

# FREOPOX

## Micairon Coating ER1915M

- solvent-based mica paint
- Use as 2K-Primer color or 2K-top coat in the internal area
- for industrial lacquer finishes, e.g. building of metals
- good corrosion protection

<b>Technical Physical data</b>	<b>Resin/ binder</b>	epoxyde resins	
	<b>Colour</b>	silver grey DB701, acc. to the colour shade: „Deutsche Bundesbahn“, pastel blue approx. RAL 5024 after RAL 840 HR other colour shades on request	
	<b>Gloss value</b> DIN 67530	mat	
	<b>Original viscosity</b> without hardener	6000 to 8000 mPa.s / Spindel 6	
	<b>Mixing ratio</b> (by weight)	10 : 1	
	<b>Hardener</b> base	FREOPOX-Hardener HE0055 polyamidoamin resin	
	<b>Potlife</b> after hardener addition	max. 8 h / 20°C	
	<b>Thinner</b>	EFD-Thinner	400424
	<b>Density</b> after hardener addition calculated	1,60 / ml	+ / - 0,1
	<b>Solid content</b> after hardener addition calculated	73 %	+ / - 2
	<b>Solid content in volume</b> after hardener addition calculated	325 ml / kg	+ / - 10
	<b>Consumption</b> calculated, after hardener addition in original viscosity, without application loss	180 to 190 g / m <sup>2</sup> dry film thickness 60 µm see „Special remarks“	
	<b>Spreading rate</b> calculated, after hardener addition in original viscosity, without application loss	5,2 to 5,5 m <sup>2</sup> / kg dry film thickness 60 µm see „Special remarks“	

**Storage stability**      Approx. 9 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 usage is essential due to quality guaranty reasons.

## Processing and application

### Application

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

spraying-airless: after hardener addition and adjustment 40 to 50 sec. / 6 mm cup  
nozzle: 0,38 to 0,41 mm spraying pressure: 100 to 150 bar

spraying-high pressure: after hardener addition and adjustment  
to 60 to 80 sec. / 4 mm cup DIN 53211  
nozzle: 1,7 to 2,0 mm spraying pressure: 3 to 4 bar

by roller: in original viscosity after hardener addition  
by brush: in original viscosity after hardener addition

### Substrates

galvanized steel, aluminium

depending upon requirement corresponding pretreatment

**Pretreatment** The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust and surfactant. According to the requirements we recommend to apply the suited chemical (e.g. phosphatizing, chromating) or / and mechanical (e.g. shot blasting) pretreatment.

### Proposal for a coating system

substrate:	galvanized steel	
primer:	FREOPOX-mica paint	ER1915M
top coat:	EFDEDUR-mica paint	UR1942

substrate:	not blasted steel	
GripPrimer:	FREOPOX-primer	ER1925
primer:	FREOPOX-mica paint	ER1915M
top coat:	EFDEDUR-mica paint	UR1942

### Application temperature

above 10 °C

**Drying** air drying at 20°C

dust dry:	after 50 min. (degree of drying 1	/ DIN EN ISO 9117-5)
dry to touch:	after 4 h (degree of drying 4	/ DIN EN ISO 9117-5)
complete dry:	after 30 days (swinging beam hardness	/ DIN EN ISO 1522)

oven drying: to 60°C possible (object temperature)

### Cleaning of working equipment

EFD-Thinner 400424

### Advise for safety protection and protection of health

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

## Special remarks

### Use in the internal area as finish coating:

in the internal area FREOPOX Eisenglimmerfarbe ER1915M can be used as economical finish coating

### Use in the external area as finish coating:

In the external area FREOPOX-Mica-iron paint ER1915M is inclined under weathering influence to chalking. For this application we recommend EFDEDUR Mica paint UR1942.

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**Information about Hardener and Thinner:**

The hardener and the thinner mentioned on page 1 are stated as standard components for this paint system. The standard hardener is also written in the order documents as well as on the label. Furthermore there are additional hardeners and thinners, which can be used as alternative in case the standard components doesn't meet the requirements. These products are tailor-made e.g. faster or slower hardening.

Hardener are taking influence on the gloss

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**Test condition**

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on ER1915MDB701, silvergry in mat adjustment and hardening with HE0055

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.