

# EFDEDUR

## HighSolid-Structure Paint GS1080H

- Two component structure paint with solvent
- Silicone-free
- Fast drying
- In- and outdoor usage
- For structure effects in a processing step

<b>Technical / physical data</b>	<b>Resin/ binder</b>	acryl resin to be hardened with isocyanate
	<b>Colour</b>	acc. to RAL 840 HR other colour shades on request
	<b>Gloss value</b> DIN 67530 and DIN EN ISO 2813	satin mat 20 to 35 geometry 60° (smooth, without structure)
	<b>Delivery viscosity = Processing viscosity</b>	2000 to 7000 mPa.s / Sp. 5 the delivery viscosity is structure dependent
	<b>Mixing ratio</b> by weight	coarse structure= micro structure =
		10 : 1 HU0140 7 : 1 HU0400
	<b>Mixing ratio</b> by volume	coarse structure= micro structure =
		6,5 : 1 HU0140 4,3 : 1 HU0400
	<b>Hardener-Typ</b>  base	coarse structure= micro structure =  EFDEDUR-Hardener HU0140 EFDEDUR-Hardener HU0400 polyisocyanate
	<b>Potlife</b> after hardener addition	approx. 2 h / 20 °C
	<b>Thinner</b>	see „Processing and application“
	<b>Density</b> after hardener addition calculated	1,5 g / ml + / - 0,1
	<b>Solid content</b> after hardener addition calculated	81 % + / - 2
	<b>Solid content in volume</b> after hardener addition calculated	430 ml / kg + / - 30
	<b>Material usage</b> calculated, after hardener addition in original viscosity, without application loss	180 to 190 g / m <sup>2</sup> dry film thickness 70 to 90 µm see “Special remarks”
	<b>Spreading rate</b> calculated after hardener addition in original viscosity, without application loss	5 bis 6 m <sup>2</sup> / kg dry film thickness 70 to 90 µm see “Special remarks”

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**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.

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**Processing and application**

**Application**

Components are to be mixed homogeneously (e.g. with high-speed mixer). Suited application methods are: high pressure, low pressure and airless. 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

Spraying-airless: e.g. WAGNER Aircote®  
Nozzle identification: 11/40  
Materialdruck: 80 to 120 bar  
Atomizer pressure: 2 to 3 bar

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

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**Substrates**

steel, non ferrous metal: single layer coat

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**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.

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**Application temperature**

above 10 °C

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**Drying**

air drying at 20°C

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)

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**Recoatability**

after sanding with the same system.

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**Cleaning of working equipment**

EFD-Thinner 400500

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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.

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**Special remarks****Test condition**

All information is based on a standard climate 20/65 DIN 50014.

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on GS1080HRA735, light grey in satin mat adjustment.

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.

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