

## 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 category C3 to C5
- Excellent chemical and mechanical resistance

## PRODUCT DATA

### GEHOPON-E90RI-Metallgrund



E90RI-751 Light grey (other colours on request)



#### Mixing ratio by weight

6:1 with curing agent EX-70



Thinner V-74

### GEHOPON-E90RI-Metallgrund / Guideline <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	<b>1.6</b>	<b>89.0</b>	<b>11.0</b>	<b>80.0</b>	<b>500</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>100</b>	<b>125</b>	<b>2.2</b>	<b>0.200</b>	<b>5.0</b>

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

2) Based on consumption in g/m<sup>2</sup> 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**



**High  
pressure <sup>4)</sup>**

<b>Application viscosity (s)</b> (8 mm DIN-cup)	<b>8 to 9</b>	<b>8 to 9</b>	<b>6 to 8</b>
<b>Nozzle diameter (mm)</b>	<b>0.33 to 0.38</b>	<b>0.33 to 0.38</b>	<b>1.5 to 2.0</b>
<b>Material pressure (bar)</b>	<b>125 to 175</b>	<b>100 to 150</b>	<b>-</b>
<b>Atomiser pressure (bar)</b>	<b>-</b>	<b>2.0 to 2.5</b>	<b>3.0 to 4.0</b>
<b>DFT * per working operation (µm)</b>	<b>80 to 100</b>	<b>80 to 100</b>	<b>80 to 100</b>
<b>Addition of thinner (%)</b>	<b>0 to 2</b>	<b>0 to 2</b>	<b>0 to 5</b>




4) recommended only for small areas



#### Pot life

1 to 2 hours (relating to 20 up to 30 °C)

\* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 1 hour
	tack free:	after approx. 4 hours
	ready for overcoating/handling:	after approx. 5 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 and cast iron**

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating, alternatively
- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

**Hot-dip galvanised steel surfaces**

- At natural weathering or condensation: Sweep blast-cleaning according to EN ISO 12944-4. After sweep blast-cleaning the surface shall have a uniform dull appearance, alternatively
- Chemical conversion layer (chromate, chromate free, phosphating)




**Air and surface temperature**  
≥ 5 °C



Relative humidity ≤ 80 %  
Dew point distance ≥ 3 °C

**PAINT SYSTEMS**

**EXAMPLES**

		<b>Product(s)</b> (other paint systems on request)
	<b>Priming coat</b>	GEHOPON-E90RI-Metallgrund
	<b>Monolayer / Top coat</b>	WIEREGEN-M165R

**SAFETY MEASURES**



The relevant data can be found in the current material safety data sheets, available at [www.geholti-wierner.de](http://www.geholti-wierner.de).

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