LACK UND KUNSTSTOFF CHEMIE GMBH

TECHNICAL INFORMATION

GEWITEX-W112-Primer

Primer-coating for steel parts
-waterborne-

■ FIELDS OF APPLICATION

Quick-drying primer coating for cast steel, blank sheets and deep drawn components.

■ PRODUCT PROPERTIES

Primer coatings of GEWITEX-W112-Primer 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-Primer is air-drying, for industrial uses however we recommend a forced drying, eg at 30 to 50 °C.

■ PRODUCT DATA

GEWITEX-W112-Primer

Product-number

W112-735 light grey, approx. RAL 7035
(other colours on request)

Viscosity of delivery
DIN 53211/6mm

18 to 23 s

Shelf life

At least 6 months in original cans at normal temperature

Appropriate thinner

demineralised water

Theoretical parameters

GEWITEX-W112-Primer, W112-735

Density (g/ml)	Solid content (weight %)	VOC content (weight %)	Solid content by volume (%)	(ml/kg)
1.35	61	approx. 3	47.5	350

DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate (m²/kg)
50	105	0.142	7,0

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) named above. The values may differ slightly for other colours.

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

Substrate	Steel, cast steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 ½ in accordance with DIN EN ISO 12944-4	
	Product	**NDFT (µm)**
Primer coating	GEWITEX-W112-Primer	40 to 60
Top coating	GEWITEX-W120 or GEWITEX-W145	40 to 60

The coating system/s named are examples proved in practice which usually can be modified. The choice of coating materials as well as their number and film thickness depends on the stress to be expected, existing specifications and the methods of application.

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■ 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 DIN 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	40 to 60 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	50 to 70 µm	-
Airless spraying Nozzle diameter: 0.28 to 0.38 mm Material pressure: 80 to 120 bar	50 to 70 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 component top coating	after 12 to 16 hours
Two component 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 component top coating	after 4 hours
Two component top coating	after 24 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.