FreiLacke

Technical Data Sheet

FREOPOX

Zinc primer
ER1947L

- Solvent-based 2K-Primer, zinc contains
- For industrial lacquer finishes, e.g. building of metals
- Very good corrosion protection
- Air- and heatforced drying process

Technical / Physical Data	**Resin/ binder**	epoxyde resins
	Colour	following RAL 840 HR, other colour shades on request
	Gloss value visual	mat
	Original viscosity without hardener	8 to 10 Pa.s / Spindel 1
	Mixing ratio (by weight)	10 : 1
	Hardener	FREOPOX-Hardener HE0055
	base	polyamidoamin resin
	Potlife after hardener addition	max. 12 h / 20°C
	Thinner	EFD-Thinner 400424
	Density after hardener addition calculated	2,1 / ml + / - 0,1
	Solid content after hardener addition calculated	82 % + / - 1
	Solid content in volume after hardener addition calculated	275 ml / kg + / - 10
	Consumption calculated after hardener addition in original viscosity, without application loss	210 to 225 g / m² dry film thickness 60 µm see „Special remarks“
	Spreading rate calculated after hardener addition in original viscosity, without application loss	4,4 to 4,7 m² / kg dry film thickness 60 µm see „Special remarks“
Storage stability	Approx. 9 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 usage is essential due to quality guaranty reasons.	

DIN EN ISO 9001
ISO/TS 16949
EMAS

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Processing and application

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

spraying-airless:	in original viscosity after hardener addition (corresponds to a processing viscosity from 110 to 130 sec. / 4 mm cup DIN 53211*) nozzle: 0,33 to 0,38 mm spraying pressure: 100 to 150 bar
spraying-high pressure:	after hardener addition and adjustment to 60 to 80 sec. / 4 mm cup DIN 53211* nozzle: 1,4 to 1,7 mm spraying pressure: 3 to 4 bar
by roller:	in original viscosity after hardener addition
by brush:	in original viscosity after hardener addition

Substrates
steel blasted

depending upon requirement corresponding pretreatment

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) pretreatment.

Proposal for a coating system

subtrate:	blasted steel	
primer:	FREOPOX-Zinc primer	ER1947L
top coat:	EFDEDUR-paint	UR1044

Application temperature
above 10 °C

Drying air drying at 20°C

dust dry:	after 20 min.	(degree of drying 1	/ DIN 53150)
dry to touch:	after 8 h	(degree of drying 4	/ DIN 53150)
complete dry:	after 7 days	(swinging beam hardness	/ ISO 1522)
oven drying:	to 70°C possible	(object temperature)	

Recoatability
with all usual lacquer systems possible

Cleaning of working equipment
EFD-Thinner 400424

Advise for safety protection and protection of health
The usual precautionery measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailled information about dangerous goods, sayfety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Information about Hardener and Thinner:
The hardener and the thinner mentioned on page 1 are stated as standard componentes for this paint system. The standard hardener is also written in the order documents as well as on the label. Furthermore there are additional hardeners and thinners, which can be used as alternative in case the standard components doesn´t meet the requirements.
These products are tailor-made e.g. faster or slower hardening.

Test condition

*Indication of the delivery viscosity according to DIN 53211:
DIN 53211 was withdrawn in October 1996.
On request the value is available according to DIN EN ISO 2431.

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on ER1947LRU731, blue grey, hardening with HE0055. 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.