






MAIN PRODUCT- PROPERTIES

- High-grade, flat High-solid Monolayer based on epoxy resin with excellent corrosion protection properties especially for interior coating
- Suitable in coating system e. g. with WIEREGEN-M87 for corrosivity category C4 to C5
- With dry film thicknesses from 100 to 160 µm suitable for corrosivity categorie C1, C2 and C3 high durability
- Excellent chemical and mechanical resistance

PRODUCT DATA

| GEHOPON-E63, GEHOPON-E63-Aluminium | RAL-colours, flat |
|---|--|
|  | E63-F.... (RAL-colours, other colours on request) E63-F7701 Aluminium |
|  | Mixing ratio by weight 6:1 with curing agent EX-91S |
|  | Thinner V-538 |

| GEHOPON-E63 | Guideline RAL-colours ¹⁾ | | | | |
|---|-------------------------------------|---|--|---|--|
|  | Density (g/mL) 1.6 | Solid content (weight %) 82.0 | VOC-content (weight %) 18.0 | Solid content by volume (%) (mL/kg) 68.0 425 | |
| | DFT * (µm) 100 | Calculated wet-film thickness (µm) 145 | VOC-content (g/m ²) ¹⁾ 4.2 | Consumption (kg/m ²) ²⁾ 0.235 | Spreading rate (m ² /kg) 4.3 |

| GEHOPON-E63-Aluminium | Guideline RAL-colours ¹⁾ | | | | |
|---|-------------------------------------|---|--|---|--|
|  | Density (g/mL) 1.45 | Solid content (weight %) 76.5 | VOC-content (weight %) 23.5 | Solid content by volume (%) (mL/kg) 60.5 415 | |
| | DFT * (µm) 100 | Calculated wet-film thickness (µm) 166 | VOC-content (g/m ²) ²⁾ 5.6 | Consumption (kg/m ²) ³⁾ 0.240 | Spreading rate (m ² /kg) 4.2 |

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 0.74 | 0.34 to 0.69 | - |
| Material pressure (bar) | 150 to 350 | 100 to 150 | - |
| Atomiser pressure (bar) | - | 2.0 to 2.5 | - |
| DFT * per working operation (µm) | 100 to 160 | 100 to 160 | 60 to 80 |
| Addition of thinner (%) | 0 to 4 | 0 to 4 | 0 to 2 |

* DFT = Dry Film Thickness

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



Pot life at

20 °C

6 to 8 hours

Drying/Curing times at 160 µm DFT

Ambient air temperature

20 °C



dust-free:

after approx. 30 minutes



tack-free:

after approx. 3 to 4 hours



overcoating interval / dry to
handle

after approx. 8 to 10 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

- Mechanical or manual derusting in preparation grade PMA respectively St 3 according to EN ISO 12944-4

Existing coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of old coatings 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) |
|---|-------------------------------|---|--------------|
|  | Monolayer | GEHOPON-E63 GEHOPON-E63-Aluminium | 100 to 160 |
| | Optional Top coats | WIEREGEN-M87 WIEREGEN-M97R WIEREGEN-M165R | 80 |

Substrate: steel, mechanical or manual derusting PMA/St3 if applicable with old coating

| | | Product(s) (other paint systems on request) | NDFT (µm) |
|---|--|---|------------|
|  | Monolayer | GEHOPON-E63-Aluminium | 100 to 160 |
| | Optional Intermediate coats | GEHOPON-E63 GEHOPON-E63-Aluminium | 80 |
| | Optional Top coats | WIEREGEN-M87 WIEREGEN-M97R WIEREGEN-M165R | 80 |

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES



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

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