

MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Excellent for electrostatic spraying and nominal dry film thicknesses of 60 µm
- Very quick curing, ready for packaging after 3 hours

PRODUCT DATA

WIEREGEN-M166R, satin glossy



M166R-S.... (RAL-colours, other colours on request)



Mixing ratio by weight

7:1 with curing agent DX-17



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

WIEREGEN-M166R / Guideline

| | Density (g/mL) | Solid content (weight %) | VOC-content (weight %) | Solid content by volume | |
|---|----------------|------------------------------------|----------------------------------|-------------------------------------|---------|
| | | | | (%) | (mL/kg) |
|  | 1.45 | 69.0 | 31.0 | 49.0 | 335 |
| | DFT* (µm) | Calculated wet-film thickness (µm) | Consumption (kg/m ²) | Spreading rate (m ² /kg) | |
| | 60 | 122 | 0.180 | 5.6 | |

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application




| | | | |
|--|--------------|------------|----------|
| Application viscosity (s) (4 mm DIN-cup) | 50 to 65 | 50 to 65 | 50 to 65 |
| Nozzle diameter (mm) | 0.28 to 0.38 | 1.1 to 1.5 | - |
| Material pressure (bar) | 100 to 150 | - | - |
| Atomiser pressure (bar) | 1.5 to 2.0 | 3.0 to 5.0 | - |
| DFT* per working operation (µm) | 60 | 60 | 60 |
| Addition of thinner (%) | 0 to 2 | 0 to 2 | 0 to 2 |



Pot life

1 to 2 hours (relating to temperature)

* DFT = Dry Film Thickness

| Drying/Curing times at 60 µm DFT | | Ambient air temperature 20 °C |
|---|---------------------------------|-------------------------------|
|  | touch dry: | after 15 minutes |
|  | tack free: | after 2 hours |
|  | ready for overcoating/handling: | after 3 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 | GEWITEX-W144-Metallgrund WIEREGEN-M162R-Metallgrund GEHOPON-EW19-Metallgrund |
| Monolayer / Top coat | WIEREGEN-M166R |

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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