





## MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR, Blatt 91 and is subject to regular external control
- 1C-AY Hydro Topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, contact line masts, railings, noise protection walls
- Application in the shop by airless-spraying with nominal dry film thicknesses of 120 µm
- Together with suitable top coats also as intermediate coat appropriate for higher corrosion stress up to C5

## PRODUCT DATA

GEHOTEX-W91	MIO-colours
	W91-E... MIO-colours (according to G+W-colours)
	<b>Mixing ratio by weight</b> not relevant
	Demineralised water

GEHOTEX-W91	Guideline MIO-colours <sup>1)</sup>				
	Density (g/mL) <b>1.45</b>	Solid content (weight %) <b>64.0</b>	VOC-content (weight %) <b>&lt; 4</b>	Solid content by volume (%) <b>48.0</b>	(mL/kg) <b>330</b>
	DFT * (µm) <b>120</b>	Calculated wet-film thickness (µm) <b>250</b>	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup> <b>1.2</b>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup> <b>0.365</b>	Spreading rate (m <sup>2</sup> /kg) <b>2.7</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 120 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 45 to 60 minutes
	tack-free:	after 1.5 to 2 hours
	dry to handle: overcoating interval with itself: overcoating interval with 2C-paint:	after 16 to 24 hours after 6 hours 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

- Freshly hot-dip galvanised surfaces can be coated directly with GEHOTEX-W91. Dry, clean surfaces without visible zinc reaction products (whiterust, etc.) are required.
- Remove adhesion-reducing substances, especially 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

Further details for processing and execution is described in the relevant applicable instructions

## 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 / Intermediate coat</b>	GEHOTEX-W91	120
	<b>Optional Top coats</b>	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](http://www.geholit-wierner.de).

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