

MAIN PRODUCT-PROPERTIES

- High-grade high-solid Priming coat with excellent corrosion protection properties
- In coating systems e. g. with WIEREGEN-M165R suitable for corrosivity categories C3 to C5
- Confirmation of suitability by Fraunhofer Institut IFAM, Bremen, for a system up to corrosivity category C5 very high durability and CX Offshore, report: KT-PB-113, A416290-2
- Excellent chemical and mechanical resistance
- Nominal dry film thicknesses of 80 to 160 µm per working operation are paintable

PRODUCT DATA

GEHOPON-E90R-Metallgrund



E90R-102 Sand yellow
E90R-812 Red brown
(other colours on request)



Mixing ratio by weight
6:1 with curing agent EX-70



Thinner V-74

GEHOPON-E90R-Metallgrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	(mL/kg)
	1.70	92.0	8.0	85.0	500
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	95	1.6	0.165	6.2
	160	190	1.6	0.330	3.1

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






Roller/Brush
application ⁴⁾

Nozzle diameter (mm)	0.38 to 0.74	0.34 to 0.69	-
Material pressure (bar)	200 to 400	100 to 150	-
Atomiser pressure (bar)	-	2.0 to 2.5	-
DFT * per working operation (µm)	80 to 160	80 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	5 °C	15 °C	30 °C
		4 hours	2 hours	1 hour

Drying/Curing times at 160 µm DFT	Ambient air temperature		
	5 °C	15 °C	30 °C
 dust-free:	after approx. 2 hours	after approx. 1.5 hours	after approx. 1 hour
 tack-free:	after approx. 8 hours	after approx. 5 hours	after approx. 3 hours
 overcoating interval / dry to handle	after approx. 10 hours	after approx. 6 hours	after approx. 4 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 1/2 according to EN ISO 12944-4

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products by suitable methods
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steel parts: Sweep blasting in accordance with EN ISO 12944-4. The surface must have a uniform dull appearance after surface preparation.

Existing primer coats - or old coats


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

	Air and surface temperature ≥ 5 °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-E90R-Metallgrund	80 to 160
	Optional Intermediate coats	GEHOPON-E90R (-ZB) GEHOPON-E87-ZB WIEREGEN-M87-ZB	80 to 160
	Top coats	WIEREGEN-M87 WIEREGEN-M97R WIEREGEN-M165R GEHOTEX-W92	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.geholti-wierner.de.

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