


MAIN PRODUCT-PROPERTIES

- High-grade high-solid Monolayer based on epoxy resin 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, A416290-1 and -2
- Excellent chemical and mechanical resistance
- Nominal dry film thicknesses of 160 to 200 µm by spraying

PRODUCT DATA

GEHOPON-E90R	MIO-colours
	E90R-7602 Grey DB 702 (other colours on request)
	Mixing ratio by weight 6:1 with curing agent EX-70
	Thinner V-74

GEHOPON-E90R	Guideline MIO-colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
	1.7	91.0	9.0	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)
	160	187	1.8	0.320	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)	160 to 200	160 to 200	60 to 80
Addition of thinner (%)	0 to 2	0 to 2	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. 3 hours	after approx. 1.5 hours	after approx. 1 hour
	tack-free:	after approx. 10 hours	after approx. 6 hours	after approx. 4 hours
	overcoating interval / dry to handle	after approx. 12 hours	after approx. 8 hours	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



- 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 through suitable measures
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steel parts: Sweep blast-cleaning according to EN ISO 12944-4 required. The surface must have a uniform dull appearance after surface preparation.

Existing priming coat or old coating


- 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	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.

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.