

MAIN PRODUCT PROPERTIES

- High-grade, MIO containing 2-pack epoxy intermediate coat for steel buildings and steel constructions
- Nominal dry film thicknesses of 120 µm by spraying, 40-60 µm by brush or roller application

PRODUCT DATA

GEHOPON-E922-ZB	RWE Code No.	
 E922-3811, Reseda green approx. RAL 6011	ZB-22-S-6011	
 Mixing ratio by weight 15:1 with curing agent EX-922		
 Thinner V-538		

GEHOPON-E922-ZB / Guide values ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.75	83	17	(%)	(mL/kg)
				64	370
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²) ²⁾	Spreading rate (m ² /kg)	Spreading rate (m ² /L)
	120	188	0.325	3.1	5.4

1) Guide values averaged data

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 ³⁾

Nozzle diameter (mm)	0.38 to 0.58	1.5 to 1.8	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	120	120	40 to 60
Addition of thinner (%)	0 to 5	4 to 7	0 to 2

* DFT = Dry Film Thickness

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

COMMENTS ON PROCESSING

 Pot life at	10 °C	20 °C	30 °C
	8 hours	6 hours	4 hours

Drying/Curing times at 120 µm DFT	Ambient air temperatures		
	5 °C	10 °C	20 °C
 dust-free:	≤ 90 minutes	≤ 60 minutes	≤ 30 minutes
 tack-free:	≤ 3.5 hours	≤ 2.5 hours	≤ 1.5 hours
 overcoating interval:	≤ 7 hours	≤ 6 hours	≤ 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")
J ("Two-pack reactive performance coatings") Type Lb	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

	Air and surface temperatures 0 to 40 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 K

PAINT SYSTEMS EXAMPLES

Substrate: Steel, blast-cleaned 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	RWE Code No.: GB-20-S-... GEHOPON-E920-Metallgrund-Rapid	120
	Intermediate coat	RWE Code No.: ZB-22-S-6011 GEHOPON-E922-ZB	120
	Top coats	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-wiemer.de .
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