

MAIN PRODUCT-PROPERTIES

- In coating systems with WIEREGEN-M42A as high-grade electrical conductive coating system according to TRBS 2153
- The requirements for electrical surface resistances according to EN 60079-0, chapter 26.13 are met in the system
- Ground conductivity according to EN 1081: $R_2=10^4$ to $10^6 \Omega$
- Application areas: ATEX and special machines for avoiding electrostatic charging

PRODUCT DATA

GEHOPON-E41A-Metallgrund, mat



E41A-750 Dark grey (other colours on request)



Mixing ratio by weight
7:1 with curing agent EX-4



Thinner V-538

GEHOPON-E41A-Metallgrund / Guideline

7 8 9 + 4 5 6 X 1 2 3 = 0 . /	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
		1.25	59.0	41.0	41.0
	DFT * (μ m)	Calculated wet-film thickness (μ m)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	60	146	0.180	5.5	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application




Application viscosity (s) (8 mm DIN-cup)	10 to 15	6 to 8	10 to 20
Nozzle diameter (mm)	0.33 to 0.43	1.5 to 2.0	-
Material pressure (bar)	150 to 200	-	-
Atomiser pressure (bar)	1.5 to 2.5	3.0 to 4.0	-
DFT * per working operation (μm)	60 to 80	60 to 80	40 to 60
Addition of thinner (%)	2 to 5	10 to 15	0 to 5



Pot life

6 to 8 hours (relating to 20 to 25 °C)

* DFT = Dry Film Thickness

Drying/Curing times at 60 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 30 minutes
	tack free:	after 4 to 5 hours
	ready for overcoating/handling:	after 12 to 16 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 1/2 according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

Hot-dip-galvanised steel surfaces and aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation: Sweep blast-cleaning according to EN ISO 12944-4. After sweep blast-cleaning the surface shall have a uniform dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



Air and surface temperature

optimal at 15 to 25 °C, not below 5 °C, not over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	GEHOPON-E41A-Metallgrund
	Monolayer	WIEREGEN-M42A

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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