

MAIN PRODUCT-	In accordance with TL/TP-KOR-Stahlbauten, Blatt 97 and is
PROPERTIES	subject to regular external control
	- High grada, guick ouring, multi nurnada applicable 2 pack E

TECHNICAL INFORMATION

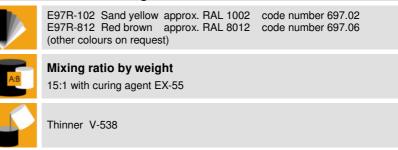
Page 1/3 - June 2020 / Vers. 4 **Corrosion Protection**

> High-grade, quick curing, multi-purpose applicable 2-pack EP Priming coat for steel buildings and steel constructions

- Excellent adhesion on steel and hot-dip galvanised steel
- Nominal dry film thicknesses of 80 to 100 µm by spraying, of approx. 60 µm by brush application or roller coating

PRODUCT DATA

GEHOPON-E97R-Metallgrund



GEHOPON-E97R-Metallgrund / Guideline¹⁾

7 8 9 + 4 5 6 X 1 2 3 + 0 , =	Density (g/mL) 1.6	Solid content (weight %) 78.0	VOC-content (weight %) 22.0	Solid conte (%) 60.0	nt by volume (mL/kg) 375
	DFT * (μm) 80	Calculated wet-film thickness (µm) 135	VOC-content (g/m ²) ²⁾ 5.9	Consumption (kg/m ²) ³⁾ 0.215	Spreading rate (m²/kg) 4.7

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

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Airless	High pressure	Roller/Brush application
0.33 to 0.58	1.5 to 2.0	-
150 to 250	-	-
-	3.0 to 4.0	-
80 to 100	80 to 100	40 to 60
0 to 3	4 to 6	0 to 1
5 °C	15 °C	30 °C
6 hours	4 hours	3 hours
	0.33 to 0.58 150 to 250 - 80 to 100 0 to 3 5 °C	Amess pressure 0.33 to 0.58 1.5 to 2.0 150 to 250 - - 3.0 to 4.0 80 to 100 80 to 100 0 to 3 4 to 6 5 °C 15 °C

* DFT = Dry Film Thickness

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2C-EP Priming coat, quick curing

Drying/Curing times at 80 μm DFT		Ambient air temperature		
		5 °C	15 °C	30 °C
StStStS	dust-free:	after ≤ 2 hours	after ≤ 1 hour	after approx. 30 minutes
	tack-free:	after ≤ 4 hours	after ≤ 2.5 hours	after ≤ 90 minutes
	overcoating interval / dry to handle:	after ≤ 6 hours	after ≤ 4 hours	after ≤ 2 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	
	(Phase II from 2010)	in its ready for use condition (including the max. amount of diluents as given in "Application methods")	
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 ½ 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 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



Air and surface temperature ≥ 0 °C

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

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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-E97R-Metallgrund	80
_	Intermediate coats	GEHOPON-E97R-ZB GEHOPON-E97RX-ZB WIEREGEN-M97R-ZB WIEREGEN-M97RX-ZB In 1 or 2 working operations	80 to 160
	Top coats	WIEREGEN-M97R WIEREGEN-M197R	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

	constructions		
		Product(s) (other paint systems on request)	NDFT (µm)
_	Priming coat	GEHOPON-E97R-Metallgrund	80
	Optional Intermediate coats	GEHOPON-E97R-ZB GEHOPON-E97RX-ZB WIEREGEN-M97R-ZB WIEREGEN-M97RX-ZB	80
	Top coats	WIEREGEN-M97R WIEREGEN-M197R	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.

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.

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