

MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-ING, Blatt 86 and is subject to regular external control
- High-grade, moisture-curing 2-pack zinc-rich Priming coat for steel buildings and steel constructions with a dry film thickness of 80 µm
- Also applicable as a monolayer protective coating, in one up to two layers of 100 µm dry film thickness
- Maximum dry film thickness: 150 µm
- Temperature resistance up to 450 °C
- The use of GEHODUR-F86-Zink in the application range of the Directive 2004/42/EG "Decopaint-Directive" ist not allowed (e.g. coating of buildings or building parts)

PRODUCT DATA

GEHODUR-F86-Zink



F86-790 Grey, code number 686.03




Mixing ratio by weight

1:2,5 with curing agent B (powder)
slow, thorough stirring of the powder is required



Thinner V-627 (Standard: ambient temperature -10 up to 25 °C)
Thinner V-561 (Slow: ambient temperature 25 up to 40 °C)

GEHODUR-F86-Zink / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	2.65	80.0	20.0	63.0	240
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ¹⁾	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)
	80	127	8.3	0.330	3.0

1) Based on consumption in g/m² at DFT 10 µm

2) Theoretical consumption related on a smooth surface. Dependent on surface roughness and processing losses different consumption data will be achieved in practice

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airless³⁾



High pressure³⁾



Roller/Brush application⁴⁾

Nozzle diameter (mm)	0.33 to 0.58	1.5	-
Material pressure (bar)	200 to 300	1.5 to 2.0	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	70 to 80	70 to 80	40 to 60
Addition of thinner (%)	0 to 5	0 to 5	0 to 3




3) The ready-to-use mixture should be sieved before spraying (mesh-size approx. 300 µm)

4) only recommended for smaller areas

* DFT = Dry Film Thickness



Pot life
approx. 10 hours

Drying/Curing times at 80 µm DFT Relative humidity 60 to 80 %		Ambient air temperature		
		5 °C	15 °C	30 °C
	dust-free:	after 30 to 60 minutes	after 15 to 30 minutes	after 15 to 30 minutes
	tack-free:	after approx. 75 minutes	after approx. 30 minutes	after 15 to 30 minutes
	dry to handle:	≤ 2 hours	≤ 1 hour	≤ 1 hour
	overcoating interval:	≥ 24 hours	≥ 16 hours	≥ 12 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1



Air and surface temperature
≥ -10 °C




relative humidity ≥ 40 %, dew point distance ≥ 3 °C
For acceleration of curing the touch dry coating could be sprayed with water

Further details for processing and execution is described in the relevant applicable instructions

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Monolayer / Protective coat	GEHODUR-F86-Zink	100
	Priming coat	GEHODUR-F86-Zink	80
	Intermediate coats/ Top coats	GEHODUR-S3 GEHOPON-E87-ZB / -E97R-ZB GEHOPON-E90R WIEREGEN-M87 / -M97R	80

SAFETY MEASURES



Necessarily protect Component B (powder) against moisture. The relevant data can be found in the current material safety data sheets, available at www.geholti-wierner.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 or 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. This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.