



WE1935M_HE0041 FREOPOX-Hydro-Primer

Product description

Product technology	water-thinnable 2C coating
Application area	e.g. in the vehicle construction sector
Drying	quickly
Grindability	good
Over-coating capability	quickly
Corrosion protection	very good
Substrate	Non-ferrous metals, Steel

General product properties

Binder-Base	Epoxy resin	
Colour	All common colour shades	
Gloss visually	matt	
Viscosity	1800-2200 mPa*s, spindle 5, 60 revolutions/min.	DIN EN ISO 2555
pH-Value	8,0-9,0	DIN 19260
Density	1,25-1,35 g/ml after addition of hardener	theoretical
Solid mass	60-67 % after addition of hardener	theoretical
Solid content in volume	49-56 % after addition of hardener	theoretical
Reference product	The values given refer to the product with the shade WE1935MRU742.	
Resistance to storage	<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>	



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Application and processing

Pretreatment	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.	
Structure recommendation	Substrate	On blasted steel plate
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.	
Hardener	HE0041	
Mixin ratio	Parts by weight 8:1 Volume parts 6,3:1	
Thinning	demineralised water	
Dry film thickness	must not exceed 250 µm – risk of reaction bubbles.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	
Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %	
Processing time	max. 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.	
Airmix spraying	130-150 sec. / 6 mm viscosity cup Nozzle 0,33 mm angle 30° Material pressure 120 bar Atomiser pressure 4 bar	DIN 53211
High pressure spraying	50-70 sec. / 4 mm Flow cup Nozzle 1,7 mm Injection pressure 3 bar	DIN 53211
Rolling/painting	as delivered viscosity	
Material usage	without application loss 180-210 g/m ² layer thickness 80 µm after addition of hardener	theoretical
Air drying	18-25 °C, 40-60 % relative humidity	
Oven drying	up to 70 °C possible	
Dust drying	after 15 minutes (degree of dryness 1)	DIN EN ISO 9117-5

Our technical data sheets are to provide you with advice based on our latest state of knowledge. This guidance does not release you from your own obligation to test our products for their suitability for your intended purposes and applications. The sale of our products is in accordance with our terms of business, delivery and payment.

DIN EN ISO 9001 | IATF 16949 | EMAS

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Dry to the touch	after 2 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 8 day/s (pendulum damping)	DIN EN ISO 1522
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.	

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.
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Comments

EFD info	Further technical information can be found in the EFD Info. No. 111 + 510.
Work-and Healthprotection	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.
Test conditions	<p>All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge an experience. We have no direct influence on the application itself. Please do not hesitate to contact us for further information.</p> <p>The information provided here contains reference values and does not constitute a specification.</p>