





## MAIN PRODUCT-PROPERTIES

- Mat 1C-AY Hydro topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions
- Application in the shop by airless-spraying with nominal dry film thicknesses of 100 µm
- Optimum adhesion even on fresh, hot-dip galvanised surface without sweep blast-cleaning

## PRODUCT DATA

GEHOTEX-W8	RAL-colours, mat
	W8-M... (RAL-colours, other colours on request)
	<b>Mixing ratio by weight</b> not relevant
	Demineralised water or water of low hardness

GEHOTEX-W8	Guideline RAL-colours <sup>1)</sup>				
	Density (g/mL) <b>1.4</b>	Solid content (weight %) <b>67.0</b>	VOC-content (weight %) <b>&lt; 4</b>	Solid content by volume (%) <b>54.0</b>	Solid content by volume (mL/kg) <b>385</b>
	DFT * (µm) <b>100</b>	Calculated wet-film thickness (µm) <b>185</b>	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup> <b>1.0</b>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup> <b>0.260</b>	Spreading rate (m <sup>2</sup> /kg) <b>3.9</b>

1) Guideline averaged data, slight deviation 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 <sup>4)</sup>

Nozzle diameter (mm)	0.38 to 0.53	-	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	120	-	50 to 70
Addition of thinner (%)	0 to 3	-	-




\* 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 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:	after 16 to 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

- 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**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> ( $\mu\text{m}$ )
	<b>Monolayer</b>	GEHOTEX-W8	100

## SAFETY MEASURES



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

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