

MAIN PRODUCT PROPERTIES

- High-gloss 2-pack PUR top coat for nominal dry film thicknesses of 40 to max. 60 µm
- Typical ACE application areas as well as building machines, loading machines, mobile cranes with high optical demands
- Very good light stability under natural weathering conditions
- Combinable with various primers based on EP and PUR, depending on the application

PRODUCT DATA

WIEREGEN-M177, high-gloss



M177-H.... (RAL colours, other colours on request)





Mixing ratio by weight

4:1 with curing agent DX-177



Thinner V-77N (Standard)
Thinner V-560 (Slow, preferred for high pressure application)

WIEREGEN-M177 / Guide values¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.15 - 1.35	65 - 75	25 - 35	(%)	(mL/kg)
				58 - 65	470 - 505
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate	
	50	75 - 90	0.09 - 0.105	(m²/kg)	
				9.0 - 9.6	

1) Guide values: Significant differences possible depending on the colour shade

PROCESSING INSTRUCTIONS

Recommendation at
temperatures
of approx. 20 °C



Airmix



**High
pressure**



**Roller/Brush
application**




	Airmix	High pressure	Roller/Brush application
Application viscosity (s) (4 mm DIN cup)	18 to 22	18 to 22	30 to 40
Nozzle diameter (mm) Spraying angle (degree)	0.23 40 to 60	1.2 to 1.5	-
Material pressure (bar)	100 to 150	-	-
Atomiser pressure (bar)	2.5 to 3.5	3.0 to 5.0	-
DFT* per working operation (µm)	40 to 60	40 to 60	40 to 60
Addition of thinner (%)	5 to 15	5 to 25	0 to 5



Pot life

2 to 3 hours (related to 20 to 25 °C)

* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT with thinner V-77N		Ambient air temperature 23 °C
	touch dry:	after 60 to 75 minutes
	tack free:	after 6 to 8 hours
	ready for overcoating/handable:	after 16 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Required priming coats (see below)

- Remove adhesion-reducing substances e.g., cleaning, washing
- Before overcoating of other priming coats compatibility tests are recommended




Air and surface temperatures

Optimal at 15 to 25 °C, not below 10 °C, not above 40 °C



max. 80 % relative humidity

PAINT SYSTEMS EXAMPLES

		Product(s) (other paint systems on request)
	Priming coats	WIEREGEN-D177-Metallgrund WIEREGEN-ACU-Metallgrund, M4-708 GEHOPON-E44R-Metallgrund GEHOPON-EW19-Metallgrund
	Top coat	WIEREGEN-M177

SAFETY MEASURES



The relevant data can be found in the current Material Safety Data Sheets, available at www.geholit-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.