

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

5:1 with curing agent DX-29



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	
	1.35	78.0	22.0	(%)	(mL/kg)
				67.0	495
	DFT * (µm)	Calculated wet film thickness (µm)	Consumption (kg/m²)	Spreading rate	
	120	179	0.245	(m²/kg)	
				4.1	

COMMENTS ON PROCESSING

Recommendation at
temperatures
of approx. 20 °C



Airmix



High pressure



Roller/Brush application




	Airmix	High pressure	Roller/Brush application
Application viscosity (s) (4 mm DIN-cup)	55 to 70	55 to 70	55 bis 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 (at 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 2½ 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 must have a uniformly dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



Air and surface temperature

optimal at 15 to 25 °C, not below 5 °C, not above 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

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

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.