

MAIN PRODUCT-PROPERTIES

- At industrial production process also usable as a monolayer at low corrosion stress
- Together with suitable priming coats for high-grade paint systems also for high corrosion stress up to C5 according to EN ISO 12944-2
- Before overcoating of fully cured coatings with WIEREGEN-DW54 grinding is recommended

PRODUCT DATA

WIEREGEN-DW54, flat



DW54-F... (RAL-colours, other colours on request)




Mixing ratio by weight

7:1 with curing agent DZ-13



Demineralised water

WIEREGEN-DW54 / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.3	62.5	< 3.0	51.0	395
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	80	157	0.205	4.9	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airless/
Airmix



High
pressure



Roller/Brush
application




	Airless/ Airmix	High pressure	Roller/Brush application
Application viscosity (s) (6 mm DIN-cup)	20 to 30	10 to 15	20 to 30
Nozzle diameter (mm)	0.33 to 0.58	1.5 to 1.8	-
Material pressure (bar)	120 to 200	-	-
Atomiser pressure (bar)	-	4.0 to 5.0	-
DFT * per working operation (µm)	80	80	40 to 60
Addition of thinner (%)	0 to 3	3 to 6	0 to 3



Pot life

2 hours at 20 °C (relating to temperature)

* DFT = Dry Film Thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 50 minutes
	tack free:	after approx. 4 hours
	ready for overcoating/handling:	after approx. 10 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating, alternatively
- 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, alternatively
- Chemical conversion layer (chromate, chromate free, phosphating)



Air and surface temperature

10 to 40 °C



Relative humidity ≤ 80 %
Dew point distance ≥ 3 °C

PAINT SYSTEMS

EXAMPLES

	Product(s) (other paint systems on request)
 Priming coats	GEHOPON-EW18-Metallgrund GEHOPON-EW19-Metallgrund GEHOTEX-W92-Metallgrund
Monolayer / Top coat	WIEREGEN-DW54

SAFETY MEASURES



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

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