

MAIN PRODUCT-PROPERTIES

- In accordance with ZTV-ING part 7, section 5 (ZTV-RHD-ST) and is subject to regular external control
- High-grade, multi-purpose applicable 2-pack EP Priming coat for steel buildings and steel constructions
- Excellent adhesion on steel and hot dip galvanised steel
- Nominal dry film thicknesses of 80 to 100 µm by spraying, of approx. 60 µm by brush application or roller coating

PRODUCT DATA

GEHOPON-E24-Metallgrund



E24-102 Sand yellow approx. RAL 1002
E24-812 Redbrown approx. RAL 8012
(other colours on request)





Mixing ratio by weight
8:1 with curing agent EX-4



Thinner V-538

GEHOPON-E24-Metallgrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.55	74.0	26.0	54.0	350
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	148	7.5	0.230	4.4

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







High pressure



Roller/Brush application

Nozzle diameter (mm)	0.33 to 0.58	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 100	80 to 100	40 to 60
Addition of thinner (%)	0 to 3	5 to 10	0 to 1
 Pot life at	10 °C	20 °C	30 °C
	8 hours	6 hours	4 hours

* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT	Ambient air temperature		
	7 °C	23 °C	30 °C
 dust-free:	after ≤ 2 hours	after ≤ 1 hour	after approx. 30 minutes
 Tack-free:	after ≤ 12 hours	after ≤ 6 hours	after ≤ 3 hours
 dry to handle:	after ≤ 20 hours	after ≤ 10 hours	after ≤ 6 hours
	10 °C	20 °C	30 °C
 overcoating interval	after approx. 15 hours	after approx. 10 hours	after approx. 6 hours

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

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products by suitable methods
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steel parts: Sweep blasting in accordance with EN ISO 12944-4. The surface must have a uniform dull appearance after surface preparation.

Existing primer coats - or old coats

- Remove adhesion-reducing substances, e. g. cleaning, washing



Air and surface temperature

≥ 10 °C




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

Further details for processing and execution is 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-E24-Metallgrund	80
	Intermediate coats	GEHOPON-E87-ZB WIEREGEN-M87-ZB In 1 or 2 working operations	80 to 160
	Top coats	WIEREGEN-M87 WIEREGEN-M25 WIEREGEN-D80-Compact	80 80 2 to 10 mm

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, Sweep blast-cleaning in accordance with EN ISO 12944-4, e. g. with mixed constructions

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coat	GEHOPON-E24-Metallgrund	80
	Optional Intermediate coats	GEHOPON-E87-ZB WIEREGEN-M87-ZB	80
	Top coat	WIEREGEN-M87	80

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.geholti-wierner.de.

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