

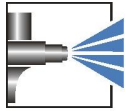


# FREOPOX-Hydro-Primer

## WE1436ML1991

<b>Characteristics</b>	<ul style="list-style-type: none"> <li>■ Water-thinnable 2C coating</li> <li>■ Application, e.g. in the vehicle construction sector</li> <li>■ Good hardness and elasticity</li> <li>■ Good corrosion protection</li> <li>■ Good adhesion to blasted metal substrates</li> </ul>																																		
<b>Technical / Physical Data</b>	<table border="1"> <tr> <td>■ Binder-Base</td> <td>Epoxy resin crosslinked with polyamine</td> </tr> <tr> <td>■ Colour</td> <td>All common colour shades</td> </tr> <tr> <td>■ Gloss value <small>visual</small></td> <td>mat</td> </tr> <tr> <td>■ Viscosity</td> <td>800-1500 mPa.s/ Spindle 4 60 revolution/ min.</td> </tr> <tr> <td>■ Hardener</td> <td>HE0436 See technical data sheet</td> </tr> <tr> <td>■ Mixing ratio</td> <td>Parts by weight 1:1</td> </tr> <tr> <td>■ Mixing ratio</td> <td>Parts by volume 0,75:1</td> </tr> <tr> <td>■ Thinner</td> <td>demineralised water</td> </tr> <tr> <td>■ pH-Value</td> <td>8,4-9,0</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,4-1,5 g/ml</td> </tr> <tr> <td>■ Density <small>calculated</small></td> <td>1,2-1,3 g/ml after adding hardener</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>64-65 %</td> </tr> <tr> <td>■ Solid Mass <small>calculated</small></td> <td>57,5-59,5 % after adding hardener</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>325-335 ml/kg</td> </tr> <tr> <td>■ Solid content in volume <small>calculated</small></td> <td>375-385 ml/kg after adding hardener</td> </tr> <tr> <td>■ Material usage <small>theoretical, without application loss</small></td> <td>150-160 g/m<sup>2</sup>, Layer thickness 60 µm after adding hardener</td> </tr> <tr> <td>■ Reference colour of the specified values</td> <td>Colour of WE1436ML1991</td> </tr> </table>	■ Binder-Base	Epoxy resin crosslinked with polyamine	■ Colour	All common colour shades	■ Gloss value <small>visual</small>	mat	■ Viscosity	800-1500 mPa.s/ Spindle 4 60 revolution/ min.	■ Hardener	HE0436 See technical data sheet	■ Mixing ratio	Parts by weight 1:1	■ Mixing ratio	Parts by volume 0,75:1	■ Thinner	demineralised water	■ pH-Value	8,4-9,0	■ Density <small>calculated</small>	1,4-1,5 g/ml	■ Density <small>calculated</small>	1,2-1,3 g/ml after adding hardener	■ Solid Mass <small>calculated</small>	64-65 %	■ Solid Mass <small>calculated</small>	57,5-59,5 % after adding hardener	■ Solid content in volume <small>calculated</small>	325-335 ml/kg	■ Solid content in volume <small>calculated</small>	375-385 ml/kg after adding hardener	■ Material usage <small>theoretical, without application loss</small>	150-160 g/m <sup>2</sup> , Layer thickness 60 µm after adding hardener	■ Reference colour of the specified values	Colour of WE1436ML1991
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<b>Substrate</b>	<ul style="list-style-type: none"> <li>■ Steel, passivated or pretreated substrates</li> </ul>																																		
<b>Pretreatment</b>	<ul style="list-style-type: none"> <li>■ The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding</li> </ul>																																		
<b>Structure recommendation</b>	<ul style="list-style-type: none"> <li>■ Substrate on blasted steel plate</li> </ul>																																		

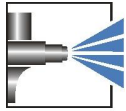
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	■ Primer	WE1436ML1991 Mixing ratio 1:1/HE0436 Dry film thickness 80 µm
	■ Top coat	WU1488GRG302 Mixing ratio 3,3:1 / HU0448 Dry film thickness 70 µm
<b>Mechanical Test</b>	■ Cross-cut-test DIN EN ISO 2409	Gt 0
<b>Resistance Test</b>	■ Condensate constant climate DIN EN ISO 6270-2 (CH)	480 hours Degree of blistering 0 (S ) DIN EN ISO 4628-2
	■ Salt spray test (NSS) DIN EN ISO 9227	1008 hours Water ingress Wb < 2,5 mm DIN EN ISO 4628-8
<b>Processing and application</b>	■	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water. Dry film thickness must not exceed 200 µm - risk of reaction bubbles.
	■ Object temperature	15-30 °C
	■ Processing conditions	Room temperature 18-22 °C Relative humidity 40-60 %
	■ Processing time	max. 3 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.
	■ Airless spraying	30-40 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle: 0,33 mm Angle 30° Material pressure 100 bar
	■ Airmix spraying	30-40 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 0,33 mm Angle 30° Material pressure 100 bar Atomiser pressure 4
	■ High pressure spraying	30-40 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 1,3 mm Spray pressure 4 bar
	■ Over-coating capability	possible with same quality, dry at the earliest after matting
	■ Cleaning of equipment	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.
	■ <b>Health &amp; Safety at Work guidelines</b>	The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.
<b>Curing</b>	■ Air drying	at 20°C, 50% relative humidity with air movement
	■ Dust drying	after 30 min. (degree of drying 1/ DIN EN ISO 9117-5)

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	<ul style="list-style-type: none"> <li>■ Dry to the touch after 6 hrs. (degree of drying 4/ DIN EN ISO 9117-5)</li> <li>■ Full drying after 10 days (pendulum damping/DIN EN ISO 1522)</li> <li>■ Oven drying possible to 70°C</li> </ul>
<b>Resistance to storage</b>	<ul style="list-style-type: none"> <li>■ 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.</li> </ul> <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>
<b>Specific comments</b>	<ul style="list-style-type: none"> <li>■ <b>Approval</b> available - on request</li> <li>■ <b>EFD-info</b> Refer to the EFD information for further technical information. Nr. 111 + 510</li> <li>■ <b>Test conditions</b> 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.</li> </ul> <p>The information provided here contains reference values and does not constitute a specification.</p>