

## MAIN PRODUCT PROPERTIES

- 1C-AC hydro dipping primer on grey cast iron, e.g. gearboxes
- Specially adjusted for dip coating
- 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-Tauchgrund



W11-732 Grey





#### Mixing ratio by weight

Not relevant



Demineralised water

### GEWITEX-WK-Tauchgrund / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.3	58.0	5	(%)	(mL/kg)
				45	335
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption <sup>1)</sup> (kg/m²)	Spreading rate (m²/kg)	
	30	69	0.090	11.1	

1) 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



Flooding /  
dipping



Flooding /  
dipping



Roller/Brush  
application <sup>2)</sup>

Application viscosity (s) (4 mm DIN-cup)	16 to 18	18 to 22	40 to 60
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	15 to 25	25 to 40	30 to 50
Addition of thinner (%)	-	-	-

\* DFT = Dry Film Thickness

2) recommended only for smaller areas / touch-ups



**Pot life**

Not relevant

**Curing time at 25 µm DFT**

**Ambient temperature 20 °C**



dust-free:

after 30 to 40 minutes



tack-free:

after 60 to 75 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	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**

- 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](http://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.