

GEHOPON-C200-INDUCTION-Primer

2C-EP Primer
according to ENERCON Specification MK 007

- **FIELDS OF APPLICATION** Two-pack epoxy-resin based coating for hard, durable as well as water and chemical resistant coatings on steel surfaces, e.g. shrunk-on-disc rotors, generators and lamination stacks of wind energy plants.
- **PRODUCT PROPERTIES** GEHOPON-C200-INDUCTION-Primer contains an epoxy resin binder with a special curing agent and is usually applied by airless spraying. A dry film thickness of approximately 50 µm can be achieved.
- Cured coatings are highly resistant to mechanical stresses as well as resistant to abrasion, compression, petrol and oil as to a large extent resistant to water, lye and solvents.

Temperature resistance:

Permanent stress (Test period 5000 hrs): 160 °C

Short-term stress / tempering: up to 180 °C (several hours)
e.g. during production process

■ **PRODUCT DATA** GEHOPON-C200-INDUCTION-Primer

Product number C200-884

Colour red brown

Mixing ration 4 : 1 parts by weight
with curing agent EX-84

Shelf life At least 6 months in original cans at normal temperature.

Suitable thinner Thinner V-74 or V-538
(also for cleaning of equipment)

Theoretical parameters GEHOPON-C200-INDUCTION-Primer, C200-884

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.5	81	19	4.3	67	447
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
50	74	0.112		8.9	

Remarks

- All values are relevant for the mixture in case of two-pack materials
 - DFT: Dry film thickness
 - All values named are approximate values and relevant for the quality (colour).
The values may differ slightly for other colours.
- * baseline for calculation: consumption in g/m² at DFT 10 µm

**Notes referring to
Directive 2004/42/EC
„Decoat-Directive“**

Subcategory as referred to in Annex IIA	VOC limit values (Phase II from 2010)	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
J ("Two-pack reactive performance coatings") Type SB	500 g/l	< 500 g/l

GEHOPON-C200-INDUCTION-Primer

■ **INSTRUCTIONS FOR APPLICATION**

Coating system
according to ENERCON-
Specification MK 007

Substrate	Steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 1/2 in accordance with EN ISO 12944-4	
	Product	NDFT (µm)
Primer coating	GEHOPON-C200-INDUCTION-Primer	50 (see specification)
Top coating	GEHODUR-C210-INDUCTION-Top resp. EP-Powder coatings *)	40 (see specification)

Remark

- *) Prior to serial application it is necessary to test suitability. Please feel free to ask for our technical advice if necessary.

Air and surface temperature

Optimal results at temperatures of 15 to 25 °C, not below 10 °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

Mixing

Mix with the enclosed quantity of curing agent, preferably with a mechanical mixer. Material must be stirred again after 10 minutes. Then the mixture is ready for use.

Application methods

Means of application / parameters	For a nominal dry film thickness of approx.	Addition of thinner V-74 or V-538
Airless spraying Nozzle diameter: 0.33 to 0.38 mm Material pressure: approx. 200 bar	50 µm	-
High pressure/air spraying Nozzle diameter: 1.0 to 1.5 mm Air pressure: 3 to 4 bar	50 µm	-
Roller coating / brush application	50 µm	-

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.

Cleaning of equipment

With thinner V-74 or V-538

Pot life 3.0 hours at 10 °C
1.5 hours at 20 °C
1.0 hour at 30 °C
0.5 hour at 40 °C

Drying and curing times

At a DFT of 50 to 80 µm and
an air and object temperature of

	10 °C	20 °C	30 °C	40 °C
Dry to touch (TG 1):	approx. 10 h	approx. 2 h	approx. 1 h	approx. 45 minutes
Tack free (TG 3):	approx. 20 h	approx. 6 h	approx. 3 h	approx. 2 h
Ready for over-coating (TG 6):	26 to 28 h	10 to 11 h	3.5 to 4.5 h	2 to 3 h

(TG = degree of drying in accordance with DIN 53150)

Additional information:

- Curing of GEHOPON-C200-INDUCTION-Primer can be accelerated by using higher temperatures, e.g. 30 minutes at 80 °C.
- waiting period until over-coating:
maximum 5 days at 20 °C,
afterwards only after a mechanical abrasive surface preparing
(sweep-blasting or grinding) and a subsequent cleaning

■ **SAFETY MEASURES**

The curing agent produces an alkaline reaction on skin and mucous membrane (eyes). Soiling must be avoided. In case of direct contact clean thoroughly with water and soap.

When application works are executed under bad ventilation conditions (closed rooms, mines etc.) it is necessary to provide for good airing and breathing masks in order to remove vapours which are being set free.

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.

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 of 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.