

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 Peppel grey approx. RAL 7032 (other colours on request)



Mixing ratio by weight

12:1 with curing agent EX-46R

by volume

7.6:1 with curing agent EX-46R



Thinner V-538

GEHOPON-E46R-Metallgrund / Guideline

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
			(%)	(mL/kg)
1.45	76.0	24.0	60.0	410
DFT* (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
100	168	0.245	4.1	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix /
Airless



High
pressure



Roller/Brush
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

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

		Product(s) (other paint systems on request)
	Priming coat	GEHOPON-E46R-Metallgrund
	Monolayer / Top coat	WIEREGEN-M163 WIEREGEN-M20 WIEREGEN-M87

SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at www.geholti-wierner.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.