

## MAIN PRODUCT PROPERTIES

- Resistant to high temperatures and natural weathering
- Nominal dry film thickness 20-30 µm, maximum 50 µm
- Temperature resistance up to 600 °C
- Not applicable in the application range of the directive 2004/42/EG
- 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-Eisenglimmer, GEHODUR-S3-Aluminium



S3-E9200, Black metallic  
S3-E7600, Grey metallic  
S3-F7700, Bright silver




#### Mixing ratio by weight

Not relevant




Thinner V-89

### GEHODUR-S3-Eisenglimmer / Guide values

	Density (g/mL)	Solid content (weight %)	VOC content (weight %)	Solid content by volume	
	1.5	68.0	32.0	(%)	(mL/kg)
	DFT* (µm)	Calculated wet-film thickness (µm)	VOC content (g/m <sup>2</sup> ) <sup>1)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>2)</sup>	Spreading rate (m <sup>2</sup> /kg)
	30	65	10.7	0.100	10.0

### GEHODUR-S3-Aluminium / Guide values

	Density (g/mL)	Solid content (weight %)	VOC content (weight %)	Solid content by volume	
	1.1	42.0	58.0	(%)	(mL/kg)
	DFT* (µm)	Calculated wet-film thickness (µm)	VOC content (g/m <sup>2</sup> ) <sup>1)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>2)</sup>	Spreading rate (m <sup>2</sup> /kg)
	30	115	8.2	0.125	7.9

1) Based on consumption in g/m<sup>2</sup> 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 application<sup>3)</sup>

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

Total target layer 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-wierner.de](http://www.geholit-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.