





MAIN PRODUCT PROPERTIES

- Listing and regular external control according to TL/TP-ING, Blatt 100
- High-grade 2-pack epoxy high-solid intermediate coat
- Nominal dry film thicknesses of 100 to 160 µm per working operation can be achieved by spraying
- Coating of freshly hot-dip galvanised, sweep-blasted surfaces with excellent adhesion is possible even under high atmospheric stress

PRODUCT DATA

GEHOPON-E103-Protect	MIO colours
 <p>Code no. 100.2.3 E103-7602 Grey DB 702 E103-7603 Grey DB 703 E103-6601 Green DB 601</p>	(other colours on request)
 <p>Mixing ratio by weight 9:1 with curing agent EX-40</p>	
 <p>Thinner V-568</p>	

GEHOPON-E103-Protect / Guide values ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.45	79	21	65	450
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m² ²⁾)	Consumption (kg/m² ³⁾)	Spreading rate (m²/kg)
	160	250	4.8	0.360	2.8

1) Guide values averaged data, slight deviations 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

Airmix

Roller/Brush application ⁴⁾

Nozzle diameter (mm)	0.38 to 0.74	0.38 to 0.48	-
Material pressure (bar)	200 to 300	150 to 250	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	100 to 160	100 to 160	60 to 80
Addition of thinner (%)	0 to 5	0 to 5	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 at

10 °C

15 °C

30 °C

6 hours

4 hours

3 hours

Drying/Curing times at 160 µm DFT

Ambient air temperature

10 °C

15 °C

30 °C



dust-free:

after ≤ 10
hours

after ≤ 7
hours

after ≤ 3
hours



tack-free:

after 48 to
72 hours

after 16 to
24 hours

after 8 to
10 hours



dry to handle:

after ≤ 5
days

after ≤ 24
hours

after ≤ 16
hours

overcoating interval:

after
approx.
48 hours

after
approx.
24 hours

after
approx.
16 hours

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 are to 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
(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

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products using suitable measures
- At natural weathering or condensation load of coated, hot-dip galvanised steel parts, and within the application area of ZTV-ING, Sheet 100, sweep-blast cleaning in accordance with EN ISO 12944-4 is required. The surface must have a uniformly dull appearance after surface preparation.



Air and surface temperatures
≥ 10 °C




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

PAINT SYSTEMS

EXAMPLES

Substrate: Hot-dip galvanised steel in accordance with EN ISO 1461
Surface preparation: sweep-blast cleaning in accordance with EN ISO 12944-4

	Systems according to TL/TP-ING, Sheet 100	Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coat	GEHOPON-E103-Protect	160
	Top coat	WIEREGEN-M100 WIEREGEN-M101R	80
	Optional clear coat	WIEREGEN-M100-Klarlack	30

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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