





MAIN PRODUCT-PROPERTIES

- High-grade, flat High-Solid alkyd resin Monolayer for corrosion protection of steelparts for a plenty of applications, e.g. steel hall-, machine- and apparatus construction
- Monolayer for corrosivity categorie up to C2, especially interior
- Together with suitable top coats as priming coat also for higher stresses
- Processing occurs preferred in the shop by airless-spraying with film thicknesses of 80 to 120 µm

PRODUCT DATA

GEHOLIT-K62	MIO-colours RAL-colours, flat
 K62-E.... MIO-colours (according to G+W-colours)	K62-F.... RAL-colours (other colours on request)
 Mixing ratio by weight not relevant	
 Thinner V-74	

GEHOLIT-K62	Guideline MIO- and RAL-colours ¹⁾				
	Density (g/mL) 1.65	Solid content (weight %) 77.0	VOC-content (weight %) 23.0	Solid content by volume (%) (mL/kg) 340	
	DFT * (µm) 80	Calculated wet-film thickness (µm) 142	VOC-content (g/m ²) ²⁾ 6.6	Consumption (kg/m ²) ³⁾ 0.235	Spreading rate (m ² /kg) 4.3

1) Guideline averaged data, slight deviation are possible depending on the colour

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

3) 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



Airless /
Airmix

High
pressure

Roller/Brush
application ⁴⁾

Application viscosity (s) (8 mm DIN-cup)	13 to 15	6 to 10	13 to 15
Nozzle diameter (mm)	0.33 to 0.68	1.5 to 2.0	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 120	80 to 120	60 to 80
Addition of thinner (%)	0 to 3	4 to 6	0 to 2

* DFT = Dry Film Thickness

4) recommended only for smaller areas



Pot life
not relevant

Drying/Curing times at 80 µm DFT

Ambient air temperature 20 °C



dust-free:

after 30 minutes



tack-free:

after approx. 2 hours



overcoating interval / dry to handle:

after approx. 4 hours

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
i ("One-pack performance coatings") Type SB	500 g/l	< 500 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4

Existing primer 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
≥ 5 °C




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

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)
	Priming coats / Monolayer	GEHOLIT-K62	80 to 120
	Optional Top coats	GEHOLIT-K48 GEHOLIT-K64 GEHOTEX-W92	40 to 60 80 to 120 60 to 80

SAFETY MEASURES



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

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