

MAIN PRODUCT- PROPERTIES

- High-grade, multi-purpose applicable, surface tolerant priming coat
- Excellent adhesion on multi substrate surfaces and old coatings
- Direct coating of freshly hot-dip galvanized surfaces without sweeping with excellent adhesion is possible even with high atmospheric loads
- High dry film thicknesses up to 160 µm in one working step is possible

PRODUCT DATA

GEHOPON-E60-MP-Grund



E60-750 (RAL-colours, other colours on request)




Mixing ratio by weight

8:1 with curing agent EX-40



Thinner V-568

GEHOPON-E60-MP-Grund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.45	83.0	17.0	71.0	490
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	112	3.5	0.165	6.1

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

High
pressure

Roller/Brush
application ⁴⁾

Nozzle diameter (mm)	0.38 to 0.68	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	2.5 to 3.5	3.0 to 5.0	-
DFT * per working operation (µm)	80 to 160	80 to 120	60 to 80
Addition of thinner (%)	2 to 4	10 to 15	-






Pot life

up to 4 hours (relating to temperature)

* DFT = Dry Film Thickness

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

Drying/Curing times at 160 µm DFT	Ambient air temperature		
	5 to 10 °C	10 to 15 °C	15 to 20 °C
 touch dry:	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
 ready for overcoating/handling:	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 and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating, alternatively
- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1, alternatively
- Hand or power-tool cleaning in preparation grade St 3 according to EN ISO 12944-4

Aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4. After sweep blast-cleaning the surface shall have a uniform dull appearance, alternatively
- Chemical conversion layer (chromate, phosphating)

Hot-dip galvanised steel surfaces

- Freshly hot-dip galvanized surfaces can be coated directly with GEHOPON-E60-MP-Grund. Required are dry, clean surfaces without visible zinc reaction products (white rust, etc.)
- With special stress for inaccessible areas and existant visible zinc reaction products: Sweep blast-cleaning according to EN ISO 12944-4. After sweep blast-cleaning the surface shall have a uniform dull appearance.

Existing priming coats or old coatings

- Remove adhesion-reducing substances e. g. cleaning, washing
- Before overcoating of unknown priming coats compatibility tests 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-MP-Grund	80 to 160
	Intermediate coats	GEHOPON-E87-ZB GEHOPON-M87-ZB GEHOPON-E94-ZB	80 80 80 to 160
	Top coats	WIEREGEN-M25 WIEREGEN-M87 WIEREGEN-M165R	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-MP-Grund	80 to 160
	Top coats	WIEREGEN-M25 WIEREGEN-M87 WIEREGEN-M165R GEHOTEX-W92	80

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.