


## MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-ING, Blatt 94 and is subject to regular external control
- High-grade, multi-purpose 2-pack EP High-Solid Priming coat for steel buildings and steel constructions
- Suitable for reconstruction of steel buildings also on manual derusted steel and old coatings based on 2-pack coating materials
- Nominal dry film thicknesses of 80 to 160 µm by spraying, of approx. 60 to 80 µm by brush application or roller coating


## PRODUCT DATA

### GEHOPON-E94-Metallgrund


|   |                            |                  |                    |
|---|----------------------------|------------------|--------------------|
|  | E94-701 Silver grey        | approx. RAL 7001 | code number 694.01 |
|   | E94-102 Sand yellow        | approx. RAL 1002 | code number 694.02 |
|   | E94-812 Red brown          | approx. RAL 8012 | code number 694.06 |
|   | (other colours on request) |                  |                    |

### Mixing ratio by weight

7:1 with curing agent EX-94

 Thinner V-568

### GEHOPON-E94-Metallgrund / Guideline <sup>1)</sup>

|  |                |                                    |   |  |                                     |
|--|----------------|------------------------------------|---|--|-------------------------------------|
|  | Density (g/mL) | Solid content (weight %)           | VOC-content (weight %)                        | Solid content by volume (%)                    | Solid content by volume (mL/kg)     |
|  | 1.7            | 90.0                               | 10.0  | 80.0   | 470                                 |
|  | 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) |
|  | 80             | 100                                | 2.1   | 0.170  | 5.9                                 |

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






Roller/Brush application <sup>4)</sup>

|                                  |              |              |          |
|----------------------------------|--------------|--------------|----------|
| Nozzle diameter (mm)             | 0.38 to 0.74 | 0.33 to 0.48 | -        |
| Material pressure (bar)          | 200 to 350   | 150 to 250   | -        |
| Atomiser pressure (bar)          | -            | 3.0 to 4.0   | -        |
| DFT * per working operation (µm) | 80 to 160    | 80 to 160    | 60 to 80 |
| Addition of thinner (%)          | 0 to 3       | 0 to 3       | 0 to 1   |

\* DFT = Dry Film Thickness

<sup>4)</sup> recommended only for smaller areas, formation of a product-specific surface structure is possible

|   |                    |             |              |              |
|---|--------------------|-------------|--------------|--------------|
|  | <b>Pot life at</b> | <b>5 °C</b> | <b>15 °C</b> | <b>30 °C</b> |
|   |                    | 7 hours     | 5 hours      | 3 hours      |

| Drying/Curing times at 80 µm DFT  |                       | Ambient air temperature |                        |                       |
|---|-----------------------|-------------------------|------------------------|-----------------------|
|   |                       | 5 °C                    | 15°C                   | 30°C                  |
|  | dust-free:            | after ≤ 4 hours         | after ≤ 3 hours        | after approx. 2 hours |
|  | tack-free:            | after ≤ 24 hours        | after ≤ 12 hours       | after ≤ 6 hours       |
|  | dry to handle:        | after ≤ 40 hours        | after ≤ 16 hours       | after ≤ 8 hours       |
|   | overcoating interval: | after approx. 30 hours  | after approx. 16 hours | after approx. 8 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")<br>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 alternatively
- Mechanical or manual derusting in preparation grade St 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 condensation of coated, hot-dip galvanised steelparts and for application area of ZTV-ING:  
Sweep blast-cleaning according to EN ISO 12944-4 required.  
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 and if applicable
- Mechanical or manual derusting in preparation grade PMA respectively PSt 2 according to EN ISO 12944-4
- If applicable additional spotting



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




relative humidity ≤ 80 %  
dew point distance ≥ 3 °C

Further details for processing and execution is described in the relevant applicable instructions


## PAINT SYSTEMS

### EXAMPLES

**Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4**

|   |                           | Product(s)<br>(other paint systems on request)                                      | NDFT<br>(µm) |
|---|---------------------------|---|--------------|
|  | <b>Priming coat</b>       | GEHOPON-E94-Metallgrund   | 80           |
|   | <b>Intermediate coats</b> | GEHOPON-E94-ZB<br>GEHOPON-E87-ZB<br>WIEREGEN-M87-ZB<br>In 1 or 2 working operations | 80 to 160    |
|   | <b>Top coats</b>          | WIEREGEN-M87<br>WIEREGEN-M97R<br>GEHOTEX-W92  | 80           |

**Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, cleaning in accordance with EN ISO 12944-4, e. g. with mixed constructions**

|   |                                    | Product(s)<br>(other paint systems on request)      | NDFT (µm) |
|---|------------------------------------|---|-----------|
|  | <b>Priming coat</b>                | GEHOPON-E94-Metallgrund                             | 80        |
|   | <b>Optional Intermediate coats</b> | GEHOPON-E94-ZB<br>GEHOPON-E87-ZB<br>WIEREGEN-M87-ZB | 80        |
|   | <b>Top coats</b>                   | WIEREGEN-M87<br>WIEREGEN-M97R<br>WIEREGEN-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-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.