

## MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR-Stahlbauten, Blatt 87 and is subject to regular external control
- High-grade, 2-pack Epoxy Priming coat for steel buildings and steel constructions
- Nominal dry film thicknesses of 60 to 80  $\mu\text{m}$  by spraying
- Maximum dry film thickness 150  $\mu\text{m}$
- Temperature resistance up to 160  $^{\circ}\text{C}$  long term stress, 200  $^{\circ}\text{C}$  short term stress

## PRODUCT DATA

### GEHOPON-E87-Zink



E87-790 Grey	code number 687.03
E87-390 Red pigmented	code number 687.04
E87-690 Green pigmented	code number 687.05





#### Mixing ratio by weight

15:1 with curing agent EX-34



Thinner V-538

### GEHOPON-E87-Zink / Guideline <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
		<b>2.5</b>	<b>85.0</b>	<b>15.0</b>	<b>56.0</b>
	DFT * ( $\mu\text{m}$ )	Calculated wet-film thickness ( $\mu\text{m}$ )	VOC-content ( $\text{g}/\text{m}^2$ ) <sup>2)</sup>	Consumption ( $\text{kg}/\text{m}^2$ ) <sup>3)</sup>	Spreading rate ( $\text{m}^2/\text{kg}$ )
		<b>80</b>	<b>143</b>	<b>6.7</b>	<b>0.355</b>

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

2) Based on consumption in  $\text{g}/\text{m}^2$  at DFT 10  $\mu\text{m}$

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 $^{\circ}\text{C}$



Airless



High pressure







Roller/Brush application <sup>4)</sup>

	Airless	High pressure	Roller/Brush application <sup>4)</sup>
Nozzle diameter (mm)	0.33 to 0.58	1.5 to 2.0	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	-	4.0 to 5.0	-
DFT * per working operation ( $\mu\text{m}$ )	60 to 80	60 to 80	40 to 60
Addition of thinner (%)	0 to 2	0 to 5	0 to 1

4) only recommended for smaller areas

\* DFT = Dry film thickness

	<b>Pot life at</b>	<b>10 °C</b>	<b>20 °C</b>	<b>30 °C</b>
		9 hours	8 hours	6 hours

Drying/Curing times at 80 µm DFT Relative humidity 60 to 80 %		Ambient air temperature		
		5 °C	15 °C	30 °C
	dust-free:	after approx. 60 minutes	after approx. 30 minutes	after approx. 30 minutes
	tack-free:	after approx. 75 minutes	after approx. 45 minutes	after approx. 45 minutes
	dry to handle:	≤ 2 hours	≤ 1 hour	≤ 1 hour
	overcoating interval:	<b>10 °C</b>	<b>20 °C</b>	<b>30 °C</b>
		after approx. 10 hours	after approx. 5 hours	after approx. 2 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 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1


	<b>Air and surface temperature</b> ≥ 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**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> (µm)
	<b>Priming coat</b>	GEHOPON-E87-Zink	70 to 80
	<b>Intermediate coats</b>	GEHOPON-E87-ZB WIEREGEN-M87-ZB In 1 to 2 working operations	80 to 160
	<b>Top coat</b>	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-wierner.de](http://www.geholit-wierner.de).

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