



ER1904G_HE0915_CLEARCOAT FREOPOX-Clearcoat

Product description

Product technology	solvent-based 2-component coating	
Abrasion resistance	good	
Chemical resistance	good	
Substrate	Steel, Aluminium	

General product properties

Binder-Base	Epoxy resin	
Colour	colourless	
Gloss visually	glossy	
Viscosity	Flow time 12-17 sec., 4 mm flow cup	DIN 53211
Density	0,95-1,00 g/ml after addition of hardener	theoretical
Solid mass	37,5-38,5 % after addition of hardener	theoretical
Solid content in volume	32,0-33,0 % after addition of hardener	theoretical
Reference product	The specified values refer to the product ER1904GRA999.	
Resistance to storage	<p>approx. 18 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

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	Aluminium
	Clearcoat	ER1904GRA999 Dry film thickness 5:1 HE0915 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Hardener	HE0915	
Mixin ratio	Parts by weight 5:1	
Thinning	EFD dilution 400424	
Processing conditions	from 10 °C to 25 °C	



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Processing time	max. 12 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
High pressure spraying	as delivered viscosity after adding curing agent nozzle 1,4 mm spray pressure 3-4 bar	
Rolling/painting	as delivered viscosity after curing agent addition	
Material usage	without application loss 85-90 g/m ² layer thickness 30 µm after addition of hardener	theoretical
Air drying	20 °C, 50 % relative humidity	
Oven drying	up to 70 °C possible (object temperature)	
Dust drying	after 90 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 24 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 7 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	with EFD dilution 400424 within the processing time.	

Further processing of coated pieces

Repainting	possible after grinding. Clean the grinded surface removing adhesion-impairing materials afterwards.
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Comments

Alternative hardener	for better chemical resistance HE0020 for higher hardness HE0020
EFD info	Further technical information can be found in the EFD Info. No. 170.
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.
Test conditions	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.