

FREOPOX

Primer ER1925M

- Solvent based prime
- Good corrosion protection
- High filling power
- For industrial goods and all kinds of construction machinery

Technical / Physical Data	Resin/ binder	epoxy resins	
	Colour	acc. RAL 840 HR other colour shades on request	
	Gloss value visual	mat	
	Original viscosity DIN 53211* without hardener	60 to 70 sec. / cup 4 mm	
	Mixing ratio by weight	3 : 1	
	Mixing ratio by volume	2,3 : 1	
	Hardener base	FREOPOX-Hardener HE0051 Phenalcamide	
	Potlife after hardener addition	max. 3 h / 20°C	
	Thinner	EFD-Thinner 400009	
	Density after hardener addition, calculated	1,21 g / ml + / - 0,01	
	Solid content after hardener addition, calculated	60 % + / - 1	
	Solid content in volume after hardener addition, calculated	452 ml / kg + / - 5 or 45 % + / - 2	
	Consumption calculated, after hardener addition in original viscosity, without application loss	214 g / m ² dry film thickness 80 µm see „Special remarks“	
	Spreading rate calculated, after hardener addition in original viscosity, without application loss	4,2 - 5,3 m ² / kg dry film thickness 80 µm see „Special remarks“	

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

Processing and application**Application**

Before adding the hardener ER1926M has to be stirred up carefully by high-speed-mixer.

Components are to be mixed homogeneously (e.g. with high-speed mixer).

spraying-airless:	in original viscosity after hardener addition nozzle: 0,23 mm or 0,009 inch angle 40°
spraying-airless:	in original viscosity after hardener addition nozzle: 0,23 mm or 0,009 inch angle 20°
spraying-high-pressure:	in original viscosity after hardener addition nozzle: 1,5 to 2,0 mm spray pressure 4 to 5 bar

Substrates

steel, stainless steel

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, purity at least SA 2 ½ "DIN EN ISO 12944-4") pretreatment.

Proposal for a coating system

substrate:	steel	
primer:	FREOPOX-Primer	ER1925M
top coat:	EFDEDUR-HighSolid-Topcoat	UR1449G

Application temperature

optimum 18°C to 24°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 4 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 7 days	(swinging beam hardness/ ISO 1522)

Overpaintableness

With itself after previous cleaning at every time
With 2K-PU-top coat after 20 to 40 min. or after drying by night

Cleaning of working equipment

With EFD-Thinner 400424 within the working time, completely dried paint can only mechanically be removed.

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**Test condition**

*Original viscosity according to DIN 53211:
DIN 53211 was withdrawn in Octobre 1996. On request the value is available according to DIN EN ISO 2431.

The statements concerning efficiency and drying depend on colour shade.
The values mentioned in this data sheet are based on ER1925MRU735, light grey hardened with HE0051.

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.

FREOPOX

Primer
ER1925M

FreiLacke

