

## MAIN PRODUCT-PROPERTIES

- High-grade, multi-purpose, surface tolerant priming coat
- Excellent adhesion on miscellaneous surfaces, especially aluminium, stainless steel and hot dip galvanised steel
- Nominal dry film thicknesses of 80 to 150 µm by spraying, of approx. 70 µm by brush application or roller coating

## PRODUCT DATA

### GEHOPON-E5-Korrogrund



E5-732 Pepple grey approx. RAL 7032  
E5-750 Light grey  
E5-812 Brown  
(other colours on request)



#### Mixing ratio by weight

9:1 with curing agent EX-40



Thinner V-568

### GEHOPON-E5-Korrogrund / Guideline <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	(mL/kg)
	1.4	79.5	20.5	65.5	455
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	80	122	4.4	0.175	5.7
	150	229	4.4	0.330	3.0

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m<sup>2</sup> 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



Airmix



Roller/Brush  
application <sup>4)</sup>

Nozzle diameter (mm)	0.38 to 0.68	0.38 to 0.53	-
Material pressure (bar)	200 to 300	150 to 250	-
Atomiser pressure (bar)	-	3.0 to 5.0	-
DFT * per working operation (µm)	80 to 150	80 to 150	60 to 80
Addition of thinner (%)	2 to 4	2 to 4	0 to 2

\* DFT = Dry Film Thickness

4) recommended only for smaller areas,  
formation of a product-specific surface structure is possible

## COMMENTS ON PROCESSING



### Pot life

up to 4 hours (depending on temperature)

Drying/Curing times at 160 µm DFT	Ambient air temperature		
	5 to 10°C	10 to 15°C	15 to 20°C
dust-free:	after 4 hours	after 2 hours	after 1 hour
Tack-free:	after 24 to 48 hours	after 12 to 16 hours	after 6 to 8 hours
overcoating interval / dry to handle:	after 3 to 4 days	after 2 days	after 1 day

The maximum waiting time until application of the top coat must not exceed 5 days, particularly in the case of natural weathering. Coated surfaces that should be recoated after waiting times > 5 days must be roughened by lightly oversweeping or grinding.

### 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 1/2 according to EN ISO 12944-4 alternatively
- Mechanical or manual derusting in preparation grade St 2 according to EN ISO 12944-4

#### Hot-dip galvanised steel surfaces

- New hot-dip galvanised surfaces can be coated directly with GEHOPON-E5-Korrogrund. Assumptions are dry, clean surfaces without visible zinc reaction products (white rust, etc.)
- In the case of special loads for inaccessible areas and in the presence of visible zinc reaction products: 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 and if applicable
- Mechanical or manual derusting in preparation grade PMA respectively PSt 2 according to EN ISO 12944-4
- If applicable additional spotting

#### Aluminium and stainless steel

- Remove adhesion-reducing substances, e. g. cleaning, washing, chemical conversion layers alternatively
- Sweep blast-cleaning according to EN ISO 12944-4. The surface must have a uniform dull appearance after surface preparation.
- Before serial coatings adhesion test are recommended



**Air and surface temperature**  
≥ 10 °C




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

## PAINT SYSTEMS

### EXAMPLES

**Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Priming coat</b>	GEHOPON-E5-Korrogrund	80 to 150
	<b>Intermediate coats</b>	GEHOPON-E5-Protect GEHOPON-E87-ZB WIEREGEN-M87-ZB GEHOPON-E94-ZB	80 to 160 80 80 80 to 160
	<b>Top coats</b>	WIEREGEN-M25 WIEREGEN-M87 WIEREGEN-M94 GEHOTEX-W92	80

**Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, cleaning in accordance with EN ISO 12944-4**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Intermediate coat</b>	GEHOPON-E5-Korrogrund	80 to 150
	<b>Top coats</b>	WIEREGEN-M25 WIEREGEN-M87 WIEREGEN-M94 WIEREGEN-W92	80

## SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at [www.geholit-wiemer.de](http://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.