FreiLacke

FREOPOX-Hydro-Grundierung
WE1986M/HE0132

Characteristics	Water-thinnable 2C coating	
	Application, e.g. in the vehicle construction sector	
	Good adhesion to steel and non-ferrous metals	
	Electrically conductive effect	
Technical / Physical Data	Binder-Base	Combination of acrylate/amino resin
	Colour	All common colour shades
	Gloss value visual	mat
	Viscosity	1800-3000 mPa.s/ Spindle 5 60 revolution/ min.
	Hardener	HE0132 See technical data sheet
	Mixing ratio	Parts by weight 2:1
	Mixing ratio	Parts by volume 1,57:1
	Thinner	demineralised water
	pH-Value	8-9
	Density calculated	1,30-1,50 g/ml
	Density calculated	1,18-1,38 g/ml after adding hardener
	Solid Mass calculated	57-61 %
	Solid Mass calculated	55,7-59,7 % after adding hardener
	Solid content in volume calculated	330-370 ml/kg
	Solid content in volume calculated	350-390 ml/kg after adding hardener
	Material usage theoretical, without application loss	160-180 g/m², Layer thickness 60 µm after adding hardener
	Reference colour of the specified values	Colour of WE1986MRU735
Substrate	Primer	
Pretreatment	The substrate must be free of adhesion-impairing substances such as oil, grease, rust, scale, rolling skin, wax and separating agent residue. Preliminary tests are recommended for assuring the suitability of coating qualities on the substrate. For more stringent requirements, we recommend: for corrosion protection - e.g. phosphating for adhesion - e.g. blasting, pickling, sanding	
Structure recommendation	Substrate	on blasted steel plate
	Primer	WE1986MRU735

DIN EN ISO 9001
IATF 16949
EMAS

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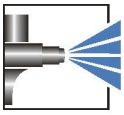

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Processing and application		Mixing ratio 2:1 HE0132 Dry film thickness 60 µm
	Top coat	WU1451GRA320 Mixing ratio 4:1 HU0448 Dry film thickness 60 µm
	Prior to use, stir well or mix components homogeneously (e.g. with fast mixer). To prevent skin formation, over-coat with water. Dry film thickness must not exceed µm - risk of reaction bubbles.	
	Object temperature	15-30 °C
	Processing conditions	Room temperature 16-25 °C Relative humidity 40-70 %
	Processing time	max. 3 hrs./ 20 °C End of the processing time cannot be detected from gelling. The processing time can decrease at higher temperatures and/or under pressure.
	Airless spraying	as delivered viscosity Nozzle 0,33 mm angle 30° Material pressure 130 bar
	Airmix spraying	as delivered viscosity Nozzle 0,33 mm Angle 30° Material pressure 120 bar Atomiser pressure 4
	High pressure spraying	as delivered viscosity Nozzle: 1,7 mm Spray pressure 3 bar
	Over-coating capability	possible with same quality, dry at the earliest after matting
	Cleaning of equipment	Immediately with water - possibly with addition of 5-10 % by weight EFD cleaning agent 400916. Dried-on equipment with org. solvents, e.g. EFD thinner 400424.
	Health & Safety at Work guidelines The standard personal safety precautions must be observed when handling painting materials. Detailed information about dangerous substances, safety data and recommendations concerning Health & Safety at Work and environmental protection can be found in the corresponding safety data sheet.	
Curing	Air drying	at 20°C, 50% relative humidity with air movement
	Dust drying	after 15 min. (degree of drying 1/ DIN EN ISO 9117-5)
	Dry to the touch	after 3 hrs. (degree of drying 4/ DIN EN ISO 9117-5)
	Full drying	after 7 days (pendulum damping/DIN EN ISO 1522)
	Oven drying	possible to 70°C
Resistance to storage	Approx. 12 month in original packagings at an ambient temperature of 5 to 25 °C. Protect from frost. Open packages are to be used within a short time. The minimum storage stability of each batch is stated on the product label. The	

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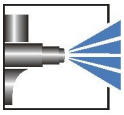

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	material does not necessarily become unusable if stored for longer than this period. However, for quality assurance purposes, an inspection of these materials is essential to ensure that they are still suitable for the intended application.
Specific comments	**Approval** available - on request
	EFD-info Refer to the EFD information for further technical information. Nr. 111 + 510
	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.

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