ER1904G_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	glossy	
Viscosity	Flow time 80-100 sec., 4 mm flow cup	DIN 53211
Density	1,00-1,15 g/ml after addition of hardener	theoretical
Solid mass	55-61 % after addition of hardener	theoretical
Solid content in volume	48-50 % after addition of hardener	theoretical
Reference product	The specified values refer to the product ER1904GRA701.	
Resistance to storage	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. 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.

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Structure recommendation	Substrate	Steel	
	Primer	ER1912M Mixing ratio 5:1 HE0052 Dry film thickness 70-90 µm	
	Top coat	ER1904G Mixing ratio 5:1 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 5:1		
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 105-120 g/m² 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

Alternative hardener	for better chemical resistance	HE0020
	for higher hardness	HE0020
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 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.	

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