

FREOPOX

UHS-Primer ER1936H

- 2-component aktivprimer with solvent
- Very good corrosion protection
- Good adhesion
- For industrial goods and all kinds of construction machines

Technical / Physical data	Resin/ binder	epoxyde resins
	Colour	in support to RAL 840 HR other colour shades on request
	Gloss value visual	satın mat
	Original viscosity DIN 53211* without hardener	60 to 80 sec. / 4 mm cup
	Mixing ratio by weight	12 : 1
	Mixing ratio by volume parts	6,3 : 1
	Hardener base	FREOPOX-Hardener HE0016 Phenalkamide
	Potlife after hardener addition	max. 3 h / 20°C
	Thinner	EFD-Thinner 400424
	Density after hardener addition, calculated	1,75 / ml + / - 0,05
	Solid content after hardener addition, calculated	80 % + / - 1
	Solid content in volume after hardener addition, calculated	342 ml / kg + / - 5 or 63 % + / - 2
	Consumption calculated, after hardener addition in original viscosity, without application loss	230 g / m ² dry film thickness 80 µm see „Special remarks“
	Spreading rate calculated, after hardener addition in original viscosity, without application loss	4,3 m ² / kg dry film thickness 80 µm see „Special remarks“

Storability

Approx. 18 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

Due to the low viscosity, the high solid content and the high density ER1936H tends to sediment. Before hardener addition ER1936H has to be stirred carefully with a high-speed mixer.

Components are to be mixed homogeneously (e.g. with high-speed mixer).

spraying-airmix:	in original viscosity after hardener addition nozzle: 0,23 mm/ 0,009 inch angle 40° atomizer pressure: 3 bar
spraying-airless:	to fix the application parameters trials are necessary before use
spraying-high pressure:	after hardener addition and viscosity adjustment to 40 to 50 sec / 4 mm cup DIN 53211 nozzle: 1,5 to 2,0 mm spraying pressure: 4 to 5 bar
by roller/ brush:	in original viscosity after hardener addition

Substrates

steel, stainless steel, aluminium, galvanized steel (hot-dip galvanized)

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, purity at least SA 2 ½ "DIN EN ISO 12944-4") pretreatment.

Proposal for a coating system

substrate:	steel (blasting)	
primer:	FREOPOX-UHS-Primer	ER1936H
top coat:	EFDEDUR-HighSolid-Paint	UR1991

Application temperature

above 18 to 24 °C

Drying air drying at 20°C

dust dry:	after	30 min.	(degree of drying 1/ DIN EN ISO 9117-5)
dry to touch:	after	5 h	(degree of drying 4/ DIN EN ISO 9117-5)
complete dry:	after	7 days	(swinging beam hardness/ DIN EN ISO 1522)

Recoatability

With itself after previous cleaning, at any time possible.

With 2K-PU-Top coat after 30 to 90 Min., or after drying over night

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 precautionary measures for ventilation as well as for personal protection are to be observed when handling painting materials. Detailed information about dangerous goods, safety data and recommendations concerning health protection and environment protection can be read in the corresponding safety data sheet.

Special remarks

Test condition

*Indication of the delivery viscosity according to DIN 53211:

DIN 53211 was withdrawn in October 1996. On request the value is available according to DIN EN ISO 2431.

All information is based on a standard climate 20/65 DIN 50014.

The statements concerning efficiency, drying and caution labelling depend on colour shade. The values mentioned in this data sheet are based on ER1936HRU735, light grey and hardened with HE0016.

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.