






MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR, Blatt 92
- High-grade 1C-AY Hydro Topcoat for steel and hot-dip galvanised steel constructions
- Application preferable by airless-spraying with nominal dry film thicknesses of 80 to 100 µm / Processing by roller coating and brush application with DFT of 60 to 80 µm also possible
- Excellent colour stability at natural weathering

PRODUCT DATA

GEHOTEX-W92	MIO-colours RAL-colours, flat
 W92-E... MIO-colours (according to G+W-colours)	W92-F... RAL-colours (other colours on request)
 Mixing ratio by weight	Not relevant
 Demineralised water	

GEHOTEX-W92	Guideline MIO-colours ¹⁾				
	Density (g/mL) 1.35	Solid content (weight %) 58,5	VOC-content (weight %) < 3	Solid content by volume (%) 44	(mL/kg) 325
	DFT * (µm) 80	Calculated wet-film thickness (µm) 182	VOC-content (g/m ²) ²⁾ 0.9	Consumption (kg/m ²) ³⁾ 0.245	Spreading rate (m ² /kg) 4.1

GEHOTEX-W92	Guideline RAL-colours ¹⁾				
	Density (g/mL) 1.35	Solid content (weight %) 60.0	VOC-content (weight %) < 3	Solid content by volume (%) 46	(mL/kg) 340
	DFT * (µm) 80	Calculated wet-film thickness (µm) 174	VOC-content (g/m ²) ²⁾ 0.9	Consumption (kg/m ²) ³⁾ 0.235	Spreading rate (m ² /kg) 4.3

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	Airmix	Roller/Brush application
Nozzle diameter (mm)	0.33 to 0.53	0.38 to 0.45	-
Material pressure (bar)	150 to 250	100 to 150	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	80 to 100	80 to 100	50 to 70
Addition of thinner (%)	0 to 3	3 to 5	-

*) DFT = Dry film thickness

COMMENTS ON PROCESSING



Pot life
Not relevant

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
 dust-free:		after 45 to 60 minutes
 tack-free:		after 2 to 3 hours
 overcoating interval / dry to handle:		after 6 to 8 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

Required priming coats respectively intermediate coats (see page 3)

- Remove adhesion-reducing substances



Air and surface temperature
10 to 35 °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: 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 coats	GEHOPON-E87-Zink GEHOTEX-W92-Metallgrund	80 80
	Intermediate coat	GEHOTEX-W92 (MIO)	80
	Top coat	GEHOTEX-W92	80

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, with appropriate surface preparation

		Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coats	GEHOTEX-W7-Haftgrund GEHOTEX-W18 GEHOTEX-W91	40 to 60 80 to 100 80 to 100
	Top coat	GEHOTEX-W92	80

Several coating systems for the corrosivity categories C3 to C5 according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES



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

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