

MAIN PRODUCT PROPERTIES

- Quick-curing, water-dilutable 1C-AC priming coat for cast steel parts, sheet metal parts, and deep-drawn components
- Air-drying; for industrial use, however, forced drying is recommended, e. g. at 30 to 50 °C

PRODUCT DATA

GEWITEX-W112-Metallgrund



W112-735, light grey, approx. RAL 7035
(other colours on request)



Mixing ratio by weight

Not relevant



Demineralised water
For cleaning of equipment: V-432

GEWITEX-W112-Metallgrund / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.35	61.0	ca. 3	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate	
	50	105	0.142	(m²/kg)	7.0

COMMENTS ON PROCESSING

Recommendation at
temperatures
of approx. 20 °C



Airless



Airmix



High
pressure




Application viscosity (s) (8 mm DIN-cup)	20 to 25	20 to 25	15 to 25
Nozzle diameter (mm)	0.28 to 0.38	0.28 to 0.38	1.3 to 1.5
Material pressure (bar)	80 to 120	60 to 100	-
Atomiser pressure (bar)	-	0.8 to 1.3	3.0 to 4.0
DFT * per working operation (µm)	50 to 70	50 to 70	40 to 60
Addition of thinner (%)	-	-	0 to 3



Pot life

Not relevant

* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 30 to 40 minutes
	tack free:	after approx. 120 minutes
	ready for overcoating/handling with 1 pack top coats: 2 pack top coats:	after 12 to 16 hours after 48 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4
Roughness grade medium (G) according to EN ISO 8503-1



Air and surface temperature

optimal at 15 to 25 °C, not below 10 °C, not above 40 °C
Ensure sufficient air movement during drying



Optimal 40 to 60 %, max. 80 % relative humidity
Dew point distance ≥ 3 °C

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	GEWITEX-W112-Metallgrund
	Monolayer / top coat	GEWITEX-W143

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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