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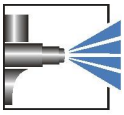

FREOPOX-Hydro-Grundierung
WE1935M/HE0037

Characteristics	Water-thinnable 2C coating	
	Application, e.g. in the vehicle construction sector	
	Fast initial drying	
	Very good corrosion protection	
	"Wet-in-wet" process	
	Good grindability	
	Rapid recoatability	
	Good adhesion to steel and non-ferrous metals	
Technical / Physical Data	Binder-Base	Epoxy resin crosslinked with polyamine
	Colour	All common colour shades
	Gloss value DIN EN ISO 2813	mat 40-50 Angle 85°
	Viscosity	2000-2400 mPa.s/ Spindle 5 60 revolution/ min.
	Hardener	HE0037 See technical data sheet
	Mixing ratio	Parts by weight 8:1
	Mixing ratio	Parts by volume 6,3:1
	Thinner	demineralised water
	pH-Value	8,0-9,0
	Density calculated	1,32-1,42 g/ml
	Density calculated	1,32-1,33 g/ml after adding hardener
	Solid Mass calculated	60,7-61,7 %
	Solid Mass calculated	58,5-59,5 % after adding hardener
	Solid content in volume calculated	322-342 ml/kg
	Solid content in volume calculated	325-345 ml/kg after adding hardener
	Material usage theoretical, without application loss	175-185 g/m², Layer thickness 60 µm after adding hardener
	Reference colour of the specified values	Colour of WE1935MRU124
Substrate	Steel, passivated or pretreated substrates	
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.	

DIN EN ISO 9001
IATF 16949
EMAS

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	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	WE1935MRU124 Mixing ratio 8:1/ HE0037 Dry film thickness 60 µm
	Top coat	WU1488GRA743 Mixing ratio 3,3:1/ HU0448 Dry film thickness 40 µm
Mechanical Test	Cross-cut-test DIN EN ISO 2409	Gt 0
Resistance Test	Condensate constant climate DIN EN ISO 6270-2 (CH)	240 hours Degree of blistering 0 (S 0) DIN EN ISO 4628-2
	Salt spray test (NSS) DIN EN ISO 9227	744 hours Water ingress Wb < 1 mm DIN EN ISO 4628-8
	Temperature resistance	Short time loading 120°C
	Chemical resistance	Needs to be checked. The temperature and concentration of chemicals have a major influence on the test outcome.
Processing and application	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 200 µm - risk of reaction bubbles.	
	Object temperature	10-30 °C
	Processing conditions	Room temperature 18-25 °C Relative humidity 40-60 %
	Processing time	max. 5 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.
	Airmix spraying	130-150 Sec./ 6 mm Viscosity cup (DIN 53211) Nozzle 0,33 mm Angle 30° Material pressure 120 bar Atomiser pressure 4
	High pressure spraying	50-70 Sec./ 4 mm Viscosity cup (DIN 53211) Nozzle 1,7 mm Spray pressure 3 bar
	Rolling / painting	as delivered viscosity
	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.

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	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 2 hrs. (degree of drying 4/ DIN EN ISO 9117-5)
	Full drying	after 8 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 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	**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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