

STEOPOX-AQUA-HÄRTER 7E717

Series 7E717 · Water-thinnable 2K polyamine hardener (colorless) for the Steopox-Aqua Stamm 2E414



01 PRODUCT DESCRIPTION

Steopox-Aqua-Härter 7E717, colorless is a water-thinnable two-component polyamine hardener of the 7E717 series for the Steopox-Aqua Stamm 2E414. The colour shade of the system is set via the hardener component – the variant described here is colorless and, together with the likewise colorless base component, produces a clear, transparent coating. Only the combination of both components yields the water-borne 2K EP coating for automotive add-on parts which adheres well to phosphated steel sheet and is chemically resistant. The characteristics in this data sheet refer to the system of base and hardener; details of the base component are given in its own technical data sheet, Steopox-Aqua Stamm 2E414.

02 PRODUCT PROPERTIES

Binder system	Polyamine adduct			
Hardener system	Steopox-Aqua Stamm 2E414, colorless			
Adjustment thinner	Demineralized water (if required)			
Cleaning thinner	Bergolin Hydro Cleaner 5P420			
Characteristics	 Water-thinnable	 Corrosion protection	 Chemically resistant	 Good adhesion
Color shade	Colorless, clear, transparent			
Gloss	Glossy, > 80 GU (60°)			
Shelf life	Approx. 6 months in the unopened original container at +4 °C to +40 °C. Protect from frost.			

Property	Comp. A	Comp. B	Mixture
Density · DIN EN ISO 2811-1 · +20 °C * ¹	Approx. 1.00–1.10 g/cm ³	Approx. 1.00–1.05 g/cm ³	Approx. 1.05 g/cm ³
VOC content · IE Directive 2010/75/EU · SDS * ¹	Approx. 42.8 g/l	Approx. 0 g/l	Approx. 13.8 g/l
Solid content (wt.-%) · SDS * ¹	Approx. 50.8 %	Approx. 48.8 %	Approx. 49.4 %
Flow viscosity · DIN EN ISO 2431 · +20 °C * ¹	Approx. 32–35 s (4 mm)	Approx. 55–60 s (4 mm)	Approx. 25–35 s (4 mm)

*¹ Depending on colour shade

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03 APPLICATION

The following information may vary depending on the application. Please contact your direct contact person for more detailed information.

Substrate	Steel sheet, clean, free from rust and grease
Surface preparation	For series production, iron or zinc phosphating is required.
Mixing ratio	100 : 200 by weight 100 : 200 by volume
Mixing	Application with a suitable 2K (3K) dosing unit. Before starting, the unit should be volumetrically calibrated (litre check) and any deviations in the mixing ratio corrected.
Theoretical consumption	Approx. 100 g/m ² of the mixture at 50 µm dry film thickness
Application method	 Electrostatic / airless / air-spray gun
Application conditions	 Application temperature +4 °C to +40 °C  Relative humidity 60–80 %
Working time ^{*2}	Max. 2 h (mixed). Unmixed: open containers 8–10 h (skin formation), covered 10 d, sealed until expiry date.

DRYING

Flash-off time	At RT 30 min 30 °C 20 min 40 °C 10 min 50 °C 5 min
Touch-dry	At RT 180 min 50 °C 60 min

^{*2} Values are based on laboratory measurements at +20 °C. Lower temperatures slow down drying; higher temperatures accelerate it.

04 NOTE

This product data sheet supersedes all previously published product data sheets. The information contained herein is based on practical experience under standard conditions and assumes proper storage and processing. Substrates, materials and working conditions may vary. Therefore, no warranty or liability can be derived from the information contained in this document or from verbal consultation. It is the buyer's responsibility to verify the product's suitability for the intended use. Preliminary trials are recommended. The relevant legal regulations, the leaflets of the BG RCI and the accident prevention regulations of the responsible employers' liability insurance association must be observed. In all other respects, our General Terms and Conditions of Sale and Delivery apply.

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