

MAIN PRODUCT-PROPERTIES

- 1-pack AY Hydro Adhesion Primer for hot-dip galvanised steel constructions
- Adjustment for an application in the shop by airless-spraying with nominal dry film thicknesses of 40 to 60 µm
- Processing by brush application and roller coating is also possible
- Optimum adhesion and elasticity even on new, hot-dip galvanised steel parts also without blast-cleaning

PRODUCT DATA

GEHOTEX-W7-Haftgrund



W7-701 Grey
W7-940 White (other colours on request)



Mixing ratio by weight

not relevant



Demineralised water or water of low hardness

GEHOTEX-W7-Haftgrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (mL/kg)	
	1.4	67.0	< 3	54.0	385
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	100	185	0.8	0.260	3.9

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 ⁴⁾

Nozzle diameter (mm)	0.38 to 0.45	1.5 to 1.8	-
Material pressure (bar)	100 to 250	-	-
Atomiser pressure (bar)	3.0 to 4.0	3.0 to 4.0	-
DFT * per working operation (µm)	40 to 60	40 to 60	40 to 60
Addition of thinner (%)	0 to 5	3 to 5	-

* DFT = Dry film thickness

4) Recommended only for smaller areas, formation of a product-specific surface structure is possible

**COMMENTS ON
PROCESSING**



Pot life
Not relevant

Drying/Curing times at 60 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 30 to 45 minutes
	tack-free:	after 1.0 to 1.5 hours
	dry to handle: overcoating interval with 1C-paint: overcoating interval with 2C-paint:	after 8 to 12 hours after 12 hours after 24 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

Hot-dip galvanised steel surfaces

- New galvanised surfaces can be coated directly with GEHOTEX-W7-Haftgrund. Dry and clean surfaces without any visible zinc reaction products (white rust, etc.) are required
- 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.



Air and surface temperature
10 to 40 °C



relative humidity ≤ 80 %
dew point distance ≥ 3 °C
Ensure sufficient air movement during drying

PAINT SYSTEMS

EXAMPLES

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461

		Product(s) (other paint systems on request)	NDFT (μm)
	Priming coat	GEHOTEX-W7-Haftgrund	40 to 60
	Top coats	GEHOTEX-W92 WIEREGEN-M87 WIEREGEN-M97R	80

SAFETY MEASURES



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

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