WE1935K_HE0041
FREOPOX-Hydro-Primer

Product description

Product technology	water-thinnable 2C coating
Application area	e.g. in the vehicle construction sector
Drying	quickly
Grindability	good
Over-coating capability	quickly
Corrosion protection	very good
Substrate	Non-ferrous metals, Steel

General product properties

Binder-Base	Epoxy resin	
Colour	All common colour shades	
Gloss visually	matt	
Viscosity	1600-2200 mPa*s, spindle 5, 60 revolutions/min.	DIN EN ISO 2555
pH-Value	8,0-9,0	DIN 19260
Density	1,25-1,35 g/ml after addition of hardener	theoretical
Solid mass	62-64 % after addition of hardener	theoretical
Solid content in volume	51-52 % after addition of hardener	theoretical
Reference product	The values given refer to the product with the shade WE1935KRU124.	
Resistance to storage	approx. 12 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. Open packages are to be used within a short time. 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.	

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de

WE1935K_HE0041
FREOPOX-Hydro-Primer

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	On blasted steel plate	
	Primer	WE1935KRU124 Mixing ratio 8:1/ HE0041 Dry film thickness 80 µm	
	Top coat	WU1488G Mixing ratio 3,3:1/ HU0448 Dry film thickness 70 µm	
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water.		
Hardener	HE0041		
Mixin ratio	Parts by weight 8:1 Volume parts 6,3:1		
Thinning	demineralised water		
Dry film thickness	must not exceed 250 µm – risk of reaction bubbles.		
Object temperature	10-30 °C, minimum +3 °C above dew point temperature		
Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %		
Processing time	max. 5 hrs. / 20 °C End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.		
Airmix spraying	130-150 sec. / 6 mm viscosity cup Nozzle 0,33 mm angle 30° Material pressure 120 bar Atomiser pressure 4 bar		DIN 53211
High pressure spraying	50-70 sec. / 4 mm Flow cup Nozzle 1,7 mm Injection pressure 3 bar		DIN 53211
Rolling/painting	as delivered viscosity		
Material usage	without application loss 190-210 g/m² layer thickness 80 µm after addition of hardener		theoretical
Air drying	18-25 °C, 40-60 % relative humidity		
Oven drying	up to 70 °C possible		
Dust drying	after 15 minutes (degree of dryness 1)		DIN EN ISO 9117-5

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de

WE1935K_HE0041
FREOPOX-Hydro-Primer

Dry to the touch	after 2 hours (degree of dryness 4)	DIN EN ISO 9117-5
Full drying	after 8 day/s (pendulum damping)	DIN EN ISO 1522
Cleaning of equipment	immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916, dried-on equipment with org. solvents, e.g. EFD thinner 400424.	

Further processing of coated pieces

Repainting	possible with same quality, dry at the earliest after matting.

Comments

EFD info	Further technical information can be found in the EFD Info. No. 111 + 510.
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.

FreiLacke | Emil Frei GmbH & Co. KG

Am Bahnhof 6
78199 Bräunlingen-Döggingen | Deutschland
+49 77071510
www.freilacke.de | info@freilacke.de