





## MAIN PRODUCT-PROPERTIES

- High-grade 2C-PUR protective coating with very fast curing and ready to handle
- With nominal dry film thicknesses of 80 to 120 µm suitable for corrosivity category C1, C2 and C3, expected durability medium
- Together with appropriate top coats for higher corrosion stress in multi-layered systems
- Excellent recoatability after cleaning of the surface
- Functional suitable for touch-up of steel parts applied in the shop with WIEREGEN-M155RN and WIEREGEN-M155R

## PRODUCT DATA

WIEREGEN-M155R	RAL-colours, flat
	M155R-F.... flat (RAL-colours, others on request)
	<b>Mixing ratio by weight</b> 20:1 with curing agent DX-10
	Thinner V-89

WIEREGEN-M155R	Guideline RAL-colours <sup>1)</sup>				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
	<b>1.5</b>	<b>75.0</b>	<b>25.0</b>	<b>56,0</b>	<b>375</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>100</b>	<b>178</b>	<b>6.7</b>	<b>0.265</b>	<b>3.8</b>

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

2) Based on consumption in g/m<sup>2</sup> 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 <sup>4)</sup>**

<b>Nozzle diameter (mm)</b>	<b>0.38 to 0.58</b>	<b>1.8 to 2.0</b>	-
<b>Material pressure (bar)</b>	<b>250 to 350</b>	-	-
<b>Atomiser pressure (bar)</b>	-	<b>4.0 to 6.0</b>	-
<b>DFT * per working operation (µm)</b>	<b>80 to 120</b>	<b>80 to 120</b>	<b>80</b>
<b>Addition of thinner (%)</b>	<b>0 to 2</b>	<b>5 to 8</b>	<b>0 to 4</b>

\*) DFT = Dry film thickness

4) recommended only for smaller areas

	<b>Pot life at</b>	<b>10 °C</b>	<b>20 °C</b>	<b>30 °C</b>
		7 to 8 hours	5 to 6 hours	3 to 4 hours

<b>Drying/Curing times at 100 µm DFT</b>		<b>Ambient air temperature</b>		
		<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
	dust-free:	after approx. 45 minutes	after approx. 30 minutes	after approx. 20 minutes
	tack-free:	after 2 to 3 hours	after 1 to 2 hours	after 75 to 90 minutes
	Overcoating interval / dry to handle:	after approx. 6 hours	after approx. 4 hours	after approx. 3 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)	
J ("Two-pack reactive 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

	<b>Air and surface temperature</b> ≥ 5 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C

## PAINT SYSTEMS

### EXAMPLES

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

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> (µm)
	<b>Protective coat</b>	WIEREGEN-M155R	100
	<b>Optional Top coats</b>	WIEREGEN-M87 WIEREGEN-M97R GEHOTEX-W92	80

Several coating systems for the corrosivity categories C2 to C5 according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

## SAFETY MEASURES



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

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