LACK UND KUNSTSTOFF CHEMIE GMBH

DATA SHEET

GEHOLIT-K913-Primer

Corrosion protection primer coating for steel surfaces

■ FIELDS OF APPLICATION

Quick-drying corrosion protection primer coating for steel girder constructions, appliances, conveyor systems, building machines and the like, for efficient application methods.

■ PRODUCT PROPERTIES

GEHOLIT-K913-Primer is based on specially modified alkyd resins and contains proven corrosion protection pigments, free of lead and chromate.
The material is preferably applied by airless-spraying. Brush application or high pressure/air spraying are also possible.

In a single working operation a dry film thickness of 80 to 100 µm can be applied.
Due to the rapid initial drying and the quick drying process, top coatings can be applied in quick succession which means economically efficient application methods. Together with suitable top coatings, high-grade corrosion protection systems can be achieved.

Capacities

Temperature resistance (dry heat): 120 °C permanently
140 °C short term

■ PRODUCT DATA

				RWE-Code-No.
Product number and colour	K913-309	oxide red	approx. RAL 3009	GB-13-L-3009
	K913-701	silver grey	approx. RAL 7001	GB-13-L-7001

Form of delivery

Ready for brush application

Standard packaging

20 litres

Shelf life

At least 18 months in original cans at normal temperature

Suitable thinner

V-89 (also for cleaning of equipment)

Theoretical parameters

GEHOLIT-K913-Primer, K913-309

Density (g/ml)	Solid content (weight %)	VOC content (weight %)	Solid content by volume (%)	(ml/kg)
1.45	69	31	48	331

DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate (m²/kg)
100	208	0.302	3.3 = 4.8 m²/l

Remarks

- All values are relevant for the mixture in case of two-component materials
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour) mentioned above. The values may differ slightly for different colours.

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values (Phase I from 2007)	(Phase II from 2010)	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in “Application methods”)
i (“One-pack performance coatings”) Type SB	600 g/l	500 g/l	< 500 g/l

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Coating systems	**Suitable top coatings:**		**RWE-Code-No.**
	WIEKORANT-A911	A911-E7833	DB-11-L-7033
		A911-E9707	DB-11-L-9007
		A911-E9811	DB-11-L-9011

■ INSTRUCTIONS FOR APPLICATION

Surface preparation Blast-cleaning in preparation grade Sa 2 ½ in accordance with DIN EN ISO 12944-4.

Air and surface temperature Optimal results at temperatures of 15 to 25 °C, not below 5 °C

Relative humidity Max. 80 % relative humidity

The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air throughout the application. (see basic specification for corrosion protection DIN EN ISO 12944-7)

Comments on processing

Application methods

Means of application / parameters	attainable dry film thickness per working operation (approx.)	Addition of thinner V-89
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 200 bar	80 to 100 µm	up to 3 %
Roller coating / brush application	60 to 80 µm	up to2 %
In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.		

Remarks

- The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

Drying and curing times Related to a temperature of 20 °C and a DFT of 80 µm

Dry to touch: After 45 to 60 minutes
Tack free: After 4 to 5 hours
Ready for over-coating: With WIEKORANT-A911 after 12 to 16 hours

■ SAFETY MEASURES

The relevant data concerning safety measures, e.g. declarations according to regulations for dangerous goods and VbF can be found in the material safety data sheet of this product.
Hazard notes and safety recommendations can be found on the labels of the containers. Furthermore the relevant regulations must be observed, e.g. the rules and regulations for the prevention of occupational accidents of the German Berufsgenossenschaften.