

MAIN PRODUCT PROPERTIES

- Listing and regular external control according to TL/TP-ING, Sheet 90
- High-grade 2-pack epoxy high-solid intermediate coat
- Nominal dry film thicknesses of 100 to 160 µm per work step by spraying
- Direct coating of freshly hot-dip galvanised surfaces without sweeping is possible, with excellent adhesion, even under high atmospheric stress

PRODUCT DATA

GEHOPON-E9-Protect



E9-... MIO (micaceous iron oxide) colour shades code number 690.30 – 74
E9-... RAL colours code number 690.75 – 99
(colours according to Annex D - TL KOR-Stahlbauten)



Mixing ratio by weight

9:1 with curing agent EX-40



Thinner V-568

GEHOPON-E9-Protect / Guide values ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC content (weight %)	Solid content by volume	
	1.45	78	22	(%)	(mL/kg)
				63	435
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	125	5	0.185	5.4
	120	188	5	0.275	3.6
	160	250	5	0.370	2.7

1) Guide value averaged data, slight deviations are possible depending on the colour shade.

2) Based on consumption in g/m² at DFT 10 µm

3) Theoretical consumption based on a smooth surface. Dependent on surface roughness and processing losses, different consumption data will be achieved in practice.

PROCESSING INSTRUCTIONS

Recommendation at temperatures of approx. 20 °C



Airless



Airmix




Roller/Brush application ⁴⁾





Nozzle diameter (mm)	0.38 to 0.74	0.38 to 0.48	-
Material pressure (bar)	200 to 300	150 to 250	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	100 to 160	100 to 160	60 to 80
Addition of thinner (%)	0 to 5	0 to 5	0 to 2

* DFT = Dry Film Thickness

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

PROCESSING INSTRUCTIONS

	Pot life at	10 °C	20 °C	30 °C
		6 hours	4 hours	3 hours

Drying/Curing times at 120 µm DFT	Ambient air temperature		
	10 °C	20 °C	30 °C
 dust-free:	after ≤ 7 hours	after ≤ 5 hours	after ≤ 2 hours
 tack-free:	after 24 to 48 hours	after 12 to 16 hours	after 6 to 8 hours
 dry to handle:	after ≤ 5 days	after ≤ 24 hours	after ≤ 16 hours
 overcoating interval:	after approx. 24 hours	after approx. 16 hours	after approx. 12 hours

The maximum waiting time until application of the top coat must not exceed 5 days, particularly in the case of natural weathering. Coated surfaces that are to be recoated after waiting times > 5 days must be roughened by light oversweeping or grinding.

Information according to 2004/42/EC „Decopaint Directive“

Subcategory as referred to in Annex IIA	VOC limit value	max. VOC content of the product in its ready-for-use condition (including the max. amount of diluent as given in "Application methods")
	(Phase II from 2010)	
J (two-pack reactive performance coatings) type Lb	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Hot-dip galvanised steel surfaces

- Freshly hot-dip galvanised surfaces may be coated directly with GEHOPON-E9-Protect. Dry, clean surfaces without visible zinc reaction products (white rust etc.) are required.
- If there are visible zinc reaction products, sweep blasting in accordance with EN ISO 12944-4 is required. The surface must have a uniformly dull appearance after surface preparation.



Air and surface temperature
≥ 10 °C




relative humidity ≤ 80 %
dew point distance ≥ 3 °C


PAINT SYSTEMS

EXAMPLES

Substrate: steel, clean-blasted 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-E97R-Zink	70 to 80
	Intermediate coat	GEHOPON-E9-Protect	100 to 160
	Top coats	WIEREGEN-M87 GEHOTEX-W92	80

Substrate: hot-dip galvanised steel according to EN ISO 1461

	Systems according to TL/TP-ING, Sheet 90	Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coat	System 1: GEHOPON-E9-Protect System 2: GEHOPON-E9-Protect	80 120
	Top coats	System 1: WIEREGEN-M87 System 2: GEHOPON-E9-Protect	80 120

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.