MAIN PRODUCT-PROPERTIES

- **As a 1C-HS all season priming coat basically independent of temperature, humidity and dew point**
- **Excellent leveling properties and curing at difficult conditions**
- **High surface tolerance / compatibility to old coatings**
- **Very high spreading rate**
- **Together with WIEMERDUR-Z20AW and a dry film thickness of 160 µm suitable for corrosivity category C3, durability high**
- **Confirmation of suitability by Fraunhofer Institut IFAM, Bremen, report: KT-PB-110-15, A419862**

PRODUCT DATA

WIEMERDUR-Z10AW-Metallgrund

	Z10-309 oxide red RAL 3009 (other colours on request)
	Mixing ratio by weight Not relevant
	V-925

WIEMERDUR-Z10AW-Metallgrund / guidance levels practically determined

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.5	**83.0**	**5**	**72.5**	**485**

DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate (m²/kg)	Spreading rate (m²/L)
80	**110**	**0.165**	**6.1**	**9.1**

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C	**Airless**	**High pressure**	**Roller/Brush application**
Delivery viscosity (s) (8 mm DIN-cup)	**15 to 25**		
Delivery viscosity (mPas) (Epprecht, MKC 25 °C)	**250 to 350**		
Nozzle diameter (mm)	**0.43 to 0.53**	**2.0 to 3.0**	**-**
Material pressure (bar)	**200 to 300**	**-**	**-**
Atomiser pressure (bar)	**-**	**3.0 to 4.0**	**-**
DFT * per working operation (µm)	**120** [1)]	**80**	**80**
Addition of thinner (%)	**0 to 2**	**2 to 5**	**0 to 2**

* DFT = Dry Film Thickness

1) To achieve optical uniform surfaces by airless-spraying, dry film thicknesses of ≥ 120 µm are recommended

Pot life
Not relevant

Drying/Curing times at 80 µm DFT	**Ambient air temperature 20 °C Relative humidity ≥ 20 %**
touch dry:	after approx. 90 minutes
tack free:	after approx. 5 hours
overcoating interval: dry to handle: dry to walk on:	after 5 hours after 8 hours after 16 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 SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, alternatively
- Hand or power-tool cleaning at preparation grade St 2 according to EN ISO 12944-4

Weathered, hot-dip-galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts, e. g. cleaning, washing, alcaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
  After sweep blast-cleaning the surface shall have a uniform dull appearance.

Existing Priming coats or old coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- With partial signs of corrosion: Hand or power-tool cleaning at preparation grade PMa respectively PSt 2 according to EN ISO 12944-4
- Before overcoating of unknown Priming coats compatibility tests are recommended

Air and surface temperature
≥ -5 °

Relative humidity ≥ 20 %
Can be processed under dew point conditions! – Surface maximum dewy
Not permitted: rain, standing water, ripe, ice

Remove standing water, visible rain- and water drops using compressed air respectively microfiber cloths or similar

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4, if applicable with old coatings

	Product(s) (other paint systems on request)	NDFT (µm)
Priming coat	WIEMERDUR-Z10AW-Metallgrund	80
Top coat	WIEMERDUR-Z20AW	80

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

	Product(s) (other paint systems on request)	NDFT (µm)
Priming coats	WIEMERDUR-Z10AW-Metallgrund	80
Top coat	WIEMERDUR-Z20AW	80

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES

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