

MAIN PRODUCT PROPERTIES

- 2-pack PUR primer for subsequent high-gloss top coats, e.g., WIEREGEN-M77N, WIEREGEN-M177
- Typical application areas: building machines, mobile cranes, ACE with high optical demands

PRODUCT DATA

WIEREGEN-ACU-Metallgrund



M4-708 Grey
(other colours on request)





Mixing ratio by weight

14:1 with curing agent DX-10



Thinner V-562

WIEREGEN-ACU-Metallgrund / Guide values

|  | Density (g/mL) | Solid content (weight %) | VOC-content (weight %) | Solid content by volume | |
|---|-------------------|---------------------------------------|---------------------------|-------------------------|---------|
| | 1.35 | 69 | 31 | (%) | (mL/kg) |
|  | DFT * (µm) | Calculated wet-film thickness (µm) | Consumption (kg/m²) | Spreading rate | |
| | 50 | 95 | 0.128 | (m²/kg) | |

PROCESSING INSTRUCTIONS

Recommendation at
temperatures
of approx. 20 °C



Airmix



**High
pressure**



**Roller/Brush
application ¹⁾**

| | Airmix | High pressure | Roller/Brush application ¹⁾ |
|---|--------------|------------------|---|
| Application viscosity (s) (4 mm DIN cup) | 25 to 30 | 25 to 30 | 8 to 10 (8 mm DIN cup) |
| Nozzle diameter (mm) Spraying angle (degree) | 0.33 to 0.38 | 1.2 to 1.5 | - |
| Material pressure (bar) | 70 to 90 | - | - |
| Atomiser pressure (bar) | 1.5 to 2.5 | 3.0 to 4.0 | - |
| DFT ²⁾ | 50 | 50 | 50 |
| Addition of thinner (%) | 15 to 20 | 10 to 15 | 0 to 2 |






Pot life

4 to 6 hours (at 20-25 °C)

1) only recommended for smaller surfaces

2) DFT = Dry Film Thickness

| Drying/curing times at 50 µm DFT | | Ambient air temperature 20 °C |
|---|-----------------------|-------------------------------|
|  | touch-dry: | after approx. 30 minutes |
|  | tack-free: | after approx. 2 to 3 hours |
|  | overcoating interval: | after approx. 8 hours |

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and grey cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

Hot-dip galvanised steel surfaces and aluminium / cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation load:
Sweep blast cleaning according to EN ISO 12944-4
After sweep blast cleaning, the surface must have a uniformly dull appearance.
- Chemical conversion layers (chromate, chromate-free, phosphating)



Air and surface temperature

optimal at 15 to 25 °C, not below 10 °C, not above 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

| | | Product(s) (other paint systems on request) |
|---|---------------------|---|
|  | Priming coat | WIEREGEN-ACU-Metallgrund, M4-708 |
| | Top coat | WIEREGEN-M77N WIEREGEN-M177 WIEREGEN-M163 |

SAFETY MEASURES



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

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