



WE1935M_HE0057 FREOPOX-Hydro-Primer

Product description

Product technology	water-thinnable 2C coating
Application area	Application, 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 value	mat 40-50 GU, angle 85° DIN EN ISO 2813
Viscosity	2000-2400 mPa*s, spindle 5, 60 revolutions/min. DIN EN ISO 2555
pH-Value	8,0-9,0 DIN 19260
Density	1,35-1,42 g/ml theoretical 1,30-1,36 g/ml after addition of hardener theoretical
Solid mass	64-66 % theoretical 62-64 % after addition of hardener theoretical
Solid content in volume	320-340 ml/kg theoretical 375-385 ml/kg after addition of hardener theoretical
Reference product	The values given refer to the product with the shade WE1935MRU124.
Resistance to storage	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. 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.



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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	HE0057 see technical data sheet	
Mixin ratio	Parts by weight 7:1 Volume parts 5,4:1	
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. 3 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	120-130 sec. / 6 mm viscosity cup Nozzle 0,33 mm angle 30° Material pressure 120 bar Atomiser pressure 4 bar	DIN 53211
High pressure spraying	90-120 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 155-165 g/m ² layer thickness 60 µm after addition of hardener	theoretical
Air drying	at 18-25°C, 40-60% relative humidity with air movement	
Oven drying	up to 70 °C possible	
Dust drying	after 20 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 | DIN ISO 45001

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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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Mechanical tests

Cross-cut-test	Gt 0	DIN EN ISO 2409
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Climatic tests

Temperature resistance	Short exposure 120 °C		
Condensate constant climate	Load duration	240 h	DIN EN ISO 6270-2 (CH)
	Bubble degree Surface	0(S0)	DIN EN ISO 4628-2
Neutral salt spray test	Load duration	540 h	DIN EN ISO 9227 (NSS)
	Detachment Cut	1 mm	DIN EN ISO 4628-8

Chemical resistance

Influencing factors	The chemical resistance depends on the concentration, temperature, exposure time and test method. This has to be checked depending on the application.
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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.
System Coating	Can be integrated into the system coating concept as a horizontal system coating (different coatings with the same look) or vertical system coating (part of a multi-layer structure). For more information, see www.freilacke.de/systemlacke .
Test conditions	All information is based on a standard climate 23/50 DIN EN 23270. All information is based on our product knowledge and 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.