FreiLacke

Technical Data Sheet

FREOPOX

UHS-Structure-Coat
ER1945M

- Ultra-High-Solid-Structure-Coat with solvent
- For structure effects in a processing step
- Good resistances
- Fast drying

Technical / Physical data	**Resin/ binder**	epoxyd resin
	Colour	according to powder master panel
	Gloss value	after powder sample
	Original viscosity without hardener	7000 to 9000 mPa.s / Sp. 5
	Standard-Mixing ratio by weight	8 : 1
	Standard-Hardener base	FREOPOX-Hardener HE0016
	Potlife after hardener addition	max. 3 h/ 20°C
	Thinner	EFD-Thinner 400424 max. 20%
	Density after hardener addition calculated	1,6 / ml + / - 0,1
	Solid content after hardener addition calculated	77 % + / - 2
	Solid content in volume after hardener addition calculated	345 ml / kg + / - 5
	Consumption calculated, after hardener addition in original viscosity, without application loss	150 - 200 g / m² dry film thickness 60 – 80 µm
	Spreading rate calculated, after hardener addition in original viscosity, without application loss	4,6 – 5,1 m² / kg dry film thickness 60 - 80 µm see „Special remarks“

DIN EN ISO 9001
ISO/TS 16949
EMAS

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Storability

Approx. 12 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).
For the application high pressure as well as low pressure spraying application is suited

After hardener addition the viscosity has to be adjusted acc. to the way of application.
With different adjustments of spraying pressure, nozzle diameter and paint viscosity various surface appearances can be achieved

Substrates

steel, aluminium

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

subtrate:	steel	
top coat:	FREOPOX-UHS-Strucutre-Coat	ER1945M

Application temperature

above 10 °C

Drying air drying at 20°C

dust dry:	after	45	min.	(degree of drying 1/ DIN 53150)
dry to touch:	after	6	h	(degree of drying 4/ DIN 53150)
complete dry:	after	7	days	(swinging beam hardness/ ISO 1522)
	after 30 days able to cope with light chemicals			
oven drying:	to 70°C possible (object temperature)			

Recoatability

with itself after previous grind at any time possible

Cleaning of working equipment

With EFD-Thinner 400424 within the working time, completely dried paint can only mechanically be removed.

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

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on ER1945MH3093, lightgrey, mat and hardening with HE0016.

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.