

## MAIN PRODUCT-PROPERTIES

- Excellent adhesion on multisubstrate surfaces
- Excellent for electrostatic spraying and nominal dry film thicknesses of 100 µm
- Very quick curing, ready for packaging after 3.5 to 4 hours

## PRODUCT DATA

### WIEREGEN-M167R, satin glossy



M167R-S.... (RAL-colours, other colours on request)



#### Mixing ratio by weight

9.6:1 with curing agent DX-6



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

### WIEREGEN-M167R / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.50	72.0	28.0	52.0	350
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )	Spreading rate (m <sup>2</sup> /kg)	
	100	192	0.285	3.5	

## COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix/  
Airless <sup>1)</sup>



High  
pressure



Roller/Brush  
application

<b>Application viscosity (s)</b> (4 mm DIN-cup)	80 to 100	60 to 100	80 to 100
<b>Nozzle diameter (mm)</b>	0.33 to 0.48	1.5 to 2.0	-
<b>Material pressure (bar)</b>	100 to 150	-	-
<b>Atomiser pressure (bar)</b>	1.5 to 2.0	3.0 to 5.0	-
<b>DFT * per working operation (µm)</b>	100	100	60
<b>Addition of thinner (%)</b>	0 to 2	0 to 2	0 to 2




<sup>1)</sup> only recommended partly



#### Pot life

1 to 2 hours (relating to temperature)

\* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 20 minutes
	tack free:	after 2 to 2.5 hours
	ready for overcoating/handling:	after 3.5 to 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 over 40 °C



max. 80 % relative humidity

## PAINT SYSTEMS

### EXAMPLES

	Product(s) (other paint systems on request)
 <b>Priming coats</b>	GEWITEX-W144-Metallgrund WIEREGEN-M162R-Metallgrund GEHOPON-EW19-Metallgrund
<b>Monolayer / Top coat</b>	WIEREGEN-M167R

## SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at [www.geholit-wierner.de](http://www.geholit-wierner.de).

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