

## **TECHNICAL INFORMATION**

Page 1/2 - Sept. 2024 / Vers. 6 **Industrial Coatings** 

## WIEREGEN-D54R

2C-PUR-HS Monolayer, quick curing

## **MAIN PRODUCT PROPERTIES**

- Ready for packaging after 180 minutes curing at 20 °C
- Excellent mechanical stability, high scratch resistance
- High chemical resistance to oils, cleaning agents, and acids
- Excellent adhesion on multi substrate surfaces
- Before overcoating of fully cured coatings with WIEREGEN-D54R grinding is recommended

### PRODUCT DATA

## WIEREGEN-D54R, satin glossy



D54R-S.... (RAL-colours, other colours on request)



# Mixing ratio by weight

5:1 with curing agent DX-10



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

## WIEREGEN-D54R / Guideline

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Density (g/mL) 1.35 DFT \*

(µm)

120

Solid content (weight %) 78.0 Calculated wet-film

180

Consumption thickness (µm) (kg/m²) 0.245

VOC-content

(weight %)

22 N

Solid content by volume (mL//kg) 67.0 495

Spreading rate  $(m^2/kg)$ 4.1

# **COMMENTS ON PROCESSING**

Recommendation at temperatures of approx. 20 °C







Airmix	

High
oressure

Roller/Brush application

		•	• •
Application viscosity (s) (4 mm DIN-cup)	55 to 70	55 to 70	55 to 70
Nozzle diameter (mm)	0.28 to 0.33	1.5 to 2.0	-
Material pressure (bar)	120 to 150	-	-
Atomiser pressure (bar)	1.5 to 2.0	3.0 to 5.0	-
DFT * per working operation (µm)	120	120	40
Addition of thinner (%)	0 to 3	0 to 3	0 to 3



#### Pot life

45 to 60 minutes (relating on 20 to 25 °C)

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



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Drying/Curing times at 120 μm DFT	Ambient air temperature 20 °C	
touch dry:	after 40 minutes	
tack free:	after 80 minutes	
ready for overcoating/handling:	after 180 minutes	

# **INSTRUCTIONS** FOR APPLICATION

## Surface preparation

#### Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 1/2 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: Sweep blast-cleaning according to EN ISO 12944-4. After sweep blast-cleaning the surface shall have a uniform dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



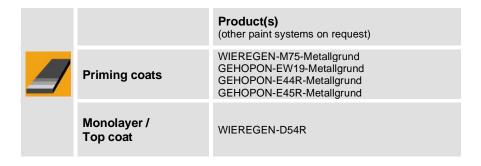
#### Air and surface temperature

optimal at 15 to 25 °C, not below 5 °C, not over 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.

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This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.

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