

E 4310 Tinting

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(min 80%)

Technical properties

Technical properties	Test method	Values
Solid content(volume) A+B		38 - 46%
Density A+B	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	85-100g/m ² , 11-14m ² /l

Depending on the color, consumption may vary

Losses during application depend on the type of the coated object, the surface preparation and the equipment used. They must be calculated separately.

Substrates & Surface preparation

E 4310 must be applied according to the recommended application system, on pre-primed, clean and degreased surfaces. E 4310 is applied depending on the intervals recommended in the technical description of the primer for application of a subsequent finishing layer

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%

Substrate temperature must be at least 3°C above the dew point

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 3500, G 3119AcZn+ Epoxy primer with MIOX;

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

Packaging

Metal package 18kg
Hardener I 3538N 1kg

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).

This Technical Data Sheet is intended to inform Customers of the product concerned. Policolor-Orgachim invites customers to check the quality of the product and carry out trial application before use, to use the product properly, to comply with the application conditions in accordance with the label instructions and technical parameters. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the Technical Data Sheet for this product. Due to the lack of control over the conditions and manner of application, the manufacturer does not guarantee /without prior written confirmation/ its durability or any direct or indirect consequential damages caused or related to the way the product is used or laid, in case the product is used for purposes other than the purpose indicated on the label and in this technical data sheet; We guarantee the properties and qualities of the product insofar as this product is not exposed to external factors and impacts that could not be foreseen by us and could not be taken into account in the preparation of this Technical Data Sheet. Policolor-Orgachim will not accept any liability in the above cases unless consent has been given explicitly, liability is imposed by legal provisions or arising from commercial obligations. As the information contained in this Technical Data Sheet is subject to periodic changes, please make sure, via our web sites or technical team, that this description is the latest and has not been replaced by a new version.

