


## MAIN PRODUCT-PROPERTIES

- 1C-AY Topcoat for high-grade corrosion protection of hot-dip galvanised steel constructions, e. g. girder masts, transforming stations of power supply industry
- Excellent adhesion on hot-dip galvanised steel parts
- Together with suitable priming coats also as topcoat in multi-layered systems for steel constructions of low alloyed steel
- Brush application will be recommended with a DFT of 80 µm

## PRODUCT DATA

WIEKORANT-A8B-DKX80		MIO-colours
	A8B-E7833 Cement grey approx. RAL 7033 A8B-E6601 Green DB 601 (other colours on request)	
	<b>Mixing ratio by weight</b> not relevant	
	Thinner V-76 (for brush application) Thinner V-27 (for spraying)	

WIEKORANT-A8B-DKX80		Guideline MIO-colours <sup>1)</sup>			
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	<b>1.35</b>	<b>70.0</b>	<b>30</b>	<b>49.0</b>	<b>365</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>100</b>	<b>211</b>	<b>8.3</b>	<b>0.275</b>	<b>3.6</b>

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m<sup>2</sup> at DFT 10 µm

3) 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



High pressure



Roller/Brush application




	Airless	High pressure	Roller/Brush application
Nozzle diameter (mm)	0.38 to 0.48	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3 to 5	-
DFT * per working operation (µm)	80	80	80
Addition of thinner (%)	2 to 5 (V-27)	8 to 10 (V-27)	0 to 2 (V-76)

\*) DFT = Dry film thickness

## COMMENTS ON PROCESSING



**Pot life**  
Not relevant

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
 dust-free:		after 60 to 75 minutes
 tack-free:		after 4 to 6 hours
 overcoating interval / dry to handle: dry to walk on:		after 8 to 10 hours after 3 to 5 days

### 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 SB	500 g/l	< 500 g/l

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Weathered, hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts, e. g. cleaning, washing, alkaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.  
The surface must have a uniform dull appearance after surface preparation.

#### Existing coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of old coatings compatibility tests are recommended



**Air and surface temperature**  
≥ 5 °C




relative humidity ≤ 80 %  
dew point distance ≥ 3 °C


## PAINT SYSTEMS

### EXAMPLES

**Substrate: hot-dip galvanised steel in accordance with EN ISO 1461 if applicable with old coating**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> ( $\mu\text{m}$ )
	<b>Optional Priming coat</b>	WIEKORANT-A2B-DKX-Grund	80
	<b>Monolayer</b>	WIEKORANT-A8B-DKX80	80

**Substrate: steel, blast-cleaning in surface preparation grade Sa 2 1/2 or mechanical respectively manual derusting PMA/St2 if applicable with old coating**

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> ( $\mu\text{m}$ )
	<b>Priming coats</b>	GEHOTEX-W5-Korrogrund GEHOLIT-K19B-Korrogrund in 1 to 2 working operations	40 to 60 each
	<b>Top coat</b>	WIEKORANT-A8B-DKX80	80

## 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).

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