

## MAIN PRODUCT-PROPERTIES

- Ready for packaging after 90 minutes curing at 20 °C
- Excellent mechanical stability, high scratch resistance
- 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

4:1 with curing agent DX-54R



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

### WIEREGEN-D54R / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	<b>1.30</b>	<b>75.5</b>	<b>24.5</b>	<b>63.0</b>	<b>485</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	<b>120</b>	<b>190</b>	<b>0.250</b>	<b>4.0</b>	

## COMMENTS ON PROCESSING

Recommendation at  
temperatures  
of approx. 20 °C



**Airmix**



**High  
pressure**



**Roller/Brush  
application**




<b>Application viscosity (s)</b> (4 mm DIN-cup)	<b>50 to 65</b>	<b>50 to 65</b>	<b>50</b>
<b>Nozzle diameter (mm)</b>	<b>0.28 to 0.33</b>	<b>1.5 to 2.0</b>	<b>-</b>
<b>Material pressure (bar)</b>	<b>120 to 150</b>	<b>-</b>	<b>-</b>
<b>Atomiser pressure (bar)</b>	<b>1.5 to 2.0</b>	<b>3.0 to 5.0</b>	<b>-</b>
<b>DFT * per working operation (µm)</b>	<b>120</b>	<b>120</b>	<b>40</b>
<b>Addition of thinner (%)</b>	<b>0</b>	<b>0</b>	<b>0</b>



#### Pot life

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

\* DFT = Dry Film Thickness

Drying/Curing times at 120 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 30 minutes
	tack free:	after 60 minutes
	ready for overcoating/handling:	after 90 minutes

## 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 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

	Product(s) (other paint systems on request)
 <b>Priming coats</b>	WIEREGEN-M75-Metallgrund GEHOPON-EW 19-Metallgrund GEHOPON-E44R-Metallgrund GEHOPON-E45R-Metallgrund
<b>Monolayer / Top coat</b>	WIEREGEN-D54R

## SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at [www.geholti-wierner.de](http://www.geholti-wierner.de).

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