

MAIN PRODUCT PROPERTIES

- Highly heat-resistant, weatherproof 1C-Si-Zinc dust priming coat for steel components, e.g. chimneys, industrial furnaces
- Nominal dry film thickness 30 µm, maximum 50 µm
- Temperature resistance up to 500 °C
- Not applicable in the application range of the directive 2004/42/EG, "Decopaint Directive"
- Functional properties are only achieved after complete curing, e.g., 1 h at 230 °C or 24 h at 160 °C

PRODUCT DATA

GEHODUR-S3-Zink



S3-790, Grey red (other colours on request)




Mixing ratio by weight

Not relevant



Thinner V-89

GEHODUR-S3-Zink / Guide values

	Density (g/mL)	Solid content (weight %)	VOC content (weight %)	Solid content by volume	
	2.40	80.5	19.5	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC content (g/m ²) ¹⁾	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)
	30	66	10.4	0.160	6.3

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

2) Theoretical consumption related to 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



Airless



High pressure



Roller/Brush application³⁾

Application viscosity (s) (4 mm DIN cup)	15 to 25	15 to 25	15 to 25
Nozzle diameter (mm)	0.23 to 0.33	1.2 to 1.5	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	30	30	30
Addition of thinner (%)	-	-	-

3) only recommended for smaller areas

* DFT = Dry Film Thickness

INSTRUCTIONS FOR APPLICATION



Pot life
Not relevant

Drying/Curing times at 30 µm DFT
Relative humidity 60 %

Ambient air temperature 20 °C



dust-free:

after approx. 1 hour



tack-free:

after approx. 4 hours



dry to handle:

≥ 12 hours

overcoating interval:

≥ 6 hours

Surface preparation

Steel surfaces

- Blast-cleaning Sa 3 according to EN ISO 12944-4,
Roughness grade medium (G) according to EN ISO 8503-1



Air and surface temperature
≥ 5 °C




relative humidity ≤ 80 %
dew point distance ≥ 3 °C

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 3 in accordance with EN ISO 12944-4

		Product(s) (other systems on request)	NDFT (µm)
	Priming coat	GEHODUR-S3-Zink	30
	Intermediate coats	GEHODUR-S3-Eisenglimmer GEHODUR-S3-Aluminium	2 x 20 - 30

Total nominal dry film thickness ≤ 90 µm in order to avoid stresses occurring in the event of strongly changing temperature loads.

SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at www.geholit-wiemer.de.

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