

# FREOPOX

## Zinc Dust Paint ER1943M

- 2-component primer with solvent
- Very good corrosion protection
- Good application characteristics
- Well suited in Steel construction industry

Technical / Physical data	Resin/ binder	epoxyde resins	
	Colour	grey	
	Original viscosity DIN 53211* without hardener	30 to 50 sec. / 6 mm cup	
	Mixing ratio by weight	15 : 1	
	Mixing ratio by volume	4,7 : 1	
	Hardener base	FREOPOX-Hardener HE0143 polyamidoamin resin	
	Potlife after hardener addition	max. 6 h / 20°C see „Special remarks“	
	Thinner	EFD-Thinner	400424
	Density after hardener addition calculated	2,50 g / ml	+ / - 0,1
	Solid content after hardener addition calculated	85 %	+ / - 2
	Solid content in volume after hardener addition calculated	225 ml / kg 57 Vol. %	+ / - 8 or + / - 1,5
	Consumption calculated after hardener addition in original viscosity, without application loss	360 g / m <sup>2</sup> dry film thickness 80 µm see „Special remarks“	

Storage stability	Approx. 12 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 usage is essential due to quality guaranty reasons.
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Zinc Dust Paint  
ER1943M**Processing and application****Application**

Components are to be mixed homogeneously (e.g. with high-speed mixer).  
The mixture is ready for use after a waiting time of 15 minutes and stirring once more.

spraying-airless: in original viscosity after hardener addition  
thinner addition (0-2 %, per weight)  
spraying-high-pressure: in original viscosity after hardener addition  
thinner addition (1-5 %, per weight)  
by roller/ brush: in original viscosity after hardener addition  
thinner addition (0-1 %, per weight)

**Substrates**

steel blasted

**Pretreatment**

The substrate must be free of materials which prevent adhesion, e.g. oil, grease, dust, surfactant and jet residual. Steel: Blast in accordance with DIN EN ISO 12944-4 with the surface preparation factor Sa 2 1/2. Middle roughness factor (G) in accordance with DIN EN ISO 8503-1.

**Proposal for a coating system**

substrate:	steel blasted	
1. primer:	FREOPOX-Zinc dust paint	ER1943M
2. primer:	FREOPOX-primer	ER1912
top coat, e.G.:	EFDEDUR-UHS-Topcoat	UR1409
	EFDEDUR-Paint	UR1044

**Application temperature**

above 10 °C

**Drying**

air drying at 20°C

dust dry: after 20 min. (degree of drying 1 / DIN EN ISO 9117-5)  
dry to touch: after 1 h (degree of drying 4 / DIN EN ISO 9117-5)  
complete dry: after 7 days (swinging beam hardness / DIN EN ISO 1522)

oven drying: to 80°C possible (object temperature)  
In the case of forced drying process the hardening is accelerated.

**Recoatability**

after 1,5 h / 20 °C

At a intermediate drying of more than 72 h. / 20 °C must be checked the Recoatability.

**Cleaning of working equipment**

EFD-Thinner 400424 within the working time, completely dried  
enamel residue can be removed only mechanically.

**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****Resistance**

With appropriate structure of coating very good corrosion protection values can be attained.  
The dry film thickness of FREOPOX-Zinc dust paint ER1943M is approx. 70-80 µm.

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**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.

The statements concerning efficiency and drying depend on colour shade.

The values mentioned in this data sheet are based on ER1943MRU700, grey and hardening with HE0143.

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

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.