






MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR, Blatt 93
- High-grade, High-Solid topcoat for corrosion protection of steel constructions
- Together with GEHOLIT-K93-Metallgrund and GEHOLIT-K93-ZB especially suitable for reconstruction of old coatings based on 1C-coating materials
- Processing is preferably carried out by airless-spraying at nominal dry film thicknesses from 80 to 120 µm

PRODUCT DATA

GEHOLIT-K93	MIO-colours RAL-colours, mat
 K93-E... MIO-colours (according to G+W-colours)	K93-M... RAL-colours (other colours on request)
 Mixing ratio by weight not relevant	
 Thinner V-50	

GEHOLIT-K93	Guideline MIO-colours ¹⁾				
	Density (g/mL) 1.5	Solid content (weight %) 79.5	VOC-content (weight %) 20.5	Solid content by volume (%) (mL/kg) 60.5 400	
	DFT * (µm) 80	Calculated wet-film thickness (µm) 133	VOC-content (g/m ²) ²⁾ 5.1	Consumption (kg/m ²) ³⁾ 0.200	Spreading rate (m ² /kg) 5.0

GEHOLIT-K93	Guideline RAL-colours ¹⁾				
	Density (g/mL) 1.45	Solid content (weight %) 79.0	VOC-content (weight %) 21.0	Solid content by volume (%) (mL/kg) 61.0 420	
	DFT * (µm) 80	Calculated wet-film thickness (µm) 133	VOC-content (g/m ²) ²⁾ 4.9	Consumption (kg/m ²) ³⁾ 0.190	Spreading rate (m ² /kg) 5.3

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



High pressure







Roller/Brush application

Nozzle diameter (mm)	0.33 to 0.68	-	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	80 to 120	-	80
Addition of thinner (%)	0 to 5	-	0 to 2

* DFT = Dry Film Thickness



Pot life
not relevant

Drying/Curing times at 80 µm DFT	Ambient air temperature		
	7°C ⁴⁾	23 °C	30 °C
 dust-free:	-	after 2 to 3 hours	after 1 to 2 hours
 tack-free:	-	after 8 to 10 hours	after 6 to 8 hours
 dry to handle:	-	after approx. 2 days	after approx. 24 hours
 overcoating interval:	10 °C	20 °C	30 °C
	after approx. 48 hours	after approx. 16 hours	after approx. 12 hours

4) Drying at temperatures ≤ 10 °C strongly delayed

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces: required priming coats (see coating systems)

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

Existing old coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing and if applicable
- Hand or power-tool cleaning at preparation grade PMA respectively PST 2 according to EN ISO 12944-4
- Additional spotting if applicable



Air and surface temperature
≥ 5 °C




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

Further details for processing and execution is described in the relevant applicable instructions.

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning Sa 2 ½ or mechanical respectively manual derusting in surface preparation grade at least St3 in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coat	GEHOLIT-K93-Metallgrund	80
	Intermediate coat	GEHOLIT-K93-ZB	80 to 120
	Top coat	GEHOLIT-K93	80 to 120

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, Sweep blast-cleaning in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coat	GEHOLIT-K93-ZB	80 to 120
	Top coat	GEHOLIT-K93	80 to 120

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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This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.