

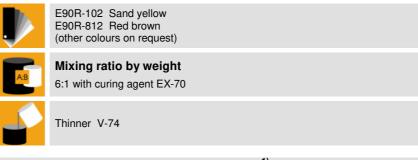
2C-EP-HS Priming coat, quick curing

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
	protection properties

- 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



GEHOPON-E90R-Metallgrund / Guideline ¹⁾

	Density (g/mL) 1.70	Solid content (weight %) 92.0	VOC-content (weight %) 8.0	Solid conte (%) 85.0	nt by volume (mL/kg) 500
7 8 9 ÷ 4 5 6 × 1 2 3 + 0 , =	DFT * (µm) 80	Calculated wet-film thickness (µm) 95	VOC-content (g/m ²) ²⁾ 1.6	Consumption (kg/m ²) ³⁾ 0.165	Spreading rate (m²/kg) 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

 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

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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 in handle	terval / dry to	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 (Phase II from 2010)	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")	
	(1 11236 11 11011 2010)		
J ("Two-pack reactive performance coatings") Type SB	500 g/l	< 500 g/l	

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

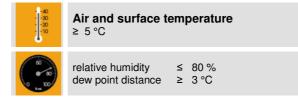
Blast-cleaning Sa 2 ½ according to EN ISO 12944-4

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



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PAINT SYSTEMS

Substrate:	steel, blast-cleaning in surface preparation grade Sa 2 1/2 in
	accordance with EN ISO 12944-4

EXAMPLES

		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.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.

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