FreiLacke

Technical Data Sheet

FREOPOX

Zinc Dust Paint
ER1920M

- 2-component aktivprimer with solvent
- Very good corrosion protection
- Good application characteristics
- Well suited in Steel construction industry
- Wet on wet application
- Zinc dust portion in the dry film approx. 90 %

Technical / Physical data	**Resin/ binder**		epoxyde resins
	Colour		grey
	Original viscosity DIN 53211* without hardener		50 to 80 sec. / 4 mm cup
	Mixing ratio (by weight)	**HE0052 =** **HE0915 =**	20 : 1 30 : 1
	Mixing ratio (by volume)	**HE0052 =** **HE0915 =**	10 : 1,40 10 : 0,94
	Hardener base		FREOPOX-Hardener HE0052 FREOPOX-Hardener HE0052 polyamidoamin resin
	Potlife after hardener addition		max. 12 h / 20°C see „Special remarks“
	Thinner		EFD-Thinner 400424
	Density after hardener addition calculated		2,75 g / ml + / - 0,1
	Solid content after hardener addition calculated		85 % + / - 2
	Solid content in volume after hardener addition calculated		195 ml / kg + / - 8 or 54 vol.% + / - 1,5
	Consumption calculated after hardener addition in original viscosity, without application loss		155 g / m² 55 ml / m² dry film thickness 30 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.

Our technical data sheets are to advise you according to our latest state of knowledge. This information does not release you from own tests of our products in view to the ability for the intended procedures and applications. The sale of our products is an accordance with our terms of business and delivery.

DIN EN ISO 9001
VDA 6.1
EMAS II

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FREOPOX

Zinc Dust Paint
ER1920MRU700

Processing and application

Application
Components are to be mixed homogeneously (e.g. with high-speed mixer).
For reaching the quality is to keep because of unequal conditions, the careful mixture of the two components compellingly.

with HE0052

spraying-airless:	in original viscosity after hardener addition
spraying-pneumatic:	in original viscosity after hardener addition To the process improvement after hardener addition 5-10 Gew.% thinner 400424 addition.
by roller/ brush:	in original viscosity after hardener addition

with HE0915

spraying-airless:	in original viscosity after hardener addition
spraying-pneumatic:	in original viscosity after hardener addition To the process improvement after hardener addition 10-20 Gew.% thinner 400424 addition.

Substrates
steel

Pretreatment
The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust, surfactant. and jet residual. purity accordance DIN EN ISO 8501-1 standard degree of cleanliness SA 2½ beam density radiance accordance Rugotest Nr.: 3, B, N10b, N9b mean depth of surface irregularities: 20 to 40 µm

Proposal for a coating system

1. primer:	FREOPOX-Zinc dust paint	ER1920M
2. primer:	FREOPOX-primer	ER1912
top coat, e.G.:	FREIOPLAST-Top coat	KP1610 or
	EFDEDUR-Paint	UR1044

Application temperature
above 10 °C

Drying air drying at 20°C

dust dry:	after 10 min. (degree of drying 1 / DIN EN ISO 9117-5)
dry to touch:	after 2-3 h (degree of drying 4 / DIN EN ISO 9117-5)
complete dry:	after 10 days (swinging beam hardness / DIN EN ISO 1522)
oven drying:	to 80°C possible (object temperature) In the case of forced drying process the hardening is accelerated.

Recoatability
after 10 min. / 20 °C
At a intermediate drying of more than 72 h. / 20 °C must be checket the Recoatability.

Cleaning of working equipment
EFD-Thinner 400424 within the working time, completely dried enamel residue can be removed only mechanically.

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

Resistance
With appropriate structure of coating very good corrosion protection values can be attained.
The dry film thickness of FREOPOX-Zincs dust paint ER1920M
> 80 µm is to be avoided.

FREOPOX-Hardener HE0052/ HE0915
It can be used HE0052 as well as HE0915 - depending upon availability locally;
see also under application.

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 and drying depend on colour shade.
The values mentioned in this data sheet are based on ER1920MRU700,grey and hardening with HE0052.

with HE0052. 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.