

MAIN PRODUCT PROPERTIES

- Listing and regular external control according to TL/TP-ING, Blatt 100
- High-grade, quick curing 2-pack EP high-solid zinc dust priming coat for steel buildings and steel constructions
- Nominal dry film thicknesses of 80 µm by spraying
- Maximum dry film thickness 160 µm
- Temperature resistance up to 160 °C long-term stress, 200 °C short-term stress

PRODUCT DATA

GEHOPON-E100R-Zink



Code no.: 100.1.1
E100R-790 Grey





Mixing ratio by weight

18:1 with curing agent EX-70



Thinner V-538

GEHOPON-E100R-Zink / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	2.6	95.0	5.0	86.0	330
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ¹⁾	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)
	80	93	1.2	0.240	4.1

1) Based on consumption in g/m² at DFT 10 µm

2) 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 ³⁾



Airmix



Roller/Brush application ⁴⁾




	Airless ³⁾	Airmix	Roller/Brush application ⁴⁾
Nozzle diameter (mm)	0.28 to 0.48	0.28 to 0.38	-
Material pressure (bar)	200 to 400	100 to 150	-
Atomiser pressure (bar)	-	2.0 to 3.0	-
DFT * per working operation (µm)	80	80	60
Addition of thinner (%)	1 to 2	1 to 2	0 to 2

3) high-performance airless recommended

4) recommended only for smaller areas

* DFT = Dry Film Thickness

 Pot life at	5 °C	15 °C	30 °C
	4 hours	2 hours	1 hour

Drying/curing times at 80 µm DFT		Ambient air temperature		
		5 °C	15 °C	30 °C
	dust-free:	after approx. 2 hours	after approx. 1.5 hours	after approx. 1 hour
	tack-free:	after approx. 6 hours	after approx. 3.5 hours	after approx. 1.5 hours
	overcoating interval / dry to handle	after approx. 8 hours	after approx. 5 hours	after approx. 2.5 hours

Notes referring to Directive 2004/42/EC "Decopaint-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 Lb	500 g/l	< 500 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

	Air and surface temperatures ≥ 5 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C

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

PAINT SYSTEMS

EXAMPLES

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

	Product(s) (other paint systems on request)	NDFT (µm)
Priming coat	GEHOPON-E100R-Zink	80
1. Intermediate coat	GEHOPON-E100R-ZB	160
2. Intermediate coat	WIEREGEN-M100R-ZB	80
Top coats	WIEREGEN-M100 WIEREGEN-M101R	80
Optional clear coat	WIEREGEN-M100-Klarlack	30

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

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.