

-waterborne-

■ **FIELDS OF APPLICATION** Quick-drying dipping paint for cast steel, cast iron, blank sheets and deep drawn components.

■ **PRODUCT PROPERTIES** GEWITEX-W112F-Dipping-Paint is adjusted in particular for dip coating application.

Primer coatings of GEWITEX-W112F-Dipping-Paint show excellent adhesion on cast steel, blank sheets and deep drawn components. Together with suitable top coatings corrosion protection systems for different demands can be attained.

GEWITEX-W112F-Dipping-Paint is air-drying, for industrial uses however we recommend a forced drying, e.g. at 30 to 50 °C.

■ **PRODUCT DATA**

GEWITEX-W112F-Dipping-Paint

Product-number W112F-F7021

colour Black grey, approx. RAL 7021

Degree of gloss flat

Viscosity of delivery 45 to 60 s
DIN 53211/4mm

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

Appropriate thinner demineralised water

Theoretical parameters GEWITEX-W112F-Dipping-Paint Black grey, W112F-F7021

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	per 10 µm DFT* (g/m ²)	Solid content by volume (%)	(mL/kg)
1.20	54	< 2	0.5	44	370
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
40	91	0.108		9.3	

- 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

■ INSTRUCTIONS FOR APPLICATION

Surface preparation Surfaces have to be dry and clean. Grease, oil and other pollutants must 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 Optimum at 40 to 60 %, max. 80 % relative humidity
Not to use at dew point conditions!

Application methods

Flushing / Dipping	Addition of water
Addition of VE-Water	5 to 10 %
Application viscosity Guidance level for DFT 20 – 40 µm	21 ± 3 s / 4 mm-cup according DIN 53211

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.

Drying times Relating to a temperature of approx. 20 °C and a dry film thickness of approx. 40 µm

Dry to touch: after 30 to 40 minutes
Tack free: after 60 to 80 minutes

Accelerated Drying:

Flashing-off /
Drying: 50 to 60 minutes at 25 to 30 °C

■ 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.

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision of construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.