FS1046H_HU0032
EFDEDUR-Structure Coating

Product description

Product technology	solvent-based 2-component coating
Application	for interior use
Drying	quickly
Content	Silicone
Mechanical resistance	good
Chemical resistance	good
Substrate	Steel

General product properties

Binder-Base	Acrylic Resin	
Colour	All common colour shades	
Gloss visually	satin mat	The gloss level is mainly depending on the layering as well as ist application- and baking conditions.
Viscosity	600-800 mPa*s, spindle 3, 60 revolutions/min.	DIN EN ISO 2555
Density	1,1-1,4 g/cm³	theoretical
Solid mass	59-67 % after addition of hardener	theoretical
Solid content in volume	41-51 % after addition of hardener	theoretical
Reference product	The specified values refer to the product FS1046HRA735.	
Resistance to storage	approx. 12 month in original packagings at an ambient temperature of 5 to 25 °C. 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.	

FreiLacke | Emil Frei GmbH & Co. KG

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

FS1046H_HU0032
EFDEDUR-Structure 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	Steel
	Top coat	FS1046HRA735 Mixing ratio 5:1 HU0032 Dry film thickness 40-60 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Hardener	HU0032	
Mixin ratio	Parts by weight 5:1	
Processing conditions	from 10 °C to 25 °C	
Processing time	max. 6 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
Airless spraying	as delivered viscosity after curing agent addition Nozzle 0,33-0,38 mm Angle 40° Material pressure 100-120 bar	
High pressure spraying	as delivered viscosity after adding curing agent nozzle 1,8-2,0 mm spray pressure 4-5 bar	
Rolling/painting	as delivered viscosity after curing agent addition	
Electrostatic	possible, system-specific	
Material usage	without application loss 100-170 g/m² layer thickness 50 µm after addition of hardener	theoretical
Air drying	18-22 °C, 40-60 % relative humidity	
Oven drying	up to 70 °C possible (object temperature)	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 7 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 14 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	EFD dilution 400500	

FreiLacke | Emil Frei GmbH & Co. KG

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

FS1046H_HU0032
EFDEDUR-Structure Coating

Further processing of coated pieces

Repainting	Use solvent-based FreiLacke primer on fully cured coatings as an adhesion promoter; grind substrate if necessary.

Comments

Liability test	Recommended performing adhesion tests if substrates painted differ from those mentioned in the product description.
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.

FreiLacke | Emil Frei GmbH & Co. KG

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