

MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Excellent for electrostatic spraying methods and nominal dry film thicknesses of 120 µm
- All-purpose applicable for many application areas

PRODUCT DATA

WIEREGEN-M165R, satin glossy



M165R-S.... (RAL-colours, other colours on request)



Mixing ratio by weight

18:1 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-M165R / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.55	75.0	25.0	56.0	360
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	100	179	0.275	3.6	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



**Airmix/
Airless**



**High
pressure**



**Roller/Brush
application**




Application viscosity (s) (4 mm DIN-cup)	80 to 120	60 to 100	90 to 120
Nozzle diameter (mm)	0.33 to 0.48	1.5 to 2.0	-
Material pressure (bar)	100 to 150	-	-
Atomiser pressure (bar)	1.5 to 2.0	3.0 to 5.0	-
DFT * per working operation (µm)	100	100	60
Addition of thinner (%)	0 to 5	3 to 7	0 to 4



Pot life

4 to 6 hours (relating to temperature)

* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 45 minutes
	tack free:	after 3 to 4 hours
	ready for overcoating/handling:	after 7 to 8 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 1/2 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 over 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

	Product(s) (other paint systems on request)
 Priming coats	GEHOPON-EW19-Metallgrund GEHOPON-E87-Metallgrund GEHOPON-E90RI-Metallgrund WIEREGEN-M162R-Metallgrund
Monolayer / Top coat	WIEREGEN-M165R

SAFETY MEASURES



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

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.