





## 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 2C-EP intermediate coat for steel buildings and steel constructions
- Excellent adhesion directly on 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-ZB	MIO-colours
	E97R-7602 Grey DB 702 code number 697.12 E97R-7603 Grey DB 703 code number 697.13 E97R-6601 Green DB 601 code number 697.14
	<b>Mixing ratio by weight</b> 15:1 with curing agent EX-55
	Thinner V-538

GEHOPON-E97R-ZB	Guideline MIO-colours <sup>1)</sup>				
	Density (g/mL) <b>1.65</b>	Solid content (weight %) <b>79.0</b>	VOC-content (weight %) <b>21.0</b>	Solid content by volume (mL/kg) <b>365</b>	
	DFT * (µm) <b>80</b>	Calculated wet-film thickness (µm) <b>133</b>	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup> <b>5.8</b>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup> <b>0.220</b>	Spreading rate (m <sup>2</sup> /kg) <b>4.5</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**

<b>Nozzle diameter (mm)</b>	<b>0.33 to 0.58</b>	<b>1.5 to 2.0</b>	-
<b>Material pressure (bar)</b>	<b>150 to 250</b>	-	-
<b>Atomiser pressure (bar)</b>	-	<b>3.0 to 4.0</b>	-
<b>DFT * per working operation (µm)</b>	<b>80 to 100</b>	<b>80 to 100</b>	<b>40 to 60</b>
<b>Addition of thinner (%)</b>	<b>0 to 5</b>	<b>4 to 7</b>	<b>0 to 1</b>
 <b>Pot life at</b>	<b>5 °C</b>	<b>15 °C</b>	<b>30 °C</b>
	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
	dry to handle:	after ≤ 6 hours	after ≤ 4 hours	after ≤ 3 hours
	overcoating interval:	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

#### 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 steel parts and for application range 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**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Priming coats</b>	GEHOPON-E97R-Zink GEHOPON-E97R-Metallgrund	70 to 80 80
	<b>Intermediate coat</b>	GEHOPON-E97R-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**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Optional Intermediate coat</b>	GEHOPON-E97R-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.geholti-wierner.de](http://www.geholti-wierner.de).

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