LACK UND KUNSTSTOFF CHEMIE GMBH

**TECHNICAL INFORMATION**

# GEWITEX-W111F-Dipping-Primer
**red brown**

**- waterborne -**

## ■ FIELDS OF APPLICATION

Quick-drying-primer for cast iron, sheet metal parts and deep drawn components.

## ■ PRODUCT PROPERTIES

GEWITEX-W111F-Dipping-primer is specially adjusted for dip coating.

The primer coats achieved by this method show excellent adhesion on cast iron, sheet metal parts and deep drawn components.

Together with suitable top-coats it is possible to produce coating systems for different demands.

GEWITEX-W111F-Dipping-primer - based on waterborne acrylic copolymerisate resin - is suitable for air drying and also for a forced drying, e.g. 30 to 50 °C.

The steel parts preserved with GEWITEX-W111F-Dipping-primer can be welded over using the usual welding processes.

Analysis of the products of combustion (ascertained by gas detection tests when welding) produced readings well under the limits currently prevailing.

**TEST REPORTS**

Inspection report 20106600011 of the SLV Duisburg, 27.04.2010
- Determination of the porosity level in accordance with the German DVS-guideline 0501
- Trace gas measurement during welding of plates coated with primer GEWITEX-W111F

**PRODUCT DATA**

**Product number** W111F-850

**Colour** red brown

**Degree of gloss** mat

**Viscosity of delivery**
DIN 53211/4mm 40 to 50 s
or
DIN EN ISO 2431/5 mm 50 to 70 s

**Shelf life** At least 6 months in original cans at normal temperature

**Appropriate thinner** Demineralised water

**Theoretical parameters**

GEWITEX-W111F-Dipping-Primer, W111F-850

| Density (g/ml) | Solid content (weight %) | VOC content (weight %) | Solid content by volume (%) | (ml/kg) |
|---|---|---|---|---|
| 1.3 | 60 | 4,3 | 47,5 | 357 |

| DFT (µm) | Calculated wet-film thickness (µm) | Consumption (kg/m²) | Spreading rate (m²/kg) |
|---|---|---|---|
| 40 | 84 | 0.112 | 8,9 |

Remarks
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour) named above. The values may differ slightly for other colours.

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# GEWITEX-W111F-Dipping-Primer
**red brown**

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

| Subcategory as referred to in Annex IIA | VOC limit values (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 WB | 140 g/l | < 140 g/l |

## ■ INSTRUCTIONS FOR APPLICATION

**Surface preparation**

All parts have to be clean and dry.
Grease, oil and other pollutants have to be removed thoroughly.

**Comments on processing**

**Air and surface temperature**

Optimal results at temperatures of 15 to 25 °C, not below 10 °C

**Relative humidity**

Optimal results at 40 to 60 %, max. 80 % relative humidity.

**Comments on processing**

**Application methods**

| **Dipping** | | | |
|---|---|---|---|
| Viscosity DIN 53211 / 4mm | 35 - 40 s | 24 - 35 s | 18 - 25 s |
| Addition of demineralised water | up to 1 part by weight | 1 to 3 part by weight | 5 to 8 part by weight |
| dry film thickness | 35 to 60 µm | 25 to 40 µm | 20 to 30 µm |

Remarks

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

**Drying times**

Related to a dry film thickness of approx. 40 µm
and a temperature of approx. 20 °C

**Air drying**

Dry to touch: After approx. 30 to 40 minutes
Tack free: After 60 to 80 minutes

**Forced drying**

evaporation/ drying: 15 to 30 minutes at 40 to 70 °C

## ■ 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.