

## MAIN PRODUCT PROPERTIES

- In accordance with TL/TP-ING, Blatt 94 and is subject to regular external control
- High-grade, multi-purpose applicable 2-pack EP High-Solid Intermediate coat for steel buildings and steel constructions
- Excellent adhesion directly on hot-dip galvanised steel
- 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-ZB



E94-7602 Grey DB 702 code number 694.12  
E94-7603 Grey DB 703 code number 694.13  
E94-6601 Green DB 601 code number 694.14




**Mixing ratio by weight**  
7:1 with curing agent EX-94



Thinner V-568

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

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	<b>1.85</b>	<b>92.0</b>	<b>8.0</b>	<b>83.0</b>	<b>450</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>80</b>	<b>96</b>	<b>1.8</b>	<b>0.180</b>	<b>5.6</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






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	40 to 60
Addition of thinner (%)	0 to 3	0 to 3	0 to 2
 Pot life at	5 °C	15 °C	30 °C
	6 hours	4 hours	3 hours

\* DFT = Dry Film Thickness

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

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 ≤ 30 hours	after ≤ 15 hours	after ≤ 8 hours
	dry to handle:	after ≤ 48 hours	after ≤ 20 hours	after ≤ 12 hours
	overcoating interval:	after approx. 48 hours	after approx. 20 hours	after approx. 12 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**

**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 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



**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) (other paint systems on request)	NDFT (µm)
	<b>Priming coats</b>	GEHOPON-E87-Zink GEHOPON-E94-Metallgrund	70 to 80 80
	<b>Intermediate coats</b>	GEHOPON-E94-ZB	80 to 160
	<b>Top coats</b>	WIEREGEN-M87 WIEREGEN-M97R 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) (other paint systems on request)	NDFT (µm)
	<b>Optional Intermediate coats</b>	GEHOPON-E94-ZB	80
	<b>Top coats</b>	WIEREGEN-M87 WIEREGEN-M97R 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-wiemer.de](http://www.geholit-wiemer.de).

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