FreiLacke

Technical Data Sheet

FREOPOX

Primer
ER1949MRU735

- Primer with solvent
- Rapidly drying
- Very good adhesion
- For iron and non-ferrous metals suitably

Technical / Physical Data	**Resin/ binder**	epoxy resins
	Colour	light-grey approx. RAL 7035 following RAL 840 HR other colour shades on request
	Gloss value visual	mat
	Original viscosity DIN 53211*, without hardener	80 to 100 Sek. / 4 mm cup
	Mixing ratio by weight	10 : 1
	Hardener base	FREOPOX-Hardener HE0915 Polyamin
	Potlife after hardener addition	max. 18 h / 20°C
	Thinner	EFD-Thinner 400424
	Density after hardener addition calculated	1,3 g / ml + / - 0,2
	Solid content after hardener addition calculated	64 % + / - 2
	Solid content in volume after hardener addition calculated	350 ml / kg + / - 10 or 44,5 Vol.% + / - 10
	Consumption calculated after hardener addition in original viscosity, without application loss	142 g / m² dry film thickness 50 µm see „Special remarks“
	Spreading rate calculated after hardener addition in original viscosity, without application loss	7,0 m² / kg dry film thickness 50 µm see „Special remarks“

DIN EN ISO 9001
VDA 6.1
EMAS II

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Storability

Approx. 18 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

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

spraying-airless:	in original viscosity after hardener addition
spraying-high-pressure:	nach Härterzugabe und Einstellung auf 25 bis 35 Sek.
	Düse: 1,4 bis 1,8 mm Spritzdruck: ca. 4 bar
by roller/ brush:	in original viscosity after hardener addition

Substrates

aluminium, steel

Pretreatment

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant; if necessary blast cleaning, purity at least SA 2 (DIN EN ISO 12944-4)

Proposal for a coating system

subtrate:	steel	
primer:	FREOPOX-Primer	ER1949MRU735
base laquer:	EFDEDUR-Paint	UR1044

Application temperature

above 10 °C

Drying air drying at 20°C

dust dry:	after 15 min.	(degree of drying 1/ DIN 53150)
dry to touch:	after 9 h	(degree of drying 4/ DIN 53150)
complete dry:	after 10 days	(swinging beam hardness/ ISO 1522)
oven drying:	to 80°C possible	(object temperature)

Overpaintableness

With itself after sanding, at any time possible.

Cleaning of working equipment

With EFD-Thinner 400424

Advise for safety protection and protection of health

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

Special remarks

Test condition

*Indication of the delivery viscosity according to DIN 53211:
DIN 53211 was withdrawn in October 1996.
On request the value is available according to DIN EN ISO 2431.

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.