

## MAIN PRODUCT PROPERTIES

- Hydro monolayer coating based on 1C-EPE combination
- Good adhesion to multi-substrate surfaces and grey cast iron
- Very good resistance to a wide range of operating materials and lubricants for engines
- High compatibility with optional 1C and 2C coating materials
- Very fast curing and packaging capability with forced drying

## PRODUCT DATA

### GEWITEX-W60, flat



W60-F... RAL-colours (other colours on request)



#### Mixing ratio by weight

Not relevant



Demineralised water

### GEWITEX-W60 / Guide values <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	<b>1.2</b>	<b>50</b>	<b>&lt; 3.0</b>	(%) <b>40</b>	(mL/kg) <b>335</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption <sup>2)</sup> (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	<b>40</b>	<b>95</b>	<b>0.120</b>	<b>8.35</b>	

1) Guide value averaged data, slight deviations are possible depending on the colour

2) 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**



**Airless / Airmix**



**High pressure**

<b>Application viscosity (s)</b> (6 mm DIN cup)	<b>18 to 22</b>	<b>30 to 40</b>	<b>30 to 40</b>
<b>Nozzle diameter (mm)</b>	<b>0.23 to 0.28</b>	<b>0.23 to 0.28</b>	<b>1.2 to 1.6</b>
<b>Material pressure (bar)</b>	<b>20 to 80</b>	<b>80 to 150</b>	<b>-</b>
<b>Atomiser pressure (bar)</b>	<b>1.5 to 2.5</b>	<b>1.5 to 3.0</b>	<b>3.0 to 4.0</b>
<b>DFT * per working operation (µm)</b>	<b>30 to 50</b>	<b>60 to 80</b>	<b>30 to 50</b>
<b>Addition of thinner (%)</b>	<b>0 to 5</b>	<b>-</b>	<b>0 to 5</b>

\* DFT = Dry Film Thickness



**Pot life**  
Not relevant

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
touch dry:		after approx. 45 minutes
tack free:		after approx. 90 minutes
ready for overcoating: ready for handling:		after approx. 4 hours after approx. 8 hours

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Steel surfaces and cast iron

- 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

#### Hot-dip galvanised steel surfaces and aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation load: Sweep blast-cleaning according to EN ISO 12944-4.  
The surface must have a uniformly dull appearance.
- Chemical conversion layers (chromate, chromate free, phosphating)



**Air and surface temperatures**  
optimal at 15 to 25 °C, not below 10 °C, not above 40 °C



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

## PAINT SYSTEMS

### EXAMPLES

		<b>Product(s)</b> (other paint systems on request)
	<b>Monolayer</b>	GEWITEX-W60

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.