

MAIN PRODUCT-PROPERTIES

- Glossy 2C-PUR Monolayer for nominal dry film thicknesses up to 100 µm for corrosivity category C1, C2 and C3 durability medium
- In combination with suitable priming coats also appropriate for higher corrosivity stress

PRODUCT DATA

WIEREGEN-M163, glossy



M163-G.... (RAL-colours, other colours on request)




Mixing ratio by weight

7:1 with curing agent DX-10



Thinner V-508 (Standard: air temperature 5 to 25 °C)
Thinner V-560 (Slow: air temperature 25 to 40 °C)

WIEREGEN-M163 / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.40	76.0	24.0	62.0	440
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	100	160	0.230	4.3	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



Airless



High pressure




Application viscosity (s) (4 mm DIN-cup)	30 to 40	30 to 40	30 to 40
Nozzle diameter (mm)	0.33 to 0.43	0.33 to 0.43	1.5 to 1.8
Material pressure (bar)	150 to 200	200 to 250	-
Atomiser pressure (bar)	2.5 to 3.5	-	3.0 to 4.0
DFT * per working operation (µm)	100	100	100
Addition of thinner (%)	8 to 12	8 to 12	8 to 12



Pot life

2 hours (relating to 20 °C)

* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 30 minutes
	tack free:	after approx. 4 hours
	ready for overcoating/handling:	after approx. 14 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

Optional Primer (see below)

- Remove adhesion-reducing substances
- Before overcoating other priming coats compatibility tests are recommended



Air and surface temperature

optimal at 15 to 25 °C, not below 5 °C, not over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

	Product(s) (other paint systems on request)
 Priming coats	GEHOPON-E45R-Metallgrund WIEREGEN-M75-Metallgrund
Monolayer / Top coat	WIEREGEN-M163

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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