Technical Data Sheet

FreiLacke

DW1204H_DE0191
FREOPOX-Hydro-Singlelayer

Product description

Product technology	water-thinnable 2C coating
Application area	e.g. Rail vehicles and components
Mechanical resistance	good flexibility
Substrate	Steel

General product properties

Binder-Base	Polyamine	
Colour	All common colour shades	
Gloss visually	Satin gloss	
Viscosity	600-1300 mPa*s, spindle 4, 60 revolutions/min.	DIN EN ISO 2555
Solid mass	53-57 % after addition of hardener	theoretical
Solid content in volume	40-44 % after addition of hardener	theoretical
Resistance to storage	approx. 6 month in original packagings at an ambient temperature of 18 to 25 °C. Protect from frost. Open packages are to be used within a short time. 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.	

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	Steel blasted to Sa 2.5
	Top coat	DW1204H Mixing ratio 1:1 DE0191 Dry film thickness 200-220 µm
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	DE0191	
Mixin ratio	Parts by weight 1:1	
Thinning	demineralised water	
Dry film thickness	must not exceed 300 µm - risk of surface defects.	
Object temperature	10-30 °C, minimum +3 °C above dew point temperature	

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Processing conditions	Room temperature 18-28 °C Relative humidity 30-80 %
Processing time	max. 3 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.
Airmix spraying	as delivered viscosity Nozzle 13 mm angle 40° Material pressure 160 bar Atomiser pressure 2 bar
High pressure spraying	as delivered viscosity nozzle 1,8mm mm spray pressure 3 bar
Oven drying	up to 70 °C possible
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. Do not mix curing agent with water! The cleaning must be carried out with organic solvents.

Further processing of coated pieces

Repainting	possible after grinding

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	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. The information provided here contains reference values and does not constitute a specification.

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