

MAIN PRODUCT-PROPERTIES

- High-grade, waterborne, multi-purpose 2-pack EP Priming coat for steel buildings and steel constructions
- Fulfills the technical requirements of Blatt 87 TL/TP-KOR in paint systems. Third party tested by IKS Dresden GmbH, report: PB300/199/11 and PB300/201/11
- Excellent adhesion on miscellaneous surfaces
- Nominal dry film thicknesses of 80 µm by spraying, of 40 to 60 µm by brush application or roller coating

PRODUCT DATA

GEHOPON-EW18-Metallgrund



EW18-102 Sand yellow approx. RAL 1002
EW18-732 Pebble grey approx. RAL 7032
EW18-740 Window grey approx. RAL 7040
(other colours on request)



Mixing ratio by weight

4:1 with curing agent EZ-18



Dilution with water (at least drinking water quality)

GEHOPON-EW18-Metallgrund / Guideline ¹⁾

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
			(%)	(mL/kg)
1.35	66.0	< 0.5	54.0	400
DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
80	145	0.1	0.200	5.0

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

Recommendation at temperatures of approx. 20 °C



Airless



High pressure






Roller/Brush application

Nozzle diameter (mm)	0.33 to 0.48	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	80	40 to 60
Addition of thinner (%)	0 to 3	3 to 8	0 to 1

* DFT = Dry Film Thickness

	Pot life	2 hours (relating to 20 °C)
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Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	dust-free:	after approx. 60 minutes
	tack-free:	after approx. 3 hours
	overcoating interval / dry to handle	after approx. 18 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 WB	140 g/l	< 140 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel surfaces



- Blast-cleaning Sa 2 1/2 according to EN ISO 12944-4

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products by suitable methods
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steel parts: Sweep blasting in accordance with EN ISO 12944-4. 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 10 °C to 40 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C Ensure sufficient air movement during drying

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-EW18-Metallgrund	80
	Intermediate coats	GEHOPON-EW18-ZB WIEREGEN-M87-ZB In 1 or 2 working operations	80 to 160
	Top coats	GEHOTEX-W92 WIEREGEN-DW18 WIEREGEN-M87	80

Several coating systems for the corrosivity categories C3 to C5 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.

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.