

## MAIN PRODUCT-PROPERTIES

- Two-pack Monolayer for machines and apparatus construction for dry film thicknesses of 40 to 60  $\mu\text{m}$
- Together with suitable priming coats also appropriate for higher corrosion stresses

## PRODUCT DATA

### WIEREGEN-DW52, satin glossy



DW52-S7021 (RAL-colours, other colours on request)



#### Mixing ratio by weight

8:1 with curing agent DZ-53



Demineralised water

### WIEREGEN-DW52 / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.35	66.0	< 4	55.0	405
	DFT * ( $\mu\text{m}$ )	Calculated wet-film thickness ( $\mu\text{m}$ )	Consumption (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	60	110	0.150	6.7	

## COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



High pressure



Pressure tank



Roller/Brush application




Application viscosity (s) (6 mm DIN-cup)	10 to 15	12 to 18	15 to 20
Nozzle diameter (mm)	1.5 to 1.8	1.5 to 1.8	-
Material pressure (bar)	-	3.0 to 5.0	-
Atomiser pressure (bar)	3.0 to 4.0	3.0 to 4.0	-
DFT * per working operation ( $\mu\text{m}$ )	50 to 70	50 to 70	40 to 60
Addition of thinner (%)	5 to 10	0 to 5	0



#### Pot life

approx. 2 hours (relating to temperature)

\* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 45 minutes
	tack free:	after approx. 4.5 hours
	ready for overcoating/handling:	after approx. 16 hours

## 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

#### Strip 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 10 °C, not over 40 °C



max. 80 % relative humidity

## PAINT SYSTEMS

### EXAMPLES

		Product(s) (other paint systems on request)
	<b>Priming coats</b>	GEHOPON-EW18-Metallgrund GEHOPON-EW19-Metallgrund
	<b>Monolayer / Top coat</b>	WIEREGEN-DW52

## SAFETY MEASURES



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

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