

WIEREGEN-M165R
- Advice for structure coating -

2C-PUR Monolayer, quick curing, ESTA

Advice for structure coating

Coating material: **WIEREGEN-M165R, satin glossy**
M165R-S.....(depending on colour)

Viscosity parameters

Viscosity of delivery: **10 - 12 s / 8 mm flowcup (after mixing)**
Spraying viscosity/Pre-coating: **50 - 60 s / 4 mm flowcup (after mixing)**

Application parameters

Pre-coating:	Application:	air spray system	air-combi
	Material pressure:	1.0 – 2.0 bar	80 - 120 bar
	Nozzle diameter:	1.5 – 2.5 mm	0.28 – 0.33 mm
	Atomizer pressure:	3.0 – 4.0 bar	1.5 – 2.0 bar
	Cross coat :	1.0 – 2.0	1.0 – 2.0

Flash-off-time: **30 minutes at ambient temperature 20 °C**

Spraying viscosity/Structure coating: **10 – 12 s / 8 mm flowcup (after mixing)**

Structure coating:	Application:	air spray system
	Material pressure:	0.5 – 1.0 bar (pressurized cup) 2.5 – 4.0 bar (piston pump, diaphragm pump, pressure tank)
	Nozzle diameter:	1.5 – 2.5 mm
	Atomizer pressure:	2.0 – 3.0 bar
	Cross coat:	1.0 – 1.5

A typical structure coating (spot effects) can generally only be achieved by low pressure system (pressure spraying). For vernier adjustment of different structure effects with perpetuation of a practical working speed, airbrush with integrated air micrometer are recommended.

Please note:

At spraying with airless and air-combi application usually only orange peel effects can be achieved.

Important: The formation and kind of the structural effect strongly depends on the spraying application parameters.
Please contact us for more information.

Dry film thickness: **60 µm – 120 µm** depending on structure

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