

MAIN PRODUCT PROPERTIES

- Quick-curing 1C-AC hydro spray primer for grey cast iron, e.g., gearboxes
- Specially adjusted for spray application
- Excellent adhesion on blasted grey cast iron
- Air-drying; forced drying is recommended for industrial use, e.g. at 50 to 100 °C
- Fully cured coatings are resistant to a wide range of gear oils and greases, even at temperatures up to 120 °C
- Short-term temperature resistance up to 150 °C

PRODUCT DATA

GEWITEX-WK-Spritzgrund



W11-702S Grey



Mixing ratio by weight

Not relevant



Demineralised water

GEWITEX-WK-Spritzgrund / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.3	60	< 5	(%)	(mL/kg)
				45	330
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption ¹⁾ (kg/m²)	Spreading rate (m²/kg)	
	40	89	0.120	8.3	

1) Theoretical consumption related on a smooth surface. Depending on surface roughness and processing losses, different consumption data will be achieved in practice.

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application ²⁾

Application viscosity (s) (4 mm DIN cup)	40 to 60	40 to 60	40 to 60
Nozzle diameter (mm)	0.33 to 0.38	1.5 to 1.8	-
Material pressure (bar)	75 to 150	1.5 to 3.0	-
Atomiser pressure (bar)	1.0 to 2.5	3.0 to 4.0	-
DFT * per working operation (µm)	30 to 50	30 to 50	30 to 50
Addition of thinner (%)	-	2 to 5	-

* DFT = Dry Film Thickness

2) recommended only for smaller areas / touch-ups



Pot life

Not relevant

Drying/Curing times at 50 µm DFT

Ambient air temperature 20 °C



dust-free:

after 30 to 40 minutes



tack-free:

after approx. 120 minutes



overcoating interval / dry to handle:

after 48 hours

Notes referring to Directive 2004/42/EC "Decopaint-Directive"

Subcategory as referred to in Annex IIA	VOC limit values (Phase II from 2010)	Max. VOC content of the product in its ready-for-use condition (including the max. amount of diluents as given in "Application methods")
i ("One-pack performance coatings") Type WB	140 g/l	< 140 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel and cast iron substrates

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4,
Roughness grade medium (G) according to EN ISO 8503-1



Air and surface temperatures

15 to 35 °C



Relative humidity ≤ 80 %

Dew point distance ≥ 3 °C

Ensure sufficient air movement during drying

SAFETY MEASURES



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

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.