

MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-ING, Blatt 50 and is subject to regular external control
- High-grade high-solid Priming coat based on epoxy resin for interior coating of partly walkable, airtight welded box girders of bridges
- Dry film thickness 100 µm per working operation by airless spraying
- Suitable for prepared weldings and also for repairing of transport and erection damages
- Excellent chemical and mechanical resistance

PRODUCT DATA

GEHOPON-E50R-Metallgrund



E50R-102 sand yellow approx. RAL 1002
code number 650.02




Mixing ratio by weight

6:1 with curing agent EX-70



Thinner V-74

GEHOPON-E50R-Metallgrund / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.7	92.0	8.0	85.0	500
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ¹⁾	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)
	100	190	1.6	0.205	4.9

1) Based on consumption in g/m² at DFT 10 µm

2) 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






Roller/Brush application³⁾

Nozzle diameter (mm)	0.38 to 0.74	-
Material pressure (bar)	300 to 400	-
Atomiser pressure (bar)	-	-
DFT * per working operation (µm)	100	60 to 80
Addition of thinner (%)	0 to 4	0 to 4

* DFT = Dry Film Thickness

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

	Pot life at	5 °C	15 °C	30 °C
		4 hours	2 hours	1 hour

Drying/Curing times at 100 µm DFT	Ambient air temperature		
	5 °C	15 °C	30 °C
 dust-free:	after approx. 2 hours	after approx. 1.5 hours	after approx. 1 hour
 tack-free:	after approx. 8 hours	after approx. 5 hours	after approx. 3 hours
 overcoating interval / dry to handle	after approx. 10 hours	after approx. 6 hours	after approx. 4 hours

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 respectively Psa 2 according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

	Air and surface temperature ≥ 5 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C

Further details for processing and execution is described in the relevant applicable instructions

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 in accordance with EN ISO 12944-4, medium (G)

		Product(s) (other paint systems on request)	NDFT (μm)
	Priming coat	GEHOPON-E50R-Metallgrund	100
	Top coat	WIEREGEN-M50R	100

SAFETY MEASURES



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

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