

## MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Suitable for electrostatic spraying methods
- Together with WIEREGEN-M165R (WIEREGEN-M166R respectively WIEREGEN-M167R) in coating systems with higher corrosivity stress

## PRODUCT DATA

### WIEREGEN-M162R-Metallgrund



M162R-735 Light grey approx. RAL 7035 (other colour shades on request)




#### Mixing ratio by weight

16:1 with curing agent DX-4



Thinner V-562 (Standard: air temperature 5 to 25 °C)  
Thinner V-89 (Slow: air temperature 20 to 35 °C)

### WIEREGEN-M162R-Metallgrund / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	<b>1.55</b>	<b>75.0</b>	<b>25.0</b>	<b>56.0</b>	<b>365</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	<b>80</b>	<b>144</b>	<b>0.220</b>	<b>4.5</b>	

## PROCESSING INSTRUCTIONS

Recommendation at temperatures of approx. 20 °C



**Airmix**



**High pressure**



**Roller/brush application**




<b>Application viscosity (s)</b> (8 mm DIN-cup)	<b>8 to 12</b>	<b>6 to 8</b>	<b>6 to 12</b>
<b>Nozzle diameter (mm)</b>	<b>0.28 to 0.33</b>	<b>1.5 to 2.0</b>	<b>-</b>
<b>Material pressure (bar)</b>	<b>80 to 100</b>	<b>-</b>	<b>-</b>
<b>Atomiser pressure (bar)</b>	<b>1.5 to 2.5</b>	<b>3.0 to 5.0</b>	<b>-</b>
<b>DFT * per working operation (µm)</b>	<b>80 to 100</b>	<b>80 to 100</b>	<b>60</b>
<b>Addition of thinner (%)</b>	<b>0 to 3</b>	<b>3 to 5</b>	<b>0 to 5</b>



#### Pot life

40 to 60 minutes (depending on temperature)

\* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 30 minutes
	tack free:	after 1.5 hours
	ready for overcoating/handling:	after 4 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

#### Hot-dip 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 5 °C, not above 40 °C



max. 80 % relative humidity

## PAINT SYSTEMS

### EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	WIEREGEN-M162R-Metallgrund
	Monolayer / Top coats	WIEREGEN-M162R WIEREGEN-M165R WIEREGEN-M166R WIEREGEN-M167R

## SAFETY MEASURES



The relevant data can be found in the current Material Safety Data Sheets, available at [www.geholit-wiemer.de](http://www.geholit-wiemer.de).

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