

WIEREGEN-D80-Compact
- hints for application -

Coating system for guard rails
(film thickness 2 to 3 mm) according to ZTV-RHD-ST

Pos.	Products and services	Theoretical consumption (kg/m ²)												
1	<p>Surface preparation</p> <p>Blast-cleaning in surface preparation grade Sa 2 ½ according to EN ISO 12944-4. The priming coat should be applied immediately after blast-cleaning.</p>													
2	<p>Priming coat</p> <p>GEHOPON-E24-Metallgrund based on 2C-Epoxy-Zinc phosphate</p> <p>Minimum dry film thickness: 80 µm The priming coat must not be scattered.</p> <table border="1"> <thead> <tr> <th>Processing times</th> <th>at +12 °C</th> <th>at +30 °C</th> </tr> </thead> <tbody> <tr> <td>Pot life / processability</td> <td>12 h</td> <td>6 h</td> </tr> <tr> <td>Water resistance after</td> <td>approx. 24 h</td> <td>approx. 12 h</td> </tr> <tr> <td>Over-coating after</td> <td>min. 24 h</td> <td>min. 8 h</td> </tr> </tbody> </table>	Processing times	at +12 °C	at +30 °C	Pot life / processability	12 h	6 h	Water resistance after	approx. 24 h	approx. 12 h	Over-coating after	min. 24 h	min. 8 h	<p>theoretical: 0.225 practical: 0.3 bis 0.5</p>
Processing times	at +12 °C	at +30 °C												
Pot life / processability	12 h	6 h												
Water resistance after	approx. 24 h	approx. 12 h												
Over-coating after	min. 24 h	min. 8 h												
3	<p>RHD-layer</p> <p>WIEREGEN-D80-Compact grey, D80-7201 based on 2C-Polyurethane plus standardising agent RS 225, max. 2 weight-% based on component A</p> <p>1 : 1 filled with quartz sand with grain size of 0.6 to 1.2 mm</p> <p>Scatter the fresh coating in excess with quartz sand with a grain size of 0.6 to 1.2 mm</p> <p>(Please note for overlaps in the guard rails appendix 2 of ZTV-RHD-ST "overlaps in the guard rails area")</p> <table border="1"> <thead> <tr> <th>Processing times</th> <th>at +12 °C</th> <th>at +30 °C</th> </tr> </thead> <tbody> <tr> <td>Pot life / processability</td> <td>60 min</td> <td>30 min</td> </tr> <tr> <td>Water resistance after</td> <td>approx. 36 h</td> <td>approx. 16 h</td> </tr> </tbody> </table>	Processing times	at +12 °C	at +30 °C	Pot life / processability	60 min	30 min	Water resistance after	approx. 36 h	approx. 16 h	<p>approx. 0.9 per mm</p> <p>approx. 0.9 per mm</p> <p>Total consumption: 8 to 10 kg; approx. 4 kg remain</p>			
Processing times	at +12 °C	at +30 °C												
Pot life / processability	60 min	30 min												
Water resistance after	approx. 36 h	approx. 16 h												
4	<p>Optional position: sealant</p> <p>WIEREGEN-M80-Compact-Finish Pepple grey approx. RAL 7032, M80-F7532</p>	<p>0.7 to 0.9</p>												

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Comments on consumption and determination of dry film thickness

- The full scattering goes down in the total dry film thickness with 1 to 2 mm.
- We recommend, at a given nominal dry film thickness of e. g. 3 mm (for the whole coating) to calculate with a dry film thickness *without* scattering of approx. 2 mm (as $2 \times 1.8 \text{ kg/m}^2 = 3.6 \text{ kg/m}^2$ of mixture WIEREGEN-D80-Compact plus supplement).
- The measurement of the dry film thickness must be carried out in accordance with ZTV-RHD-ST, in such a way that half the diameter of the maximum grain size must be subtracted from the measured value above the scattering (then 0.6 mm for quartz sand).
- For calculation it has to be considered, that irregularities, such as roughness in the sheet metal, at the weldings and in the layer itself, considerable additional consumptions amounts compared to the theoretical consumption amounts related to the nominal dry film thickness can occur. (s. ZTV-RHD-ST item 5.4)

Comments on processing

Please also note the appropriate technical information for the priming coat GEHOPON-E24-Metallgrund.

Mixing

Mix GEHOPON-E24-Metallgrund homogeneously with the appropriate packaged curing agent EX-4. After a waiting period of 15 minutes stirr again and the mixture is ready to use.

Mix WIEREGEN-D80-Compact with the appropriate packaged curing agent DX-16. After repotting, add the respective supplements and mix thoroughly and homogeneously in a mechanical stirrer (compulsory stirrer). The material is then ready for use.

Application methods

GEHOPON-E24-Metallgrund: (Airless-)spraying, roller coating, brush application. Adjustment of processing viscosity with thinner V-538.

WIEREGEN-D80-Compact can be applied by trowel or wide spatula.

Revision after longer waiting period

If the maximum waiting period between the individual films specified on page 1 or in the technical information are exceeded, please ask the manufacturer. We generally recommend:

GEHOPON-E24-Metallgrund: grinding / sweeping and cleaning; if applicable apply additional priming coat.

WIEREGEN-D80-Compact: cleaning, e. g. by water jet

Cleaning of equipment

GEHOPON-E24-Metallgrund: thinner V-538

WIEREGEN-D80-Compact: thinner V-74

Cured material must be removed mechanically.

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 of 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.