

MAIN PRODUCT- PROPERTIES

- Well-trying, solvent-based alkyd resin priming coat
- Together with GEHOLIT-K48 in coating systems for many application areas, e. g. machine and apparatus construction

PRODUCT DATA

GEHOLIT-K48-Metallgrund



K48-735 Light grey (other colours on request)




Mixing ratio by weight

Not relevant



Thinner V-74

GEHOLIT-K48-Metallgrund / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.30	60.0	40.0	41.0	310
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	50	122	0.160	6.2	

COMMENTS ON PROCESSING

Recommendation at
temperatures
of approx. 20 °C



Airless



**High
pressure**



**Roller/Brush
application**




Application viscosity (s) (4 mm DIN-cup)	60 to 70	40 to 60	60 to 70
Nozzle diameter (mm)	0.33 to 0.43	1.5 to 2.0	-
Material pressure (bar)	approx. 200	-	-
Atomiser pressure (bar)	-	3.5 to 4.5	-
DFT * per working operation (µm)	40 to 50	40 to 50	40 to 50
Addition of thinner (%)	0 to 3	0 to 5	0 to 2



Pot life

Not relevant

* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 20 minutes
	tack free:	after approx. 2.5 hours
	ready for overcoating/handling:	after approx. 4.5 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

Existing priming coats or prefabrication primer

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of other priming coats compatibility tests are recommended



Air and surface temperature


optimal at 15 to 25 °C, not below 5 °C, not over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	GEHOLIT-K48-Metallgrund
	Monolayer / Top coat	GEHOLIT-K48

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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