

MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Overcoatable/ready for packaging after 3 hours hardening at 20 °C
- Sprayable adjustment for nominal dry film thickness 50 µm

PRODUCT DATA

GEHOPON-E44R-Metallgrund



E44R-102 Sand yellow approx. RAL 1002
E44R-735 Light grey approx. RAL 7035 (other colours on request)



Mixing ratio by weight

9:1 with curing agent EX-44R



Thinner V-538

GEHOPON-E44R-Metallgrund / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.30	66.0	34.0	(%)	(mL/kg)
				50.0	385
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	50	100	0.130	7.7	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application




Application viscosity (s) (4 mm DIN-cup)	25 to 30	25 to 30	-
Nozzle diameter (mm)	0.18 to 0.28	1.3 to 1.6	-
Material pressure (bar)	60 to 90	-	-
Atomiser pressure (bar)	1.5 to 2.5	3.0 to 4.0	-
DFT * per working operation (µm)	40 to 60	40 to 60	-
Addition of thinner (%)	-	-	-



Pot life

1.5 hours (relating to 20 °C)

* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 20 minutes
	tack free:	after 1.5 to 2.0 hours
	ready for overcoating/handling:	after 3.0 to 3.5 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 0 °C, not over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	GEHOPON-E44R-Metallgrund
	Monolayer / Top coat	WIEREGEN-D54R or WIEREGEN-D154R WIEREGEN-M163 WIEREGEN-M26

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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