

MAIN PRODUCT-PROPERTIES

- 1-pack AY Hydro Priming coat for corrosion protection of steel constructions, e. g. steel hall -, apparatus -, crane construction
- Application in the shop by airless-spraying with nominal dry film thicknesses of 60 to 80 μm , e. g. in automatic painting lines
- With optional top coats also suitable for higher corrosion stress
- High compatibility with many suitable commercially available top coats

PRODUCT DATA

GEHOTEX-W90-Metallgrund



W90-732 Pebble grey approx. RAL 7032
(RAL-colours, other colours on request)




Mixing ratio by weight
not relevant



Demineralised water

GEHOTEX-W90-Metallgrund / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.3	58.0	< 4	45.0	345
	DFT * (μm)	Calculated wet-film thickness (μm)	VOC-content (g/m^2) ²⁾	Consumption (kg/m^2) ³⁾	Spreading rate (m^2/kg)
	60	134	1.1	0.175	5.7

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m^2 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

Airmix

Roller/Brush application ⁴⁾




Nozzle diameter (mm)	0.33 to 0.58	0.38 to 0.45	-
Material pressure (bar)	150 to 250	75 to 100	-
Atomiser pressure (bar)	-	3 to 4	-
DFT * per working operation (μm)	60 to 80	60 to 80	40 to 60
Addition of thinner (%)	0 to 3	2 to 5	-

* DFT = Dry Film Thickness

4) Recommended only for smaller areas



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 to 1.5 hours
	dry to handle: overcoating interval with 1C-paint: overcoating interval with 2C-paint:	after 4 to 6 hours after 6 hours after 5 days

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

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4 alternatively in industrial application areas
- Remove adhesion-reducing substances, e. g. cleaning, washing, phosphating

Existing (Pre-Fab-)coatings

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



Air and surface temperature
10 °C to 40 °C




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

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coat	GEHOTEX-W90-Metallgrund	60 to 80
	Optional Top coats	GEHOLIT-K65 WIEREGEN-M87 WIEREGEN-M97R GEHOTEX-W9 GEHOTEX-W92	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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