



WU1406H_HU0448 EFDEDUR-Hydro-Coating

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	On blasted steel plate
Structure recommendation	Primer	WE1935MRU124 Mixing ratio 8:1/ HE0041 Dry film thickness 60 µm
Structure recommendation	Top coat	WU1406HS2615 Mixing ratio 4:1/ HU0448 Dry film thickness 40 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.	
Hardener	HU0448 see technical data sheet	
Mixin ratio	Parts by weight 4:1 Volume parts 3,3:1	
Thinning	demineralised water	
Dry film thickness	must not exceed 60 µm – risk of reaction bubbles.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	
Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %	
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	40-70 sec. / 4 mm viscosity cup Nozzle 0,23 mm angle 40° Material pressure 80 bar Atomiser pressure 4 bar	DIN 53211
High pressure spraying	30-40 sec. / 4 mm Flow cup Nozzle 1,5 mm Injection pressure 3 bar	DIN 53211
Rolling/painting	as delivered viscosity	



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Material usage	without application loss 110-120 g/m ² layer thickness 40 µm after addition of hardener	theoretical
Air drying	18-22 °C, 40-60 % relative humidity	
Oven drying	up to 70 °C possible	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 8 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 8 day/s (pendulum damping)	DIN EN ISO 1522
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.
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 111 + 510.
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.
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.