ER1947L_HE0055
FREOPOX-Zinc Dust Primer

Product description

Product technology	solvent-based 2-component coating
Application area	e.g. in the mechanical engineering and plant construction sector
Corrosion protection	very good
Substrate	Steel, blasted

General product properties

Binder-Base	Epoxy resin	
Colour	in accordance with RAL 840 HR other colours on request	
Gloss visually	matt	
Viscosity	8000-10000 mPa*s, spindle 1, 60 revolutions/min.	DIN EN ISO 2555
Density	2,0-2,2 g/ml after addition of hardener	theoretical
Solid mass	81-83 % after addition of hardener	theoretical
Solid content in volume	265-285 ml/kg after addition of hardener	theoretical
Reference product	The specified values refer to the product ER1947LRU731.	
Resistance to storage	approx. 9 month in original packagings at an ambient temperature of 5 to 25 °C. 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.	

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	ER1947L Mixing ratio 10:1 HE0055 Dry film thickness 40-60 µm
	Top coat	UR1040H Mixing ratio 5:1 HU0001 Dry film thickness 50-70 µm

FreiLacke | Emil Frei GmbH & Co. KG

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

ER1947L_HE0055
FREOPOX-Zinc Dust Primer

Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Hardener	HU0055	
Mixin ratio	Parts by weight 10:1	
Thinning	EFD dilution 400424	
Processing conditions	from 10 °C to 25 °C	
Processing time	max. 12 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 0,33-0,38 mm Angle 40° Material pressure 100-150 bar	
High pressure spraying	Set to 60-80 sec / 4 mm flow-cup after adding hardener Nozzle 1,4-1,7 mm Spray pressure 3-4 bar	DIN 53211
Rolling/painting	as delivered viscosity after curing agent addition	
Material usage	without application loss 210-225 g/m² layer thickness 60 µm	theoretical
Oven drying	up to 70 °C possible (object temperature)	
Air drying	20 °C, 50 % relative humidity	
Dust drying	after 20 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 8 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	after 1 hours / room temperature approx. 20 °C.

Comments

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