





MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR-Stahlbauten, Blatt 87 and is subject to regular external control
- High-grade, multi-purpose 2C-Epoxy Intermediate coat for steelbuildings and -constructions
- Excellent adhesion directly on hot-dip galvanised steel
- Nominal dry film thicknesses of 80 to 100 µm by spraying, of approx. 60 µm by brush or roller coating

PRODUCT DATA

GEHOPON-E87-ZB	MIO-colours
 E87-7602 Grey DB 702 E87-7603 Grey DB 703 E87-6601 Green DB 601	code number 687.12 code number 687.13 code number 687.14
 Mixing ratio by weight 15:1 with curing agent EX-74	
 Thinner V-538	

GEHOPON-E87-ZB	Guideline MIO-colours ¹⁾				
	Density (g/mL) 1.75	Solid content (weight %) 82.0	VOC-content (weight %) 18.0	Solid content by volume (mL/kg) 360	
	DFT * (µm) 80	Calculated wet-film thickness (µm) 127	VOC-content (g/m ²) ²⁾ 5.0	Consumption (kg/m ²) ³⁾ 0.220	Spreading rate (m ² /kg) 4.5

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	High pressure	Roller/Brush application
Nozzle diameter (mm)	0.33 to 0.58	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 100	80 to 100	40 to 60
Addition of thinner (%)	0 to 5	5 to 10	0 to 2
 Pot life at	10 °C	20 °C	30 °C
	8 hours	6 hours	4 hours

* DFT = Dry film thickness

Drying/Curing times at 80 µm DFT	Ambient air temperature		
	7°C	23°C	30°C
 dust-free:	after ≤ 2 hours	after ≤ 1 hour	after approx. 30 minutes
 tack-free:	after ≤ 12 hours	after ≤ 6 hours	after ≤ 3 hours
 dry to handle:	after ≤ 20 hours	after ≤ 10 hours	after ≤ 6 hours
 overcoating interval:	10°C	20°C	30°C
	after approx. 15 hours	after approx. 10 hours	after approx. 6 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

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products through suitable measures
- At natural weathering or condensation of coated, hot-dip galvanised steel parts and in application range of ZTV-ING:
Sweep blast-cleaning according to EN ISO 12944-4 required.
The surface must have a uniform dull appearance after surface preparation.

Existing Priming coat or old coating

- Remove adhesion-reducing substances, e. g. cleaning, washing



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 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coats	GEHOPON-E87-Zink GEHOPON-E87-Metallgrund	70 to 80 80
	Intermediate coats	GEHOPON-E87-ZB WIEREGEN-M87-ZB In 1 to 2 working operations	80 to 160
	Top coat	WIEREGEN-M87	80

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

		Product(s) (other paint systems on request)	NDFT (µm)
	Optional Intermediate coat	GEHOPON-E87-ZB	80
	Top coat	WIEREGEN-M87	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-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.