



## ER1904G\_HE0020\_CLEARCOAT FREOPOX-Clearcoat

### Product description

<b>Product technology</b>	solvent-based 2-component coating	
<b>Abrasion resistance</b>	good	
<b>Chemical resistance</b>	very good	
<b>Substrate</b>	Steel, Aluminium	

### General product properties

<b>Binder-Base</b>	Epoxy resin	
<b>Colour</b>	colourless	
<b>Gloss visually</b>	glossy	
<b>Viscosity</b>	Flow time 12-17 sec., 4 mm flow cup	DIN 53211
<b>Density</b>	0,95-1,00 g/ml after addition of hardener	theoretical
<b>Solid mass</b>	36,5-37,0 % after addition of hardener	theoretical
<b>Solid content in volume</b>	29,5-30,5 % after addition of hardener	theoretical
<b>Reference product</b>	The specified values refer to the product ER1904GRA999.	
<b>Resistance to storage</b>	<p>approx. 18 month in original packagings at an ambient temperature of 5 to 25 °C. Open packages are to be used within a short time.</p> <p>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.</p>	



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### Application and processing

<b>Pretreatment</b>	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, mill scale, wax and release agent residues. We recommend the use of suitable mechanical pre-treatment processes (e.g. blasting, grinding) or chemical pre-treatment processes (e.g. phosphating) according to the requirements.	
<b>Structure recommendation</b>	Substrate	Aluminium
	Clearcoat	ER1904GRA999 Dry film thickness 4:1 HE0020 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
<b>Hardener</b>	HE0020	
<b>Mixin ratio</b>	Parts by weight 4:1	
<b>Thinning</b>	EFD dilution 400424	
<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>Processing time</b>	max. 12 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
<b>High pressure spraying</b>	as delivered viscosity after adding curing agent nozzle 1,4 mm spray pressure 3-4 bar	
<b>Rolling/painting</b>	as delivered viscosity after curing agent addition	
<b>Material usage</b>	without application loss 95-100 g/m <sup>2</sup> layer thickness 30 µm after addition of hardener	theoretical
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Oven drying</b>	up to 70 °C possible (object temperature)	
<b>Dust drying</b>	after 90 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 24 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 7 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	with EFD dilution 400424 within the processing time.	



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### Further processing of coated pieces

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#### Repainting

possible after grinding. Clean the grinded surface removing adhesion-impairing materials afterwards.

### Comments

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#### EFD info

Further technical information can be found in the EFD Info. No. 170.

#### Work-and Healthprotection

The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning Health and Safety at Work and environmental protection can be found in the corresponding safety data sheet.

#### 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.