

MAIN PRODUCT-PROPERTIES

- Low-solvent high-solid alkyd resin priming coat for steel surfaces
- Together with suitable topcoats, also for higher stress, for many application areas, e. g. steel girder construction, machine and apparatus construction
- Processing is preferably carried out in the factory by airless-spraying at nominal dry film thicknesses from 80 to 120 µm

PRODUCT DATA

GEHOLIT-K65-Metallgrund



K65-732 (RAL-colours, other colours on request)




Mixing ratio by weight

Not relevant



Thinner V-89

GEHOLIT-K65-Metallgrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1,55	78.0	22.0	61.0	395
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	131	5.6	0.205	4.9

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




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)	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 100	60 to 80
Addition of thinner (%)	0 to 2	4 to 6	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 30 minutes
	tack free:	after approx. 2 hours
	ready for overcoating/handling:	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 and cast iron

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

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**
≥ 5 °C

 Relative humidity ≤ 80 %
Dew point distance ≥ 3 °C


PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning grade Sa 2 ½ in accordance with EN ISO 12944-4

	Product(s) (other paint systems on request)	NDFT
 Priming coat / Monolayer	GEHOLIT-K65-Metallgrund	80 to 120
Monolayer / Topcoat	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-wiemer.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.