

MAIN PRODUCT-PROPERTIES

- High-grade, moisture-curing polyurethane zinc-rich priming coat for touch-up of small defects of hot-dip galvanised steel components according to EN ISO 1461
- Nominal dry film thickness of 100 to 120 µm in 1 to 2 working operations
- Maximum dry film thickness: 150 µm
- Temperature resistance up to 160 °C
- Adjusted particularly for brush application

PRODUCT DATA

WIEREGEN-DF35-Zink



F35-717 Grey




Mixing ratio by weight

not relevant



Thinner V-562

WIEREGEN-DF35-Zink / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	2.15	79.0	21.0	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	100	206	9.3	0.445	2.2

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m² at DFT 10 µm

3) Theoretical consumption related on a smooth surface. Dependent on surface roughness and processing losses different consumption data will be achieved in practice

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airless



High pressure



Roller/Brush application ⁴⁾

Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	80 to 120
Addition of thinner (%)	-	-	0 to 1




4) only recommended for smaller areas

* DFT = Dry Film Thickness



Pot life

Process opened cans on the same day
respectively protect from humidity

Drying/Curing times at 100 µm DFT Relative humidity 60 to 80 %		Ambient air temperature		
		5 °C	15 °C	30 °C
	dust-free:	after approx. 40 minutes	after approx. 20 minutes	after approx. 15 minutes
	tack-free:	after approx. 60 minutes	after approx. 30 minutes	after approx. 20 minutes
	dry to handle:	≤ 2 hours	≤ 1 hour	≤ 1 hour
	overcoating interval:	≥ 48 hours	≥ 20 hours	≥ 16 hours

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
i ("One-pack performance coatings") Type SB	500 g/l	< 500 g/l

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, alternatively
- Partial mechanical grinding PMA according to EN ISO 12944-4

Hot-dip galvanised steel surfaces

- Transition zones steel/galvanised steel - sweep-blast-cleaning according to EN ISO 12944-4 is recommended, alternatively
- Remove adhesion-reducing substances and zinc reaction products through suitable measures



Air and surface temperature

≥ 5 °C



relative humidity ≥ 40 %, dew point distance ≥ 3 °C

Further details for processing and execution is described in the relevant applicable instructions

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coat	WIEREGEN-DF35-Zink	100 to 120

SAFETY MEASURES



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

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