

EFDEDUR

Metal Effectcoat UR1044

- 2-component-PUR Metal Effect top coat with solvent
- Good working properties
- For industrial goods

Technical / Physical Data	Resin/ binder	polyacrylic resin to be hardened with isocyanate	
	Colour	matallic colour shades	
	Gloss value visuell	H =	satin glossy
		M =	tuff mat
	Original viscosity DIN 53211* without hardener	30 to 80 sec. / 4 mm cup	
	Mixing ratio by weight	10 : 1	
	Hardener base	EFDEDUR-Hardener polyisocyanate	HU0400
	Potlife after hardener addition	max. 4 h / 20 °C	
	Thinner	EFD-Thinner	400320
		EFD-Thinner	400500
	Density after hardener addition calculated	1,02 g / ml	+ / - 0,1
	Solid content after hardener addition calculated	46 %	+ / - 5
	Solid content in volume after hardener addition calculated	360 ml / kg	+ / - 10
Consumption calculated after hardener addition in original viscosity, without application loss	60 to 80 g / m ² dry film thickness 20 to 30 µm see „Special remarks“		

Storability Approx. 9 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).

spraying-highpressure: after hardener addition and viscosity adjustment to 16 to 20 sec.
nozzle: 1,2 to 1,8 mm spraying pressure: 3 to 5 bar

Substrates

steel, non ferrous metals

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	
primer:	FREOPOX-Primer	ER1912
top coat:	EFDEDUR-Metal Effectcoat	UR1044

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 3 h	(degree of drying 4/ DIN 53150)
complete dry:	after 5 days	(swinging beam hardness/ 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 precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety 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 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 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.

Test condition

*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

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

The statements concerning efficiency and drying depend on colour shade. The values mentioned in this data sheet are based on UR1044HRA906, white aluminium, satin glossy and hardening with HU0400.

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.