

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

WIIEGEN-D54R, satin glossy



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




Mixing ratio by weight

4:1 with curing agent DX-30



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

WIIEGEN-D54R / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.3	75.0	25.0	63.0	485
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	120	190	0.250	4.0	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application




Application viscosity (s) (4 mm DIN-cup)	50 to 65	50 to 65	50 to 65
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 5	0 to 5	0 to 5



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 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 over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

	Product(s) (other paint systems on request)
 Priming coats	WIIEGEN-M75-Metallgrund GEHOPON-EW19-Metallgrund GEHOPON-E44R-Metallgrund GEHOPON-E45R-Metallgrund
Monolayer / Top coat	WIIEGEN-D54R

SAFETY MEASURES



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

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