

## MAIN PRODUCT PROPERTIES

- 1C-AY Hydro Topcoat for high-grade corrosion protection of hot-dip galvanised steel surfaces, e. g. girder masts, transforming stations of electric power supply companies
- Together with suitable protective priming coats as a top coat for steel structures in multi-layer systems of low alloyed steel
- Processing will be done preferable by brush application (DFT 80 to 120 µm)

## PRODUCT DATA

### GEHOTEX-W20B-DKX-Hydro MIO-colours



W20B-E7833 Cement grey approx. RAL 7033 (other colours on request)



#### Mixing ratio by weight

not relevant



Demineralised water or water of low hardness

### GEHOTEX-W20B-DKX-Hydro Guideline MIO-colours <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	<b>1.3</b>	<b>64.5</b>	<b>&lt; 5</b>	<b>54.0</b>	<b>415</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>100</b>	<b>185</b>	<b>0.9</b>	<b>0.240</b>	<b>4.15</b>

1) Guideline averaged data, slight deviations 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

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 16 to 24 hours ≥ 48 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)	
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, alkaline 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 unknown 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**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Optional priming coat</b>	GEHOTEX-W180-Shopprimer	20
	<b>Monolayer</b>	GEHOTEX-W20B-DKX-Hydro	80 to 120

**Substrate: steel, mechanical or manual derusting PMA/St2 if applicable with old coating**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Priming coats</b>	GEHOTEX-W5-Korrogrund	40 to 60
	<b>Top coat</b>	GEHOTEX-W20B-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](http://www.geholit-wiemer.de).

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