EFDEDUR

System-Structurecoat
GS9128

- Two component structure paint with solvent
- On powder coating co-ordinated system
- Standard-System: GS1928 EFDEDUR-Structure Paint
- Silicone-free
- Indoor usage
- For structure effects in a processing step orange peeling and two processing steps splatter effect
- Good mechanical and chemical resistance for special applications

Technical / physical data		
Resin/ binder		acryl resin to be hardened with isocyanate
Colour		between powder coating and RAL-colour or costumer sample (customer´s requirement)
Gloss value		after powder sample
Original viscosity		650 to 850 mPa.s / Spindel 3
Mixing ratio by weight		5 : 1 HU0040 / HU0032 / HU0001 10 : 1 HU0010
Hardener-Typ base	Standard-Hardener = Alternative-Hardener =	EFDEDUR-Hardener HU0040 EFDEDUR-Hardener HU0032 / HU0001 / HU0010 polyisocyanate see „Special remarks"
Potlife after hardener addition		approx. 6 h / 20 °C
Thinner		EFD-Thinner 400320 or 400500
Density after hardener addition, calculated		1,2 g / ml + / - 0,1
Solid content after hardener addition, calculated		67 % + / - 2
Solid content in volume after hardener addition, calculated		425 ml / kg + / - 10
Material usage calculated, after hardener addition in original viscosity, without application loss		90 to 140 g / m² dry film thickness 40 to 60 µm

Storability	
	Approx. 24 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.

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FreiLacke

Processing and application	**Application**

Application
Components are to be mixed homogeneously (e.g. with high-speed mixer).
Suited application methods are: high pressure, low pressure and spraying-airless.

Following the addition of the curing agent, set the processing viscosity in accordance with the respective application process. Depending on the desired texture, the application takes place in one (self-forming texture) or in two operations (sprinkle effect):
1) smooth pre-spraying
   following the drying of the coating surface (approx. 30 min. / 20 °C)
2) sprinkle the desired texture using reduced spray pressure

By changing the spray pressure, nozzle diameter and coating viscosity, different surface structures can be achieved. Too high material pressure can for the degradation of the structural image lead (flatten structure).

spraying-airless: in original viscosity after hardener addition
                        nozzle: 0,33 to 0,38 mm   spraying pressure: 100 to 120 bar
spraying-highpressure: in original viscosity after hardener addition
                        nozzle: 1,8 to 2,0 mm   spraying pressure: 4 to 5 bar
electrostic-spraying: possible
by roller/ brush: in original viscosity after hardener addition

Substrates
steel: single layer coat
non ferrous metal: primer necessary
plastics, wood: primer necessary

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: non ferrous metal, e.g. Aluminium
primer: FREIOPOX-Primer   ER1912
top coat: EFDEDUR- Structure Coat   GS9128

Application temperature above 10 °C

Drying   air drying at 20°C

dust dry: after 30 min.   (degree of drying 1/ DIN EN ISO 9117-5)
dry to touch: after 8 h   (degree of drying 4/ DIN EN ISO 9117-5)
complete dry: after 20 days   (swinging beam hardness/ DIN EN ISO 1522)

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

Cleaning of working equipment
EFD-Thinner 400500

Advise for safety protection and protection of health
The usual precautionery measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailled 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 and Thinner:**
	The hardener and the thinner mentioned on page 1 are stated as standard componentes 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 and thinners, 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).

Standard-Hardener HU0040:	good elasticity
Alternative-Hardener HU0032:	indoor usage, good mechanical and chemical stability, fast drying
Alternative-Hardener HU0001:	for indoor and outdoor usage, good UV-restistance
Alternative-Hardener HU0010:	Coarse structure for indoor and outdoor usage, with good UV-resistance, very good elasticity and good adhesion on ABS

Test condition

The statements concerning efficiency, drying and caution labelling depend
on colour shade. The values mentioned in this data sheet are based on GS9128HH2802 and hardening with HU0040.

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.