



## ER1950M\_HE0915 FREOPOX-Primer

### Product description

<b>Product technology</b>	solvent-based 2-component coating	
<b>Application</b>	suitable as adhesion promoter	
<b>Corrosion protection</b>	good	
<b>Substrate</b>	Non-ferrous metals, Steel, Aluminium	

### General product properties

<b>Binder-Base</b>	Epoxy resin	
<b>Colour</b>	in accordance with RAL 840 HR other colours on request	
<b>Gloss visually</b>	matt	
<b>Viscosity</b>	Flow time 40-50 sec., 4 mm flow cup	DIN 53211
<b>Density</b>	1,25-1,35 g/ml after addition of hardener	theoretical
<b>Solid mass</b>	62-63 % after addition of hardener	theoretical
<b>Solid content in volume</b>	44-45 % after addition of hardener	theoretical
<b>Reference product</b>	The specified values refer to the product ER1950MRU309.	
<b>Resistance to storage</b>	<p>approx. 24 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	ER1950M Mixing ratio 7:1 HE0915 Dry film thickness 50-60 µm
	Top coat	UR1044G Mixing ratio 5:1 HU0400 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>	HE0915	

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.

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<b>Mixin ratio</b>	Parts by weight 7:1	
<b>Thinning</b>	EFD dilution 400424	
<b>Processing conditions</b>	from 10 °C to 25 °C	
<b>Processing time</b>	max. 8 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
<b>High pressure spraying</b>	as delivered viscosity after adding curing agent nozzle 1,4 mm spray pressure 4 bar	
<b>Material usage</b>	without application loss 140-150 g/m <sup>2</sup> layer thickness 50 µm after addition of hardener	theoretical
<b>Oven drying</b>	up to 100 °C possible (object temperature)	
<b>Air drying</b>	20 °C, 50 % relative humidity	
<b>Dust drying</b>	after 65 minutes (degree of dryness 1)	DIN EN ISO 9117-5
<b>Dry to the touch</b>	after 20 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.	

### Further processing of coated pieces

<b>Repainting</b>	after 60 min. / 20 °C with an intermediate drying time of $\geq$ 3 days / 20 °C, recoatability must be tested.
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### 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.