



ER1904M_HE0915 FREOPOX-Coating

Product description

Product technology	solvent-based 2-component coating	
Abrasion resistance	good	
Chemical resistance	good	
Substrate	Steel, Aluminium	

General product properties

Binder-Base	Epoxy resin	
Colour	in accordance with RAL 840 HR other colours on request	
Gloss visually	matt	
Viscosity	Flow time 80-100 sec., 4 mm flow cup	DIN 53211
Density	1,25-1,40 g/ml after addition of hardener	theoretical
Solid mass	62,5-67,5 % after addition of hardener	theoretical
Solid content in volume	47,0-49,0 % after addition of hardener	theoretical
Reference product	The specified values refer to the product ER1904MRA743.	
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	<p>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.</p>	
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Structure recommendation	Substrate	Steel
	Primer	ER1912M Mixing ratio 5:1 HE0052 Dry film thickness 70-90 µm
	Top coat	ER1904M Mixing ratio 10:1 HE0915 Dry film thickness 40-60 µm
Note before use	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer).	
Hardener	HE0915	
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 0,38 mm Angle 30° Material pressure 150 bar	
High pressure spraying	Set to 25-35 sec / 4 mm flow-cup after adding hardener Nozzle 1,4 mm Spray pressure 3-4 bar	DIN 53211
Rolling/painting	as delivered viscosity after curing agent addition	
Material usage	without application loss 135-145 g/m ² layer thickness 50 µm after addition of hardener	theoretical
Oven drying	up to 70 °C possible (object temperature)	
Air drying	20 °C, 50 % relative humidity	
Dust drying	after 90 minutes (degree of dryness 1)	DIN EN ISO 9117-5
Dry to the touch	after 24 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.	



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Further processing of coated pieces

Repainting

possible after grinding. Clean the grinded surface removing adhesion-impairing materials afterwards.

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.