



## ER1926M\_HE0051 FREOPOX-Primer

### Product description

|                             |                                                     |
|-----------------------------|-----------------------------------------------------|
| <b>Product technology</b>   | solvent-based 2-component coating                   |
| <b>Application area</b>     | e.g. in the vehicle construction sector             |
| <b>Corrosion protection</b> | very good                                           |
| <b>Substrate</b>            | Steel, Stainless steel, Aluminium, Galvanised steel |

### General product properties

|                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |             |
|--------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|
| <b>Binder-Base</b>             | Epoxy resin                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |             |
| <b>Colour</b>                  | in accordance with RAL 840 HR<br>other colours on request                                                                                                                                                                                                                                                                                                                                                                                                                         |             |
| <b>Gloss visually</b>          | matt                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |             |
| <b>Viscosity</b>               | Flow time 38-44 sec., 4 mm flow cup                                                                                                                                                                                                                                                                                                                                                                                                                                               | DIN 53211   |
| <b>Density</b>                 | 1,3-1,4 g/ml after addition of hardener                                                                                                                                                                                                                                                                                                                                                                                                                                           | theoretical |
| <b>Solid mass</b>              | 60-62 % after addition of hardener                                                                                                                                                                                                                                                                                                                                                                                                                                                | theoretical |
| <b>Solid content in volume</b> | 40-44 % after addition of hardener                                                                                                                                                                                                                                                                                                                                                                                                                                                | theoretical |
| <b>Reference product</b>       | The specified values refer to the product ER1926MG1874.                                                                                                                                                                                                                                                                                                                                                                                                                           |             |
| <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                                                                                                                                                                                                                                                                                                                     | On blasted steel plate                                            |
|                                 | Primer                                                                                                                                                                                                                                                                                                                        | ER1926M<br>Mixing ratio 5:1 HE0051<br>Dry film thickness 50-70 µm |
|                                 | Top coat                                                                                                                                                                                                                                                                                                                      | UR1984H<br>Mixing ratio 8:1 HU0936<br>Dry film thickness 40-60 µm |



## ER1926M\_HE0051 FREOPOX-Primer

|                               |                                                                                                       |                   |
|-------------------------------|-------------------------------------------------------------------------------------------------------|-------------------|
| <b>Note before use</b>        | Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).                       |                   |
| <b>Hardener</b>               | HE0051                                                                                                |                   |
| <b>Mixin ratio</b>            | Parts by weight 5:1                                                                                   |                   |
| <b>Thinning</b>               | EFD dilution 400009                                                                                   |                   |
| <b>Processing conditions</b>  | from 10 °C to 25 °C                                                                                   |                   |
| <b>Processing time</b>        | max. 3 hrs. / 20 °C<br>The processing time can decrease at higher temperatures and/or under pressure. |                   |
| <b>Airless spraying</b>       | as delivered viscosity after curing agent addition<br>Nozzle 0,23 mm Angle 20°                        |                   |
| <b>High pressure spraying</b> | as delivered viscosity after adding curing agent<br>nozzle 1,5-2,0 mm<br>spray pressure 2-4 bar       |                   |
| <b>Material usage</b>         | without application loss 190-195 g/m <sup>2</sup><br>layer thickness 60 µm after addition of hardener | theoretical       |
| <b>Air drying</b>             | 20 °C, 50 % relative humidity                                                                         |                   |
| <b>Dust drying</b>            | after 15 minutes (degree of dryness 1)                                                                | DIN EN ISO 9117-5 |
| <b>Dry to the touch</b>       | after 2 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> | possible with UR1984 after drying at room temperature of 20-40 min. |
|-------------------|---------------------------------------------------------------------|

### 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.<br><br>The information provided here contains reference values and does not constitute a specification. |