LACK– UND KUNSTSTOFF– CHEMIE GMBH

TECHNICAL INFORMATION

GEWITEX-W112

Single-layer for steel parts
-waterborne-

■ FIELDS OF APPLICATION

Quick-drying single-layer for cast steel, blank sheets and deep drawn components.

■ PRODUCT PROPERTIES

Single-layer of GEWITEX-W112 show excellent adhesion on cast steel, blank sheets and deep drawn components.

The material can be applied by spraying (e.g. airless, airmix, high pressure).

Together with suitable top coatings corrosion protection systems for indoor and outdoor uses can be attained.

GEWITEX-W112 is air-drying, for industrial uses however we recommend a forced drying, e. g. at 30 to 50 °C.

■ PRODUCT DATA

GEWITEX-W112

Product-number

W112-F7021 black grey, approx. RAL 7021
(other colours on request)

Viscosity of delivery
DIN 53211/6mm

12 to 18 s

Shelf life

At least 6 months in original cans at normal temperature

Appropriate thinner

demineralised water

Theoretical parameters

GEWITEX-W112, W112-F7021

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	VOC-content per 10 µm DFT* (g/m²)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.2	53	< 2	0.6	43	360
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
80	185	0.222		4.5	

Remarks

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

* baseline for calculation: consumption in g/m² at DFT 10 µm

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

Coating systems

Suitable top coatings
GEWITEX-W120
GEWITEX-W145

Other top coatings on demand.

It is recommended to fix coating systems adapted to the application in manufacturing instructions and specifications.

■ INSTRUCTIONS FOR APPLICATION

Surface preparation

Coatings
Adhesion-reducing substances must be removed.

Comments on processing

Air and surface temperature

Optimal results at temperatures of 15 to 20 °C, not below 10 °C

Relative humidity

Optimum at 40 to 60 %, 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 EN ISO 12944-7)

Application methods

Means of application / parameters	attainable dry film thickness per operation (approx.)	Addition of demineralised water
High pressure/air spraying Nozzle diameter: 1.3 to 1.5 mm Pressure: 3 to 4 bar	80 µm	0 to 3 %
Airmix spraying Nozzle diameter: 0.28 to 0.38 mm Material pressure: 60 to 100 bar Pressure: 0.8 to 1.3 bar	80 µm	0 to 3 %
Airless spraying Nozzle diameter: 0.28 to 0.38 mm Material pressure: 80 to 120 bar	80 µm	-

Remarks

- The statement is related to a temperature of approximately 20 °C.
- The parameters mentioned above are recommendations respectively rough guides. In practice other values could be necessary.

Cleaning of equipment

Coating material (liquid paint): With water
Surface dried coating: With cleaning thinner V-407 or V-411 (only short term load of the equipment)

Drying times

	Air drying at a temperature of approx. 20 °C:
Dry to touch	after 30 to 40 minutes
Tack free	after approx. 2 hours
Over-coatable with	
One pack top coating	after 12 to 16 hours
Two pack top coating	after 48 hours
	Accelerated Drying:
Flashing-off	10 minutes at 18 to 20 °C
Drying	20 minutes at 60 to 70 °C
Tack free	after approx. 20 minutes cooling at 20 to 25 °C
Over-coatable with	
One pack top coating	after 16 hours
Two pack top coating	after 48 hours

■ **SAFETY MEASURES**

The relevant data concerning safety measures can be found in the material safety data sheet of this product.
The valid issue of the material safety data sheet is available from our website www.geholit-wiemer.de.