

EFDEDUR

Structure Paint FS1415

- Two component structured paint with solvent
- With self forming effect
- Silicone oil contains
- Fast draying
- For in/outdoor usage
- For structure effects in one processing step (orange peeling)
- Processing after hardener addition without thinner addition

Technical / Physical Data	Resin/ binder	alkyd resin, contains silicone oil	
	Colour	acc. to RAL 840 HR other colour shades on request	
	Gloss value visuel	satin mat	
	Original viscosity	3000 bis 4000 mPa.s / Spindel 5	
	Mixing ratio	6 : 1	
	Hardener Base	EFDEDUR-Hardener HU0180 polyisocyanate see „Special remarks“	
	Spec. resistance after hardener addition „Ransburg“ – testing tool	500 to 1000 k Ohm	
	Potlife after hardener addition	6 h / 20 °C	
	Thinner	EFD-Thinner 400320 or EFD-Thinner 400500	
	Density after hardener addition, calculated	1,33 g / ml + / - 0,01	
	Solid content after hardener addition, calculated	70 %	+ / - 3
	Solid content in volume after hardener addition, calculated	440 ml / kg + / - 20	
	Material usage after hardener addition calculated, without application loss	110 to 120 g / m ² dry film thickness 50 µm	
	Consumption after hardener addition calculated, without application loss	8,5 to 9,0 m ² / kg dry film thickness 50 µm	

Storability Approx. 12 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.



Processing and application

Application

Components are to be mixed homogeneously (e.g. with high-speed mixer).

Suitable applications are: high pressure-, low pressure- as well as the airless-spraying.

The application has to done with 1 to 2 cross coats (self-creating structure/orange peel structure) recommended dry film thickness: 50 to 70 microns. The surface structures of the coating can be altered by varying of spraying pressure, size of spraying nozzle, as well as viscosity of the coating material

airless-spraying: in original viscosity after hardener addition

nozzle size: 0,33 mm (0,013 inch)

pressure of material: 100 to 120 bar

pneumatic-spraying: in original viscosity after hardener addition

nozzle size: 0,33 mm / 50 ° geometry (1350)

pressure of material: 100 to 120 bar

spraying (atomizer) pressure: 2 to 3 bar

electrostatic-spraying: possible

by roller:

in original viscosity after hardener addition

Substrates

steel

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.

Proposal for a coating system:

substrate: steel

top coat: EFDEDUR- Structure Paint FS1415

Application temperature

above 10 °C

Drying

air drying at 20°C

dust dry: after 30 min. (degree of drying 1/ DIN 53150)

dry to touch: after 5 h (degree of drying 4/ DIN 53150)

complete dry: after 8 days (swinging beam hardness/ ISO 1522)

oven drying: to 100°C possible (object temperature)

Repair coating

EFDEDUR-Pre-Coatinf UR1900MRU910, white applied on totally hardened coating should be used as adhesion promotor if nec. sanding the surface.

Cleaning of working equipment

EFD-Thinner 400500

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, sayfety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Information about Hardener:

The hardener mentioned on page 1 are stated as standard components for this paint system. The standard hardener is also written in the order documents as well as on the label.

Furthermore there are additional hardeners , which can be used as alternative in case the standard components doesn't meet the requirements. These products are tailor-made e.g. faster or slower hardening.

Hardener are taking influence on the gloss (see page 1).

Test condition

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on FS1415HRA735, and hardening with EFDEDUR-Hardener HU0180

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

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.