

MAIN PRODUCT-PROPERTIES

- Satin glossy, low-solvent high-solid alkyd resin monolayer for nominal dry film thicknesses up to 120 µm
- In combination with suitable priming coats also applicable for higher corrosion stress for steel halls or apparatus construction

PRODUCT DATA

GEHOLIT-K64, satin glossy



K64-S.... (RAL-colours, other colours on request)




Mixing ratio by weight

Not relevant



Thinner V-89

GEHOLIT-K64 / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.50	76.0	24.0	59.0	395
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	80	136	0.200	5.0	

COMMENTS ON PROCESSING

Recommendation at
temperatures
of approx. 20 °C



Airless/
Airmix



High
pressure



Roller/Brush
application




Application viscosity (s) (8 mm DIN-cup)	13 to 15	6 to 10	13 to 15
Nozzle diameter (mm)	0.33 to 0.74	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 120	80 to 100	60 to 80
Addition of thinner (%)	0 to 2	-	0 to 2



Pot life

Not relevant

* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 60 minutes
	tack free:	after approx. 4 hours
	ready for overcoating/handling:	after 12 to 16 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

Optional priming coat (see below)

- Remove adhesion-reducing substances
- 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-K65-Metallgrund
	Monolayer / Top coat	GEHOLIT-K64

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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