

STEOPOX-HÄRTER WS 7E717-0095

Series 7E717-0095 · Water-based 2K polyamine hardener (black) for the Steopox-Aqua Stamm 2E414



01 PRODUCT DESCRIPTION

Steopox-Härter WS 7E717-0095, schwarz is a water-based, two-component polyamine/epoxy hardener developed specifically for corrosion protection in automotive manufacturing. Combined with the Steopox-Aqua Stamm 2E414 it forms a resistant, chemically resistant coating with excellent adhesion to metal surfaces – for vehicle bodies, frames and other safety-critical components. Thanks to its water-based formulation the product helps reduce VOC emissions and meets modern environmental standards.

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	Black (RAL 9005)			
Gloss	Approx. 5–35 GU (satin matt) · 60° · DIN EN ISO 2813			
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	Approx. 1.00–1.10 g/cm³	Approx. 1.25–1.45 g/cm³	Approx. 1.13–1.28 g/cm³
VOC content · IE Directive 2010/75/EU	Approx. 42.8 g/l	Approx. 62.0 g/l	Approx. 51.3 g/l
Solid content (wt.-%) · SDS	Approx. 50.8 %	Approx. 57.5 %	Approx. 54.3 %
Flow viscosity · DIN EN ISO 2431 · +20 °C	Approx. 32–35 s (4 mm)	Approx. 75–80 s (4 mm)	Approx. 40–50 s (4 mm)

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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 : 92 by weight 100 : 120 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. 135 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	Max. 2 h (mixed). Unmixed: open containers 8–10 h (skin formation), covered 10 d, sealed until expiry date.
Recoating interval (with itself)	Sandable from 1 h after oven curing at 80 °C. Recoatable after oven curing with the 7E717 series (test other media on site).
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 80 °C 20 min
Load-bearing	Mechanically 2 h after oven curing (80 °C) or 16 h at RT chemically 7 d (10 d at RT)

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**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.

MODIFIED BY

25.08.2026 – Martin Krull, Head of Laboratory

APPROVED BY

25.08.2026 – Stefan Eisenmenger, Product Management