

## WIEREGEN-ACU-Metallgrund

**2C-PUR Primer**  
**light grey, M4-702**  
**white, M4-940**

■ **FIELDS OF APPLICATION** Anticorrosive primers for subsequent two-pack-systems on polyurethane-base applied on machines, gear boxes, installations and equipment in aggressive atmosphere, nuclear power plants etc.

■ **PRODUCT PROPERTIES** WIEREGEN-ACU-Metallgrund contains a polyacrylate binder with a special polyisocyanate as a curing agent.

**Capacities** Due to their composition it is excellently suitable as primer coatings in subsequent two-pack corrosion protection systems. Together with corresponding two-pack top-coatings paint systems will be obtained with excellent resistance against chemicals and aggressive atmosphere as well as a high resistance to the effects of natural weathering and light.

Temperature resistance (dry heat): 120 °C  
(150 °C short term resistance)

■ **TECHNICAL DATA** WIEREGEN-ACU-Metallgrund Curing agent

**Product Number** M4-702, light grey DX-14  
M4-940, white

**Mixing ratio** 10 parts by weight 1 part by weight

**Shelf life** at least 12 months in original cans at normal temperature

**Appropriate Thinner** V-562

**Theoretical parameters** WIEREGEN-ACU-Metallgrund light grey M4-702

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m <sup>2</sup> )	(%)	(mL/kg)
1.5	70	30	9	50	338
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )		Spreading rate (m <sup>2</sup> /kg)	
60	120	0.180		5.6	

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/m<sup>2</sup> at DFT 10 µm

**Suitable coating systems** The choice of primers and their number and thickness of layer is depend on the stress to be expected, existing prescriptions and application methods.

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

WIEREGEN-ACU-Metallgrund

**2C-PUR Primer**  
light grey, M4-702  
white, M4-940

■ **INSTRUCTIONS FOR APPLICATION**

**Surface Preparation**

The surfaces and the primers must be dry and clean. Oil, fat and other kinds of contamination must be thoroughly removed.

**Air and surface temperature**

Optimal results at temperatures of 15 to 25 °C, not below 10 °C

**Relative humidity**

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)

**Comments on processing**

**Mixing**

Mix thoroughly with the enclosed quantity of curing agent, preferably with a mechanical mixer. Material must be stirred again after 15 minutes. Then the mixture is ready for use.

**Application methods**

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner V-562
Airmix spraying Nozzle diameter 0.28 to 0.33 mm Material pressure 80 to 120 bar Atomiser pressure 1 to 2 bar	60	10 to 15 %
High pressure/air spraying Nozzle diameter 1.3 to 1.8 mm Atomiser pressure 4 to 5 bar	60	10 to 15 %

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.

**Cleansing of equipment** use thinner V-562

**Pot life** 4 to 6 hours (dependent on temperature)

**Drying times**

Related to a temperature of 20 °C and 60 µm of dry film

Dry to touch: after approximately 30 minutes

Tack free: after 2 to 3 hours

Ready for re-coating: after 12 to 16 hours

WIEREGEN-ACU-Metallgrund can be cured more quickly at increased temperatures e.g. 30 minutes at 70 °C

■ **SAFETY 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](http://www.geholit-wiemer.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 of 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.