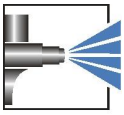
FreiLacke



EFDEDUR-Hydro-Strukturlack
WU1008M/HU0208

Characteristics	Water-thinnable 2C coating	
	Application, e.g. in the mechanical engineering and plant construction sector	
	Structure effect	
	Fast initial drying	
	Forced drying possible	
	Good chemical resistance	
	Good adhesion to steel and non-ferrous metals	
	Good stability	
Technical / Physical Data	Binder-Base	Acrylate resin crosslinked with polyisocyanate
	Colour	All common colour shades
	Gloss value visual	mat
	Viscosity	4000-5000 mPa.s/ Spindle 5 60 revolution/ min.
	Hardener	HU0208 See technical data sheet
	Mixing ratio	Parts by weight 6:1
	Mixing ratio	Parts by volume 4,2:1
	Thinner	demineralised water
	pH-Value	8,4-8,6
	Density calculated	1,40-1,44 g/ml
	Density calculated	1,34-1,37 g/ml after adding hardener
	Solid Mass calculated	61,64 %
	Solid Mass calculated	62,5-65 % after adding hardener
	Solid content in volume calculated	309-328 ml/kg
	Solid content in volume calculated	353-370 ml/kg after adding hardener
	Material usage theoretical, without application loss	216-226 g/m², Layer thickness 80 µm
	Reference colour of the specified values	Colour of WU1008MRA903
Substrate	Steel, passivated or pretreated substrates	
	Primer	
Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease,	

DIN EN ISO 9001
IATF 16949
EMAS

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	rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding	
Structure recommendation	Substrate	on iron-phosphated steel plate
	Top coat	WU1008MRA903 Mixing ratio 6:1/ HU0208 Dry film thickness 80 µm
Mechanical Test	Cross-cut-test DIN EN ISO 2409	Gt 0
	Temperature resistance	Short time loading 120°C
	Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.
Processing and application	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water. Dry film thickness must not exceed 100 µm - risk of reaction bubbles.	
	Object temperature	10-30 °C
	Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %
	Processing time	max. 5 hrs./ 20 °C The processing time can decrease at higher temperatures and/or under pressure.
	Airmix spraying	30-60 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 0,33 mm Angle 30° Material pressure 100 bar Atomiser pressure 2
	High pressure spraying	30-60 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 2 mm Spray pressure 3 bar
	Rolling / painting	as delivered viscosity
	Electrostatic	possible, system-specific
	Over-coating capability	possible with same quality, dry at the earliest after matting
	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.
	Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.	
Curing	Air drying	at 20°C, 50% relative humidity with air movement
	Dust drying	after 15 min. (degree of drying 1/ DIN EN ISO 9117-5)

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	Dry to the touch	after 4 hrs. (degree of drying 4/ DIN EN ISO 9117-5)
	Full drying	after 8 days (pendulum damping/DIN EN ISO 1522)
	Oven drying	possible to 80°C

Resistance to storage

- Approx. 12 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.

  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.

Specific comments

- **EFD-info**
  Refer to the EFD information for further technical information.
  Nr. 111 + 510
- **Test conditions**
  All information is based on a standard climate 23/50 DIN EN 23270.
  All information is based on our product knowledge and 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.

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