

## MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Excellent corrosion protection with suitable Monolayer/Topcoats
- High compatibility for subsequent 2-pack Monolayer/Topcoats
- Very fast curing at accelerated drying

## PRODUCT DATA

### GEHOPON-EW19-Metallgrund



EW19-735 Light grey approx. RAL 7035 (other colours on request)



#### Mixing ratio by weight

2.5:1 with curing agent EZ-19



Dilution with water (at least drink water quality)

### GEHOPON-EW19-Metallgrund / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.25	56.0	<0.5	45.0	360
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	50	111	0.140	7.2	

## COMMENTS ON PROCESSING

Recommendation at  
temperatures  
of approx. 20 °C



Airless /  
Airmix



High  
pressure



Roller/Brush  
application




<b>Application viscosity (s)</b> (6 mm DIN-cup)	30 to 40		30 to 40		30 to 40	
<b>Nozzle diameter (mm)</b>	0.33 to 0.48		1.5 to 2.0		-	
<b>Material pressure (bar)</b>	150 to 250		-		-	
<b>Atomiser pressure (bar)</b>	2.5 to 3.5		3.0 to 4.0		-	
<b>DFT * per working operation (µm)</b>	40 to 50	80	40 to 50	80	40 to 60	
<b>Addition of thinner (%)</b>	0 to 2	0	0 to 2	0	0	



#### Pot life

2 hours (relating to 20 °C)

\* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 30 minutes
	tack free:	after approx. 60 minutes
	ready for overcoating/handling:	after approx. 8 hours

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 1/2 according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

#### Hot-dip-galvanised steel surfaces and aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation:  
Sweep blast-cleaning according to EN ISO 12944-4.  
After sweep blast-cleaning the surface shall have a uniform dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



#### Air and surface temperature

optimal at 15 to 25 °C, not below 10 °C, not over 40 °C



max. 80 % relative humidity

## PAINT SYSTEMS

### EXAMPLES

	Product(s) (other paint systems on request)
 <b>Priming coat</b>	GEHOPON-EW19-Metallgrund
<b>Monolayer / Top coat</b>	WIEREGEN-C165R or WIEREGEN-M165R WIEREGEN-D54R or WIEREGEN-D154R WIEREGEN-DW54 WIEREGEN-M155R

## SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at [www.geholit-wiemer.de](http://www.geholit-wiemer.de).

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