

# FREOPOX

Primer

ER1926M – Grob Werke

- Solvent based primer
- Suitable as singlelayer for indoor usage
- Very good corrosion protection
- Excellente adhesion
- For industrial goods and all kinds of construction machinery

<b>Technical / Physical Data</b>	<b>Resin/ binder</b>	epoxy resins
	<b>Colour</b>	acc. RAL 840 HR other colour shades on request
	<b>Gloss value</b> visual	satin mat
	<b>Original viscosity</b> DIN 53211* without hardener	38 to 44 sec. / cup 4 mm
	<b>Mixing ratio</b> by weight	5 : 1
	<b>Mixing ratio</b> by volume	3,5 : 1
	<b>Hardener</b> base	FREOPOX-Hardener HE0051 Phenalcamide
	<b>Potlife</b> after hardener addition	max. 3 h / 20°C
	<b>Thinner</b>	EFD-Thinner 400009
	<b>Density</b> after hardener addition, calculated	1,34 g / ml + / - 0,05
	<b>Solid content</b> after hardener addition, calculated	62 % + / - 1
	<b>Solid content in volume</b> after hardener addition, calculated	316 ml / kg + / - 5 or 41 % + / - 2
	<b>Consumption</b> calculated, after hardener addition in original viscosity, without application loss	158 g / m <sup>2</sup> dry film thickness 50 µm see „Special remarks“
	<b>Spreading rate</b> calculated, after hardener addition in original viscosity, without application loss	6,3 m <sup>2</sup> / kg dry film thickness 50 µm see „Special remarks“

### Storability

Approx. 24 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

## Processing and application

### Application

Before adding the hardener ER1926M has to be stirred up carefully by high-speed-mixer.

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

spraying-airless:	in original viscosity after hardener addition nozzle: 0,23 mm or 0,009 inch    angle 20°
spraying-high-pressure:	in original viscosity after hardener addition nozzle: 1,5 to 2,0 mm    spray pressure 4 to 5 bar

### Substrates

steel, stainless steel, aluminium, galvanized steel (hot-dip galvanizes)

### 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, purity at least SA 2 ½ “DIN EN ISO 12944-4”) pretreatment.

### Proposal for a coating system

substrate:	steel, blasted	
primer:	FREOPOX-Primer	ER1926M
top coat:	EFDEDUR-HighSolid-Coating	UR1984

### Application temperature

optimum 18°C to 24°C

### Drying

	air drying at 20°C	
dust dry:	after 20 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after 3 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after 7 days	(swinging beam hardness/ ISO 1522)

### Overpaintableness

With itself after previous cleaning at every time  
With 2K-PU-top coat after 20 to 40 min. or after drying by night

### Cleaning of working equipment

With EFD-Thinner 400424 within the working time, completely dried paint can only mechanically be removed.

### Advise for safety protection and protection of health

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

## Special remarks

### Alternative hardener

FREOPOX-Hardener H0103/ Mixing ratio 6:1 by weight  
Higher gloss level and elasticity, with a pot life of 4 hours/20°C

### Test condition

\*Original viscosity according to DIN 53211:  
DIN 53211 was withdrawn in Octobre 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 ER1926MG1995, jet black, satin mat and hardened with HE0103.

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.