

GEWITEX-WK-Spritzgrund, W11-

1C-AC Hydro Primer

■ FIELDS OF APPLICATION

Quick-drying primer for spray application on cast iron, e.g. gearboxes.

■ PRODUCT PROPERTIES

GEWITEX-WK-Spritzgrund is specially adjusted for spray application. Primer coatings of GEWITEX-WK-Spritzgrund show excellent adhesion on cast iron.

Together with suitable top coatings corrosion protection systems for different demands can be attained.

GEWITEX-WK-Spritzgrund is air-drying, for industrial uses however we recommend a forced drying at 50 to 100°C.

Capacities

The fastness of the coating against stresses while being manufactured, e.g. filing works using cooling lubricants, followed by cleaning in laundering facilities, can be achieved only when complying with the drying conditions mentioned in the instructions for application.

When completely dried through, GEWITEX-WK-Spritzgrund is resistant against many gear-oils and grease even at temperatures up to 120 °C.

■ TECHNICAL DATA

Product Number W11-

Colour grey or white

Degree of Gloss matt

**Viscosity on delivery
(DIN 53211/4mm)** 40 to 60 seconds

Shelf life at least 6 months in original cans at normal temperature

Appropriate Thinner demineralised water

Theoretical parameters GEWITEX-WK-Spritzgrund

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)		Solid content by volume	
			per 10 µm DFT* (g/m²)	(%)	(mL/kg)
1,3	56	< 5	1,5	43	330
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
40	93	0,12		8,3	

Remarks

- All values are relevant for the mixture in case of two-pack materials
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour).
The values may differ slightly for other colours.
- * baseline for calculation: consumption in g/m² at DFT 10 µm

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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

Coating Systems

The choice of other primer- and top coatings and their number and film thickness depends on the stress to be expected, existing specifications and the methods of application.

We recommend to issue written specifications with different coating systems specially adapted to the various fields of application.

■ INSTRUCTIONS FOR APPLICATION

Surface Preparation

Steel and cast iron

Blast-cleaning in accordance with EN ISO 12944-4,
surface preparation grade Sa 2 ½

Aluminium and plastic surfaces

Aluminium and plastic surfaces must be dry and clean. Fat, oil, release agents and other impurities must be thoroughly removed.

Air and Surface temperature

Optimal results at temperatures of 18 to 25°C, not below 15°C
not above 30°C

Relative humidity

Optimal results: 40 to 60 %, max. 80 % relative humidity

The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air throughout the application.
(see basic specification for corrosion protection EN ISO 12944-7)

Application methods

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of demineralised water
High pressure/air spraying Nozzle diameter: 1.5 to 1,8 mm Air pressure: 3 to 4 bar Material pressure: 1,0 to 2,0 bar (pressure vessel) Viscosity: 40 to 60 Sec. / 4mm DIN 53211	30 to 40 µm	2 to 5 %

Remarks

- The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

Cleaning of equipment

Coating material (liquid paint): With water
Surface dried coating: With cleaning thinner V-407 or V-411 (only short term load of the equipment)

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Drying times	<u>Air drying at a temperature of approx. 20 °C:</u>
Dry to touch:	after 30 to 40 minutes
Tack free:	after approx. 2 hours
	<u>Accelerated drying:</u>
Flashing-off:	5 to 15 minutes at 40 °C
Drying:	20 to 30 minutes, 70 to 80 °C
Tack-free:	after cooling down

■ PROTECTIVE MEASURES

The relevant data concerning safety measures can be found in the material safety data sheet of this product.
The valid issue of the material safety data sheet is available from our website www.geholit-wiemer.de.

The statements made here are based on the present state of our knowledge. We can give no guarantee for consequences arising from the use of the material nor can we undertake responsibility for advice or statements made by our employees. To this extent the consultative activities of our employees are not binding. The supervision of construction, the maintaining of process guide lines and the observation of the recognised technical rules are a matter solely for the processor even if our employees are present at the time our material is being applied.
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