

E 4310

Product Description

Two-component acrylic-urethane enamel, with excellent durability and long recoating term.

Use

Decorative protection of metal surfaces, exploited outside and inside (in transport and construction sphere, for surfaces, operated in aggressive environments as part of approved systems according to ISO 12944).

Properties

Excellent resistance to weathering, temperature changes, salts, alkaline corrosion, marine environment, spraying with oil compounds, lubricants.

Colours

RAL

Gloss level: Gloss/Semi gloss/Mat

Technical properties

Technical properties	Test method	Values
Solid content	SR ISO 3251/2003	min 38%
Density	BNS EN ISO 2811-1	0,990 ±1,2g/cm ³
Flash point	ISO 2719:2016	27°C
VOC values	BNS EN ISO11890-1:2008	400g/l

Recommended thickness of layer

Dry film	30-40µm
Wet film	65-80µm
Theoretic consumption	130-140g/m ² , depending on the required thickness of dry film.

Substrates & Surface preparation

To achieve maximum adhesion and durability of the system, the surface preparation must comply with the following requirements:

Surface	Minimum	Recommended
Ferrous metals	Rust cleaning with sandblasting or blasting, up to Grade St2, according to ISO 8501-1	Rust cleaning with sandblasting or blasting, up to Grade Sa 2 ½, according to ISO 8501-1
	Cleaning, drying and no visible surface injuries according to ISO 12944-4 6.1	

Application equipment and Application Conditions

Machine Equipment, conventional and airless spray (airless-air assistance)

Ambient temperature from 10 to 30 °C

Humidity of the environment , max 65%

Information on nozzles and pressure for machine application

Conventional Spray nozzle - 1.3mm; pressure - 3-4atm;

Mixing

by weight 100g E4310 is mixed with 20g I 3538N

The prepared mixture is left for pre-reaction for about 30 minutes at 20-23 ° C, Thinner D 4300 is added in a ratio according to the chosen application method.

Pot life of the mixture: The prepared mixture should be used within 3-4 hours at (t=20°C).

Thinning and cleaning of tools:

Conventional spray - up to 5-15% with Thinner D 4300

Drying and Curing Schedule

At temperature	23°C	80°C
Dust dry	1h	
Touch dry	8h	
Full drying	14h	30min

The times mentioned in the above table are measured in a laboratory environment at a controlled temperature and air humidity. Depending on different application environments these values may vary.

Surface Drying - time necessary for touch dry

Time for application of the second layer is 10-15 minutes (wet to wet) at 20-23°C or after complete drying of the previous layer.

In the case of accelerated drying (80°C), a flash of time of 25-30min is needed

Product compatibility

Acrodur 4310 can be used in combination with the below listed primers:

- For ferrous metals surfaces - with G 3500, G3733, G3100, G3119AcZn;
- For cold and hot galvanized surfaces - with G 3733, G 3119AcZn+ Epoxy primer with MIOX;

For other types of coatings or special requirements, please contact us.

Packaging

Metal package 15kg (18kg)

Hardener I 3538N 1kg

Second package option refers to tinted product.

Depending on the color of the product and the individual requirement of the customer, the packages may vary.

Storage

The product should be stored in closed, dry and fire-proof warehouses and premises at a temperature of not more than 30 ° C. Do not expose to direct sunlight. Keep out of reach of children!

Shelf life:

12 months from production date in factory-sealed package.

Safety

According to safety data sheet (MSDS).

