

Guideline formulation: W 2173 V1 d

Product: Epotufester M550-BG-70 + Arolon 845

 Formulation for: **waterred. Hybride - rust protection primer, white**

Components:	parts per weight	Supplier
1. EPOTUFESTER M550 - BG - 70	14,0	REICHHOLD
	load	
2. Tri ethyl amine	add while stirring	1,0
3. water deionised	add in portions while stirring	14,0
4. Diccnate 3111 (Co-Naphtenate Emulsion)		0,1
5. Additol XL 252		0,2
6. Surfino 104 E		0,3
7. BYK 025		0,3
	add an mix	
8. Talkum EL 20		10,0
9. Halox SZP-391		3,2
10. Heucophos ZPA		3,2
11. Omycarb 2		8,5
12. Plastorit Super		4,2
13. Titandioxid Kronos 2310		10,5
add and disperse with glass beads until reach fineness of 7NS		
14. AROLON 845 -W-45	30,0	REICHHOLD
	langsam unter rühren zusetzen	
15. Byk 025		0,3
16. Exkin 2	add and mix until homogenous	0,2
		100,0

solvent content: approx. 4%

solid content: approx. 63 %

viscosity: 25-30 sec./ DIN cup 4, 20°C

PH-value: 8,8 - 9,2

drying times (100µ wet): 12 min dust free, ~18 min to handle

Persoz-hardness at R.T.:

25 min	30 min	1 h	2 h	4 h	6 h	1 d	5 d	12 d	20 d
30	32	43	49	52	66	118	142	184	190

 water storage (1h) after 4h drying at RT: **NO** loss of hardness immediately after test finish!

adhesion to CRS: GT 0

Saltspray test DIN SS50021: DFT 25µ, 300h: 1mm rust, few small bubbles

DFT 50µ, 300h: no rust, very few small b. only al. the cut

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