzle, as well as viscosität of the coating material

airless-spraying:	in original viscosity after hardener addition nozzle size: 0,33 mm (0,013 inch) pressure of material: 100 to 120 bar
pneumatic-spraying:	in original viscosity after hardener addition nozzle size: 0,33 mm / 50° geometry (1350) pressure of material: 100 to 120 bar spraying (atomizer) pressure: 2 to 3 bar
electrostatic-spraying: by roller/brush	possible in original viscosity after hardener addition

Substrates

steel

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: steel
top coat: EFDEDUR-System-Structurecoat FS9115V

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 100°C possible (object temperature)

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 in the order documents as well as on the 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.

Hardener are taking influence on the gloss (see page 1).

Test condition

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on FS9115VH3293, HOMAG white and hardening with EFDEDUR-Hardener HU0180

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.