LACK– UND KUNSTSTOFF– CHEMIE GMBH

TECHNICAL INFORMATION

GEHOPAL-L8-Metallgrund

1C-PVC/AY Primer
for steel and hot-dip galvanised steel

■ FIELDS OF APPLICATION

Primer coating for steel and hot-dip galvanised steel, in combination with suitable top coatings for systems with high protective capacities.
Therefore GEHOPAL-L8-Metallgrund is suitable especially for mixed constructions (steel/galvanised steel) or re-coating of weathered hot-dip galvanised steel parts.

■ PRODUCT PROPERTIES

GEHOPAL-L8-Metallgrund is a one-pack material based on PVC/ acrylic resin. It offers very good corrosion protection on steel surfaces and at the same time excellent adhesion to hot-dip galvanised steel parts. Coatings of GEHOPAL-L8-Metallgrund are resistant to temperatures up to a maximum of 80 °C.

GEHOPAL-L8-Metallgrund can be applied by brush, roller, high pressure/air spraying or airless-spraying and dries quickly. This means efficient working procedures.

■ PRODUCT DATA

Product number and colour
L8-750 grey
L8-812 red brown
L8-732 pepple grey approx. RAL 7032

Form of delivery
Ready for brush application

Shelf life
At least 12 months in original cans at normal temperature

Suitable thinner
For brush application: thinner V-89
For spray application: thinner V-74

Theoretical parameters

GEHOPAL-L8-Metallgrund, L8-812

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	VOC-content per 10 µm DFT* (g/m²)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.3	63	37	11.2	43	330

DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate (m²/kg)
80	185	0.244	4.1

Remarks
- All values are relevant fort he mixture in case of two-pack materials
- DFT: Dry film thickness
- All values named are approximate values and relevant fort he quality (colour). The values may differ slightly for other colours.

* baseline for calculation: consumption in g/m² at DFT 10 µm

D-76670 Graben-Neudorf PO-Box 1120 D- 76676 Graben-Neudorf Sofienstraße 36 Tel. +49 7255 99-0 Fax +49 7255 99-123
D-47005 Duisburg PO-Box 100529 D- 47249 Duisburg Obere Kaiserswerther Str. 18 Tel. +49 203 99707-0 Fax +49 203 99707-10

Coating systems

Substrate	Steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4	
	Product	**NDFT (µm)**
Primer coating	GEHOPAL-L8-Metallgrund	80
Top coating	GEHOPAL-L77 or GEHOPAL-L75	80 80

Substrate	Steel with hot-dip galvanising in accordance with EN ISO 1461	
Surface preparation	Cleaning in accordance with EN ISO 12944-4	
	Product	**NDFT (µm)**
Primer coating	GEHOPAL-L8-Metallgrund	80
Top coating	GEHOPAL-L77 or GEHOPAL-L75	80 80

The coating system/s named are examples proven in practice which usually can be modified. The choice of coating materials as well as their number and film thickness depends on the stress to be expected, existing specifications and the methods of application.

■ INSTRUCTIONS FOR APPLICATION

Surface Preparation

Steel surfaces:
Blast-cleaning in accordance with EN ISO 12944-4, surface preparation grade Sa 2 ½.

Hot-dip galvanised surfaces:
Dry and clean surfaces are essential for good adhesion of coating materials. Besides contaminants like grease, oil, dust, etc. especially zinc salts (zinc corrosion products) have to be removed totally.
Remark: Zinc salts are forming relatively quick and cannot - or hardly - be recognised at the beginning.

Air and surface temperature

Optimal results at temperatures of 15 to 25 °C, not below 5 °C

Relative humidity

Max. 80 % relative humidity

The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air throughout the application. (see basic specification for corrosion protection EN ISO 12944-7)

Comments on processing

Application methods

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 250 bar	80 to 100 µm	up to 2 % V-74
Roller coating / brush application	60 µm	up to 2 % V-89
In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.		

Remarks

- The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

Drying and curing times Related to a temperature of 20 °C and a dry film thickness of 80 µm

Dry to touch: after 20 minutes
Tack free: after approximately 1 hour
Ready for over-coating: after 6 hours with GEHOPAL-L75 or GEHOPAL-L77

■ SAFETY MEASURES

The relevant data concerning safety measures can be found in the material safety data sheet of this product.
The valid issue of the material safety data sheet is available from our website www.geholit-wiemer.de.