



## WE1903D\_HE0005 FREOPOX-Hydro-Primer

### Product description

<b>Product technology</b>	water-thinnable 2C coating
<b>Application area</b>	e.g. in the mechanical engineering and plant construction sector
<b>Drying</b>	quickly
<b>Mechanical resistance</b>	good hardness and elasticity
<b>Substrate</b>	Steel, blasted, iron-phosphated steel

### General product properties

<b>Binder-Base</b>	Epoxy resin	
<b>Gloss visually</b>	matt	
<b>Viscosity</b>	500-1250 mPa*s, spindle 4, 60 revolutions/min.	DIN EN ISO 2555
<b>pH-Value</b>	8,0-9,0	DIN 19260
<b>Density</b>	1,25-1,30 g/ml after addition of hardener	theoretical
<b>Solid mass</b>	57-59 % after addition of hardener	theoretical
<b>Solid content in volume</b>	46-47 % after addition of hardener	theoretical
<b>Resistance to storage</b>	<p>approx. 12 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. 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>	

### 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	On blasted steel plate
	Primer	WE1903DRU113 Mixing ratio 12:1/ HE0005 Dry film thickness 80 µm
	Top coat	WU1488GRG743 Mixing ratio 4:1/ HU0444 Dry film thickness 70 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
<b>Hardener</b>	HE0005 see technical data sheet	



## WE1903D\_HE0005 FREOPOX-Hydro-Primer

<b>Mixin ratio</b>	Parts by weight 12:1	
<b>Thinning</b>	demineralised water	
<b>Dry film thickness</b>	must not exceed 250 µm – risk of reaction bubbles.	
<b>Object temperature</b>	10-30 °C, minimum +3 °C above dew point temperature	
<b>Processing conditions</b>	Room temperature 18-25 °C Relative humidity 40-60 %	
<b>Processing time</b>	max. 2,5 hrs. / 20 °C End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.	
<b>Airmix spraying</b>	as delivered viscosity after curing agent addition Nozzle 0,33 mm angle 30° Material pressure 120 bar Atomiser pressure 2,5 bar	
<b>High pressure spraying</b>	as delivered viscosity after adding curing agent nozzle 1,6 mm spray pressure 3 bar	
<b>Rolling/painting</b>	as delivered viscosity after curing agent addition	
<b>Material usage</b>	without application loss 210-230 g/m² layer thickness 80 µm after addition of hardener	theoretical
<b>Oven drying</b>	up to 70 °C possible	
<b>Air drying</b>	18-25°C °C, 40-60% % relative humidity	
<b>Dust drying</b>	after 45 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 5 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>	immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916, dried-on equipment with org. solvents, e.g. EFD thinner 400424.	

### Further processing of coated pieces

<b>Repainting</b>	possible with same quality, dry at the earliest after matting.
<b>Comments</b>	
<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 111 + 510.
<b>Work-and Healthprotection</b>	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.



## **WE1903D\_HE0005** **FREOPOX-Hydro-Primer**

### **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.