

#### **TECHNICAL INFORMATION**

Page 1/2 - Nov. 2023 / Vers. 2 **Industrial Coatings** 

# WIEREGEN-D133S-Struktur

**2C-PUR Structure Coating** 

## **MAIN PRODUCT-PROPERTIES**

- Monolayer 2C-PUR structure coating with high mechanical and chemical durability
- Different structures realizable
- **Excellent absorption of overspray**

#### PRODUCT DATA

#### WIEREGEN-D133S-Struktur, satin glossy



D133S-S....(RAL-colours, other colours on request)



## Mixing ratio by weight

6:1 with curing agent DX-10



Thinner V-562 (Standard: air temperature 5 to 25 °C) Thinner V-560 (Slow: air temperature 25 to 40 °C)

#### WIEREGEN-D133S-Struktur / Guide values

7	8	9	÷
4	5	6	X
1	2	3	÷

Density (g/mL) 1.40

100

DFT \* (µm)

Solid content (weight %) 77.0

Calculated wet-film thickness (µm) 153

VOC-content (weight %) 23.0

Consumption (kg/m<sup>2</sup>) 0.220

Solid content by volume (%) (mL//kg) 63.0 450

> Spreading rate (m<sup>2</sup>/kg) 4.5

## **COMMENTS ON PROCESSING**

Recommendation at temperatures of approx. 20 °C

Application viscosity (s)





High



Roller/Brush

application

irmix 1)	High	
	pressure	

12 to 16	12 to 16
20+030	_

(8 mm DIN-cup)	12 10 16	12 10 10	12 10 10
Nozzle diameter (mm)	0.33 to 0.43	2.0 to 3.0	-
Material pressure (bar)	150 to 200	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	
DFT * per working operation (µm)	100	100	80
Addition of thinner (%)	0 to 2	0 to 2	0 to 4

<sup>1)</sup> only recommended for precoating in multi-layer process



#### Pot life

75 to 90 minutes (relating to temperature)

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<sup>\*</sup> DFT = Dry Film Thickness



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# WIEREGEN-D133S-Struktur 2C-PUR Structure Coating

Drying/Curing times at 100 μm DFT	Ambient air temperature 20 °C
touch dry:	after 20 minutes
tack free:	after 3 to 4 hours
ready for overcoating / handling:	after 5 to 6 hours

# INSTRUCTIONS FOR APPLICATION

#### Surface preparation

#### Steel surfaces and 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 12944-4,

#### Hot-dip galvanised steel surfaces and aluminium/cast aluminium

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



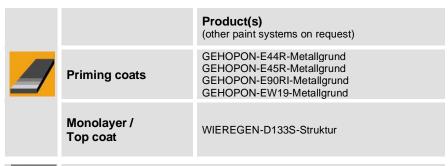
#### Air and surface temperature

optimal between 15 and 25 °C, not below 5 °C, not above 40 °C



max. 80 % relative humidity

# PAINT SYSTEMS EXAMPLES



### **SAFETY MEASURES**



The relevant data can be found in the current material safety data sheets, available at 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 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.

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