MAIN PRODUCT-PROPERTIES

- **In accordance with TL/TP-KOR-Stahlbauten, Blatt 97 and is subject to regular external control**
- **High-grade, quick curing 2-pack EP zinc rich Priming coat for steel buildings and steel constructions**
- **Nominal dry film thicknesses of 60 to 80 µm by spraying**
- **Maximum dry film thickness 150 µm**
- **Temperature resistance up to 160 °C long term stress, 200 °C short term stress**

PRODUCT DATA

GEHOPON-E97R-Zink

	E97R-390 Red grey code number 697.03
	**Mixing ratio by weight** 16:1 with curing agent EX-80
	Thinner V-538

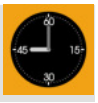
GEHOPON-E97R-Zink / Guideline

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
2.5	**85.0**	**15.0**	**56.0**	**225**

DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [1)]	Consumption (kg/m²) [2)]	Spreading rate (m²/kg)
80	**143**	**6.7**	**0.350**	**2.85**

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

Recommendation at temperatures of approx. 20 °C	 **Airless**	 **High pressure**	 **Roller/Brush application [3)]**
Nozzle diameter (mm)	**0.38 to 0.63**	**1.5 to 2.0**	**-**
Material pressure (bar)	**150 to 300**	**-**	**-**
Atomiser pressure (bar)	**-**	**4.0 to 5.0**	**-**
DFT * per working operation (µm)	**60 to 80**	**60 to 80**	**40 to 60**
Addition of thinner (%)	**0 to 2**	**0 to 5**	**0 to 1**
 **Pot life at**	**5 °C**	**15 °C**	**30 °C**
	6 hours	4 hours	3 hours

3) recommended only fo smaller areas
* 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 ≤ 3 hours	after ≤ 2 hours	after ≤ 45 minutes
	overcoating interval / dry to handle	after ≤ 5 hours	after ≤ 3 hours	after ≤ 1 hour

Notes referring to Directive 2004/42/EC „Decopaint-Directive“		
Subcategory as referred to in Annex IIA	VOC limit values (Phase II from 2010)	Max. VOC content of the product 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, Roughness grade medium (G) according to EN ISO 8503-1

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)
Priming coat	GEHOPON-E97R-Zink	70 to 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

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.