MAIN PRODUCT PROPERTIES

- **1C-AY Hydro Topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transforming stations of electric power supply companies**
- **Together with suitable priming coats also as topcoat in multi-layered systems for steel constructions of low alloyed steel**
- **Processing occurs preferably by brush application (DFT 80 to 120 µm)**

PRODUCT DATA

GEHOTEX-W19B-DKX-Hydro	**MIO-colours**
	W19B-E7833 Cement grey approx. RAL 7033 (other colours on request)
	**Mixing ratio by weight** not relevant
	Demineralised water or water of low hardness

GEHOTEX-W19B-DKX-Hydro **Guideline MIO-colours** [1)]

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
	**1.4**	**64.0**	**< 4**	**49.0**	**350**
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [2)]	Consumption (kg/m²) [3)]	Spreading rate (m²/kg)
	100	**204**	**1.2**	**0.285**	**3.5**

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)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	**80 to 120**
Addition of thinner (%)	-	-	**0 to 2**

*) DFT = Dry film thickness

COMMENTS ON PROCESSING

Pot life
Not relevant

Drying/Curing times at 100 µm DFT	Ambient air temperature 20 °C
dust-free:	after 45 to 60 minutes
tack-free:	after 1.5 to 2 hours
overcoating interval / dry to handle: dry to walk on:	after 10 to 16 hours from 48 hours

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”)
i (“One-pack performance coatings”) Type WB	140 g/l	< 140 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Weathered, hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts, e. g. cleaning, washing, alcaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
  The surface must have a uniform dull appearance after surface preparation.

Existing coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of other priming coats compatibility tests are recommended

Air and surface temperature
10 to 35 °C

relative humidity ≤ 80 %
dew point distance ≥ 3 °C

PAINT SYSTEMS

EXAMPLES

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (µm)
	**Optional priming coat**	GEHOTEX-W180-Shopprimer	20
	Monolayer	GEHOTEX-W19B-DKX-Hydro	80 to 120

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ or mechanical respectively manual derusting PMA/St2 if applicable with old coating

		Product(s) (other paint systems on request)	NDFT (µm)
	**Priming coats**	GEHOTEX-W5-Korrogrund	40 to 60
	Top coat	GEHOTEX-W19B-DKX-Hydro	80 to 120

SAFETY MEASURES

The relevant data can be found in the current material safety data sheets, available at www.geholit-wiemer.de.

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