

2C-EP Primer, quick curing

MAIN PRODUCT- PROPERTIES	 Fast curing protective coating for industrial areas with excellent adhesion on multisubstrate surfaces Overcoatable/ready for packaging after approx. 5 hours hardening at 20 °C Good hardening also at low temperatures, minimum 0 °C Sprayable adjustment for nominal dry film thickness from 100 to 120 μm 					
PRODUCT DATA GEHOPON-E46R-Metallgrund						
		E46R-732 Pepple grey approx. RAL 7032 (other colours on request)				
	A:B	-	tio by weight uring agent EX-46R	by volume 7.6:1 with curi	ing agent EX-46R	
		Thinner V-538				
GEHOPON-E46R-Metallgrund / Guideline						
	GENUP		Ū			
789 450 123 0	789÷	Density (g/mL) 1.45	Solid content (weight %) 76.0	VOC-content (weight %) 24.0	Solid content by volume (%) (mL//kg) 60.0 410	
	123+ 0,=	DFT * (µm) 100	Calculated wet-film thickness (μm) 168	Consumption (kg/m ²) 0.245	Spreading rate (m²/kg) 4.1	
COMMENTS ON	_					

COMMENTS ON PROCESSING

Recommendation at	
temperatures	
of approx. 20 °C	

TECHNICAL INFORMATION

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Industrial Coatings

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Airmix /



High

Roller/Brush

	Airless	pressure	application
Application viscosity (s) (8 mm DIN-cup)	8 to 10	6 to 10	8 to 10
Nozzle diameter (mm)	0.33 to 0.43	1.3 to 1.8	-
Material pressure (bar)	125 to 250	-	
Atomiser pressure (bar)	2.0 to 4.0	2.0 to 4.0	-
DFT * per working operation (μm)	70 to 90	70 to 90	40 to 60
Addition of thinner (%)	0 to 3	4 to 6	0 to 2



Pot life

1.5 hours (relating to 20 °C)

* DFT = Dry Film Thickness

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GEHOPON-E46R-Metallgrund

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Drying/Curing times at 100 µm DFT	Ambient air temperature 20 °C		
touch dry:	after 30 to 40 minutes		
tack free:	after 2.5 to 3.0 hours		
ready for overcoating/handling:	after 4.5 to 5.0 hours		

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
 Blast-cleaning Sa 2 ½ according to EN ISO 12944-4,
 - Roughness grade medium (G) according to EN ISO 8503-1

Hot-dip-galvanised steel resp. Strip-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)

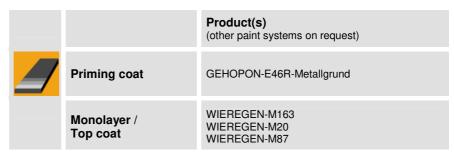


Air and surface temperature optimal at 15 to 25 °C, not below 0 °C, not over 40 °C

max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES



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.

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