

## MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR-Stahlbauten, Blatt 97 and is subject to regular external control
- 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



E97R-102 Sand yellow approx. RAL 1002 code number 697.02  
E97R-812 Red brown approx. RAL 8012 code number 697.06  
(other colours on request)




#### Mixing ratio by weight

15:1 with curing agent EX-55



Thinner V-538

### GEHOPON-E97R-Metallgrund / Guideline <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (mL/kg)	
	<b>1.6</b>	<b>78.0</b>	<b>22.0</b>	<b>60.0</b>	<b>375</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>135</b>	<b>5.9</b>	<b>0.215</b>	<b>4.7</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






High pressure



Roller/Brush application

Nozzle diameter (mm)	0.33 to 0.58	1.5 to 2.0	-	
Material pressure (bar)	150 to 250	-	-	
Atomiser pressure (bar)	-	3.0 to 4.0	-	
DFT * per working operation (µm)	80 to 100	80 to 100	40 to 60	
Addition of thinner (%)	0 to 3	4 to 6	0 to 1	
	Pot life at	5 °C	15 °C	30 °C
		6 hours	4 hours	3 hours

\* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature		
		5 °C	15 °C	30 °C
	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 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**

**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




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 coat</b>	GEHOPON-E97R-Metallgrund	80
	<b>Intermediate coats</b>	GEHOPON-E97R-ZB GEHOPON-E97RX-ZB WIEREGEN-M97R-ZB WIEREGEN-M97RX-ZB In 1 or 2 working operations	80 to 160
	<b>Top coats</b>	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**

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