

MAIN PRODUCT-PROPERTIES

- High-grade, 2C-Epoxy High-Solid priming coat
- Nominal dry film thicknesses of 80 to 120 µm per working operation paintable
- Direct coating of new hot-dip galvanised surfaces without sweeping with excellent adhesion is possible even under high atmospheric stress

PRODUCT DATA

GEHOPON-C0034



C0034-850 Red brown
(other colours on request)



Mixing ratio by weight

7:1 with curing agent EX-40



Thinner V-74

GEHOPON-C0034 / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (mL/kg)	
	1.45	81.0	19.0	68.0	465
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	120	4.1	0.175	5.7

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

Low pressure

Roller/Brush application ⁴⁾

Nozzle diameter (mm)	0.33 to 0.43	2.5 to 3.0	-
Material pressure (bar)	150 to 250	20 to 30	-
Atomiser pressure (bar)	-	6.0 to 8.0	-
DFT * per working operation (µm)	80 to 120	80 to 120	60 to 80
Addition of thinner (%)	0 to 2	0 to 2	0 to 2

* DFT = Dry Film Thickness

4) recommended only for smaller areas, formation of a product-specific surface structure is possible

COMMENTS ON PROCESSING



Pot life

approx. 4 hours (relating on 20 to 25 °C)

Drying/Curing times at 80 µm DFT	Ambient air temperature		
	5 to 10°C	10 to 15°C	15 to 20°C
 dust-free:	after 4 hours	after 2 hours	after 1 hour
 tack-free:	after 24 to 48 hours	after 8 to 12 hours	After 4 to 6 hours
 overcoating interval / dry to handle:	after 3 to 4 days	after 2 days	after 1 day

The maximum waiting time until application of the top coat must not exceed 5 days, particularly in the case of natural weathering. Coated surfaces that should be recoated after waiting times > 5 days must be roughened by lightly oversweeping or grinding.

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)	
J ("Two-pack reactive performance coatings") Type SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Hot-dip galvanised steel surfaces

- Freshly hot-dip galvanised surfaces can be coated directly with GEHOPON-C0034. Assumptions are dry, clean surfaces without visible zinc reaction products (white rust, etc.)
- In the case of special loads for inaccessible areas and in the presence of visible zinc reaction products: Sweep blasting in accordance with EN ISO 12944-4. The surface must have a uniform dull appearance after surface preparation.



Air and surface temperature

≥ 10 °C



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

PAINT SYSTEMS

EXAMPLES

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)
	Protective coating	GEHOPON-C0034	80

SAFETY MEASURES



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

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