

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
- Excellent applicable for the renovation of steel buildings and mixed constructions, also on manual derusted steel and old coatings
- Nominal dry film thicknesses of 80 to 160 µm by spraying, of approx. 80 µm by brush application or roller coating

PRODUCT DATA

GEHOPON-E60-Korrogrund



E60-732 Pepple grey approx. RAL 7032
E60-735 Light grey approx. RAL 7035
E60-812 Brown approx. RAL 8012
(other colours on request)



Mixing ratio by weight

8:1 with curing agent EX-40



Thinner V-568

GEHOPON-E60-Korrogrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.5	83.0	17.0	69.5	465
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	100	144	3.7	0.215	4.6
	160	230	3.7	0.345	2.9

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

2) Based on consumption in g/m² 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 ⁴⁾

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 160	80 to 160	60 to 80
Addition of thinner (%)	2 to 4	2 to 4	-

* 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

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 ½ 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-E60-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

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coat	GEHOPON-E60-Korrogrund	80 to 160
	Intermediate coats	GEHOPON-E87-ZB WIEREGEN-M87-ZB GEHOPON-E94-ZB	80 80 80 to 160
	Top coats	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

		Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coat	GEHOPON-E60-Korrogrund	80 to 160
	Top coats	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.geholti-wiemer.de.

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