



## WU1017D\_HU0117\_METALLIC EFDEDUR-Hydro-Metal Effectcoat

### Product description

<b>Product technology</b>	water-thinnable 2C coating
<b>Application area</b>	e.g. in the mechanical engineering and plant construction sector
<b>Surface finish</b>	Metallic effect
<b>Surface</b>	Different structures are possible depending on application and viscosity.
<b>Stability</b>	good
<b>Drying</b>	quickly
<b>Substrate</b>	Non-ferrous metals, Steel, Primer

### General product properties

<b>Binder-Base</b>	Acrylic Resin
<b>Colour</b>	Metallic colour shades
<b>Gloss visually</b>	satin mat <span style="float: right;">The gloss level is mainly depending on the layering as well as ist application- and baking conditions.</span>
<b>Viscosity</b>	750-1050 mPa*s, spindle 5, 60 revolutions/min. <span style="float: right;">DIN EN ISO 2555</span>
<b>pH-Value</b>	8-9 <span style="float: right;">DIN 19260</span>
<b>Solid mass</b>	54-57 % after addition of hardener <span style="float: right;">theoretical</span>
<b>Solid content in volume</b>	42-46 % after addition of hardener <span style="float: right;">theoretical</span>
<b>Reference product</b>	The values given refer to the product with the shade WU1017DRA906.
<b>Resistance to storage</b>	<p>approx. 9 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. Open packages are to be used within a short time.</p> <p>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.</p>



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### Application and processing

<b>Pretreatment</b>	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.	
<b>Structure recommendation</b>	Substrate	On iron-phosphated steel plate
	Top coat	WU1017DRA906 Mixing ratio 6:1/ HU0117 Dry film thickness 60 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
<b>Hardener</b>	HU0117 see technical data sheet	
<b>Mixin ratio</b>	Parts by weight 6:1	
<b>Thinning</b>	demineralised water	
<b>Dry film thickness</b>	must not exceed 100 µm – risk of reaction bubbles.	
<b>Object temperature</b>	10-30 °C, minimum +3 °C above dew point temperature	
<b>Processing conditions</b>	Room temperature 18-22 °C Relative humidity 40-60 %	
<b>Processing time</b>	max. 5 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
<b>Airmix spraying</b>	30-60 sec. / 6 mm viscosity cup Nozzle 0,33 mm angle 30° Material pressure 100 bar Atomiser pressure 2 bar	DIN 53211
<b>High pressure spraying</b>	30-60 sec. / 6 mm Flow cup Nozzle 2 mm Injection pressure 3 bar	DIN 53211
<b>Rolling/painting</b>	as delivered viscosity	
<b>Electrostatic</b>	possible, system-specific	
<b>Material usage</b>	without application loss 150-160 g/m <sup>2</sup> layer thickness 60 µm	theoretical
<b>Air drying</b>	18-22 °C, 40-60 % relative humidity	
<b>Oven drying</b>	up to 70 °C possible	



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<b>Dust drying</b>	after 15 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 4 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 8 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	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.	

### Further processing of coated pieces

<b>Repainting</b>	possible with same quality, dry at the earliest after matting.
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### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 111 + 510.
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	<p>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.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>