



## WU1450\_HU0127 EFDEDUR-Hydro-Top coat

### Product description

<b>Product technology</b>	water-thinnable 2C coating
<b>Application area</b>	e.g. in the vehicle construction sector

### General product properties

<b>Binder-Base</b>	Acrylic Resin	
<b>Viscosity</b>	150 - 200 mPa*s, spindle 5, 60 revolutions/min.	DIN EN ISO 2555
<b>Solid mass</b>	50 - 55 % after addition of hardener	theoretical
<b>Solid content in volume</b>	40 - 45 ml/kg after addition of hardener	theoretical
<b>Resistance to storage</b>	<p>approx. 12 month in original packagings at an ambient temperature of 18 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>	

### Application and processing

<b>Tool/mould</b>	<p>Metal forms</p> <p>GRP types (of glass fibre-reinforced plastic)</p>	
<b>Pretreatment</b>	The substrate must be free of adhesion-improving substances such as oil, grease, rust, scale, mill scale, wax and release agent residues.	
<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>	HU0127	
<b>Mixin ratio</b>	Parts by weight 3 : 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>	<p>Room temperature 18-28 °C</p> <p>Relative humidity 30-80 %</p>	
<b>Processing time</b>	<p>max. 3 hrs. / 20 °C</p> <p>End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.</p>	
<b>Airmix spraying</b>	<p>20 - 30 sec. / 4 mm viscosity cup</p> <p>Nozzle 0,28 mm angle 30°</p> <p>Material pressure 160 bar</p> <p>Atomiser pressure 2-3 bar</p>	DIN 53211



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<b>High pressure spraying</b>	20-30 sec. / 4 mm Flow cup Nozzle 1,6 mm Injection pressure 2 - 2,5 bar	DIN 53211
<b>Oven drying</b>	up to 80 °C possible	
<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. Do not mix curing agent with water! The cleaning must be carried out with organic solvents.	

### Further processing of coated pieces

<b>Repainting</b>	possible after grinding. Clean the grinded surface removing adhesion-impairing materials afterwards.
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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>	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.