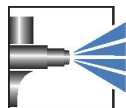


EFDEDUR-Hydro-Coating

WU1488H/HU0448

Characteristics	■ Water-thinnable 2C coating ■ Application, e.g. in the mechanical engineering and plant construction sector ■ Forced drying possible ■ Good light and weather resistance																																		
Technical / Physical Data	<table> <tr> <td>■ Binder-Base</td><td>Acrylate resin crosslinked with polyisocyanate</td></tr> <tr> <td>■ Colour</td><td>All common colour shades</td></tr> <tr> <td>■ Gloss value DIN EN ISO 2813</td><td>satiny glossy 55-70 Angle 60°</td></tr> <tr> <td>■ Viscosity DIN 53211 (formerly)</td><td>Flow time 35-45 seconds 4 mm viscosity cup</td></tr> <tr> <td>■ Hardener</td><td>HU0448 See technical data sheet</td></tr> <tr> <td>■ Mixing ratio</td><td>Parts by weight 5:1</td></tr> <tr> <td>■ Mixing ratio</td><td>Parts by volume 3,8:1</td></tr> <tr> <td>■ Thinner</td><td>demineralised water</td></tr> <tr> <td>■ pH-Value</td><td>8,2-8,7</td></tr> <tr> <td>■ Density calculated</td><td>1,15-1,40 g/ml</td></tr> <tr> <td>■ Density calculated</td><td>1,1-1,3 g/ml after adding hardener</td></tr> <tr> <td>■ Solid Mass calculated</td><td>46-57 %</td></tr> <tr> <td>■ Solid Mass calculated</td><td>46-57 % after adding hardener</td></tr> <tr> <td>■ Solid content in volume calculated</td><td>270-350 ml/kg</td></tr> <tr> <td>■ Solid content in volume calculated</td><td>280-360 ml/kg after adding hardener</td></tr> <tr> <td>■ Material usage theoretical, without application loss</td><td>100-110 g/m², Layer thickness 40 µm after adding hardener</td></tr> <tr> <td>■ Reference colour of the specified values</td><td>Colour of WU1488HRA735</td></tr> </table>	■ Binder-Base	Acrylate resin crosslinked with polyisocyanate	■ Colour	All common colour shades	■ Gloss value DIN EN ISO 2813	satiny glossy 55-70 Angle 60°	■ Viscosity DIN 53211 (formerly)	Flow time 35-45 seconds 4 mm viscosity cup	■ Hardener	HU0448 See technical data sheet	■ Mixing ratio	Parts by weight 5:1	■ Mixing ratio	Parts by volume 3,8:1	■ Thinner	demineralised water	■ pH-Value	8,2-8,7	■ Density calculated	1,15-1,40 g/ml	■ Density calculated	1,1-1,3 g/ml after adding hardener	■ Solid Mass calculated	46-57 %	■ Solid Mass calculated	46-57 % after adding hardener	■ Solid content in volume calculated	270-350 ml/kg	■ Solid content in volume calculated	280-360 ml/kg after adding hardener	■ Material usage theoretical, without application loss	100-110 g/m², Layer thickness 40 µm after adding hardener	■ Reference colour of the specified values	Colour of WU1488HRA735
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Substrate	■ Primer																																		
Pretreatment	■ The substrate must be free of adhesion-impairing substances such as oil, grease, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate.																																		
Structure recommendation	<table> <tr> <td>■ Substrate</td><td>on blasted steel plate</td></tr> <tr> <td>■ Primer</td><td>WE1935MRU124 Mixing ratio 8:1/ HE0041 Dry film thickness 60 µm</td></tr> </table>	■ Substrate	on blasted steel plate	■ Primer	WE1935MRU124 Mixing ratio 8:1/ HE0041 Dry film thickness 60 µm																														
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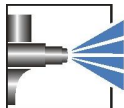


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	■ Top coat	WU1488HRA735 Mixing ratio 5:1/ HU0448 Dry film thickness 40 µm
Mechanical Test	■ Cross-cut-test DIN EN ISO 2409	Gt 0
Resistance Test	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2
	■ Salt spray test (NSS) DIN EN ISO 9227	504 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8
	■ 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 80 µm - risk of reaction bubbles.	
	■ Object temperature	10-30 °C
	■ Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	■ Processing time	max. 3 hrs./ 20 °C End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.
	■ Airmix spraying	40-70 Sec./ 4 mm Viscosity cup (DIN 53211) Nozzle 0,23 mm Angle 40° Material pressure 80 bar Atomiser pressure 4
	■ High pressure spraying	30-40 Sec./ 4 mm Viscosity cup (DIN 53211) Nozzle 1,5 mm Spray pressure 3 bar
	■ Rolling / painting	as delivered viscosity
	■ 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. Do not mix curing agent with water! The cleaning must be carried out with organic solvents.
	■ 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.

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Curing	■ Air drying	at 20°C, 50% relative humidity with air movement
	■ Dust drying	after 30 min. (degree of drying 1/ DIN EN ISO 9117-5)
	■ Dry to the touch	after 8 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 70°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.	