





MAIN PRODUCT PROPERTIES

- **1C-AY Hydro Monolayer for high-grade corrosion protection of steel constructions, e. g. steel hall construction, apparatus construction, crane construction**
- **Application in the shop by airless-spraying with nominal dry film thicknesses of 80 to 120 µm, e. g. in automatic systems**
- **As monolayer with 100 µm suitable for corrosivity category C1, C2, high durability, and C3, medium durability**
- **Test report PB300/272/12 by IKS Dresden**
- **Test report KT-PB-110-2023 A20072834 by IFAM Bremen**
- **For higher corrosion stress in multi-layered systems together with suitable optional top coats**

PRODUCT DATA

GEHOTEX-W9	RAL-colours, mat
	W9-M.... (RAL-colours, other colours on request)
	Mixing ratio by weight not relevant
	Demineralised water

GEHOTEX-W9	Guideline RAL-colours ¹⁾				
	Density (g/mL) 1.3	Solid content (weight %) 62.0	VOC-content (weight %) < 6	Solid content by volume (%) 50.0	(mL/kg) 385
	DFT * (µm) 100	Calculated wet-film thickness (µm) 200	VOC-content (g/m²) ²⁾ 1.6	Consumption (kg/m²) ³⁾ 0.260	Spreading rate (m²/kg) 3.8

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⁾

	Airless	High pressure	Roller/Brush application ⁴⁾
Nozzle diameter (mm)	0.33 to 0.58	-	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	80 to 120	-	60 to 80
Addition of thinner (%)	0 to 5	-	0 to 2

*) 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



dry to handle:
overcoating interval with 1C-paint:
overcoating interval with 2C-paint:

after 6 to 8 hours
after 8 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

- Sweep blast-cleaning 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 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 / Monolayer	GEHOTEX-W9	80 to 120
	Optional Top coats	WIEREGEN-M87 WIEREGEN-M97R GEHOTEX-W92	80

SAFETY MEASURES



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

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