



## ER1904H\_HE0020\_METALLIC FREOPOX-Metal Effectcoat

### Product description

<b>Product technology</b>	solvent-based 2-component coating	
<b>Abrasion resistance</b>	good	
<b>Chemical resistance</b>	very good	
<b>Substrate</b>	Steel, Aluminium	

### General product properties

<b>Binder-Base</b>	Epoxy resin	
<b>Colour</b>	Metallic colour shades	
<b>Gloss visually</b>	satin mat	
<b>Viscosity</b>	Flow time 30-60 sec., 4 mm flow cup	DIN 53211
<b>Density</b>	1,1-1,2 g/ml after addition of hardener	theoretical
<b>Solid mass</b>	54-55 % after addition of hardener	theoretical
<b>Solid content in volume</b>	40-41 % after addition of hardener	theoretical
<b>Reference product</b>	The specified values refer to the product ER1904HH3228.	
<b>Resistance to storage</b>	<p>approx. 9 month in original packagings at an ambient temperature of 5 to 25 °C. 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>	

### Application and processing

<b>Pretreatment</b>	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.	
<b>Structure recommendation</b>	Substrate	Steel
	Primer	ER1912M Mixing ratio 5:1 HE0052 Dry film thickness 70-90 µm
	Top coat	ER1904H Mixing ratio 4:1 HE0020 Dry film thickness 40-60 µm
<b>Note before use</b>	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
<b>Hardener</b>	HE0020	



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<b>Mixin ratio</b>	Parts by weight 4:1	
<b>Thinning</b>	EFD dilution 400424	
<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>Processing time</b>	max. 12 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
<b>High pressure spraying</b>	Set to 25-35 sec / 4 mm flow-cup after adding hardener Nozzle 1,4 mm Spray pressure 3-4 bar	DIN 53211
<b>Material usage</b>	without application loss 80-90 g/m <sup>2</sup> layer thickness 30 µm after addition of hardener	theoretical
<b>Oven drying</b>	up to 70 °C possible (object temperature)	
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Dust drying</b>	after 90 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 24 hours (degree of dryness 4)	DIN EN ISO 9117-5
<b>Full drying</b>	after 7 day/s (pendulum damping)	DIN EN ISO 1522
<b>Cleaning of equipment</b>	with EFD dilution 400424 within the processing time.	

### Comments

<b>EFD info</b>	Further technical information can be found in the EFD Info. No. 170.
<b>Work-and Healthprotection</b>	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.
<b>Test conditions</b>	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.