



ER1925M_HE0051 FREOPOX-Primer

Product description

Product technology	solvent-based 2-component coating
Application area	e.g. in the vehicle construction sector
Filling capacity	very good
Corrosion protection	good
Substrate	Steel, Steel, blasted

General product properties

Binder-Base	Epoxy resin	
Colour	in accordance with RAL 840 HR other colours on request	
Gloss visually	matt	
Viscosity	Flow time 60-70 sec., 4 mm flow cup	DIN 53211
Density	1,20-1,22 g/ml after addition of hardener	theoretical
Solid mass	59-61 % after addition of hardener	theoretical
Solid content in volume	43-47 % after addition of hardener	theoretical
Reference product	The specified values refer to the product ER1925MRU735.	
Resistance to storage	<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

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.
---------------------	---



ER1925M_HE0051 FREOPOX-Primer

Structure recommendation	Substrate	Steel
	Primer	ER1925M Mixing ratio 3:1 HE0051 Dry film thickness 70-90 µm
	Top coat	UR1449G Mixing ratio 7:1 HU0140 Dry film thickness 50-70 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Hardener	HE0051	
Mixin ratio	Parts by weight 3:1	
Thinning	EFD dilution 400009	
Processing conditions	from 10 °C to 25 °C	
Processing time	max. 3 hrs. / 20 °C The processing time can decrease at higher temperatures and/or under pressure.	
Airless spraying	as delivered viscosity after curing agent addition Nozzle 0,23 mm Angle 20°	
Airmix spraying	as delivered viscosity after curing agent addition Nozzle 0,23 mm angle 40°	
High pressure spraying	as delivered viscosity after adding curing agent nozzle 1,5-2,0 mm spray pressure 2-4 bar	
Material usage	without application loss 214 g/m ² layer thickness 80 µm after addition of hardener	theoretical
Air drying	20 °C, 50 % relative humidity	
Dust drying	after 30 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 4 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 with UR1449G after drying at room temperature of 20-40 min.
-------------------	--



ER1925M_HE0051 FREOPOX-Primer

Comments

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 and 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.