





## MAIN PRODUCT PROPERTIES

- High-grade, 2-pack Epoxy High-Solid intermediate coat
- Nominal dry film thicknesses of 80 to 160 µm per work step by spraying
- Direct coating of freshly hot-dip galvanised surfaces without sweeping with excellent adhesion is possible even under high atmospheric stress
- Within RWE systems, hot-dip galvanised surfaces must be sweep-blasted.

## PRODUCT DATA

GEHOPON-E921-Protect	RWE Code No.
 E921-3509, Oxide red approx. RAL 3009	GB21-S-3009
 <b>Mixing ratio by weight</b> 9:1 with curing agent EX-40	
 Thinner V-568	

### GEHOPON-E921-Protect / Guide values <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	(mL/kg)
	<b>1.5</b>	<b>78.0</b>	<b>22.0</b>	<b>62.0</b>	<b>415</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²) <sup>2)</sup>	Spreading rate (m²/kg)	Spreading rate (m²/L)
	<b>80</b>	<b>128</b>	<b>0.195</b>	<b>5.1</b>	<b>7.65</b>
	<b>100</b>	<b>161</b>	<b>0.240</b>	<b>4.2</b>	<b>6.25</b>

1) Guide values averaged data, slight deviations are possible depending on the colour

2) 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**

**High pressure**

**Roller/Brush application <sup>3)</sup>**

	Airless	High pressure	Roller/Brush application <sup>3)</sup>
<b>Nozzle diameter (mm)</b>	<b>0.38 to 0.74</b>	<b>1.5 to 1.8</b>	<b>-</b>
<b>Material pressure (bar)</b>	<b>150 to 300</b>	<b>-</b>	<b>-</b>
<b>Atomiser pressure (bar)</b>	<b>-</b>	<b>3.0 to 4.0</b>	<b>-</b>
<b>DFT * per working operation (µm)</b>	<b>80 to 160</b>	<b>60 to 120</b>	<b>60 to 80</b>
<b>Addition of thinner (%)</b>	<b>2 to 4</b>	<b>10 to 15</b>	<b>0 to 2</b>

\* DFT = Dry Film Thickness




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

## COMMENTS ON PROCESSING



### Pot life

approx. 4 hours (at 20 to 25 °C)

Drying/Curing times at 160 µm DFT		Ambient air temperature		
		5 - 10 °C	10 - 15 °C	15 - 20 °C
	dust-free:	after 4 hours	after 2 hours	after 1 hour
	tack-free:	after 24 to 48 hours	after 12 to 16 hours	after 6 to 8 hours
	overcoating interval:	after 3 to 4 days	after 2 days	after 1 day

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 lightly oversweeping or grinding.

### 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")
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 can be coated directly with GEHOPON-E921-Protect. Dry, clean surfaces without visible zinc reaction products (white rust, etc.) are required.
- In the case of special loads for inaccessible areas and in the presence of visible zinc reaction products: Sweep blasting in accordance with EN ISO 12944-4. 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:** hot-dip galvanised steel in accordance with EN ISO 1461,  
sweep blast-cleaning in accordance with EN ISO 12944-4

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Intermediate coat</b>	RWE Code No.: GB-21-S-3009 GEHOPON-E921-Protect	80 to 160
	<b>Top coats</b>	RWE Code No.: DB-23-S-... WIEREGEN-M923 RWE Code No.: DB-24-S-... WIEREGEN-M924	80

## SAFETY MEASURES



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