MAIN PRODUCT-PROPERTIES

- **High-grade 2C-PUR topcoat for steel buildings and steel constructions in different degrees of gloss**
- **Excellent colour stability at natural weathering, particularly in the case of inorganic pigmented colours**
- **Nominal dry film thicknesses of 40 to 80 µm by spraying**
- **Excellent recoatability after cleaning of the surface**

PRODUCT DATA

WIEREGEN-M20	**RAL-colours, mat, flat, satin glossy**
	M20-M.... mat M20-F.... flat M20-S.... satin glossy (other colours on request)
	**Mixing ratio by weight** 6:1 with curing agent DX-4
	Thinner V-89

WIEREGEN-M20	**Guideline RAL-colours flat** [1]			
	Density (g/mL) **1.3**	Solid content (weight %) **70.0**	VOC-content (weight %) **30.0**	Solid content by volume (%) **56.0** / (mL/kg) **430**
	DFT * (µm) **80**	Calculated wet-film thickness (µm) **143**	VOC-content (g/m²) [2] **7.0**	Consumption (kg/m²) [3] **0.185** / Spreading rate (m²/kg) **5.4**

1) Guideline averaged data, slight deviation are possible depending on the colour
2) Based on consumption in g/m² at DFT 10 µm
3) Theoretical consumption related on a smooth surface. Dependent on surface roughness and processing losses different consumption data will be achieved in practice

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C	 **Airless**	 **High pressure**	 **Roller/Brush application** [4]
Nozzle diameter (mm)	**0.38 to 0.58**	**1.5 to 2.0**	**-**
Material pressure (bar)	**150 to 250**	**-**	**-**
Atomiser pressure (bar)	**-**	**3.0 to 4.0**	**-**
DFT * per working operation (µm)	**40 to 80**	**40 to 80**	**40 to 60**
Addition of thinner (%)	**0 to 5**	**4 to 8**	**0 to 1**

* DFT = Dry Film Thickness
4) recommended only for small areas

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	10 °C	**20 °C**	**30 °C**
Pot life at	10 hours	6 hours	4 hours

Drying/Curing times at 80 µm DFT	**Ambient air temperature**		
	7 °C	**23 °C**	**30 °C**
dust-free:	≤ 5 hours	≤ 2 hours	≤ 1 hour
tack-free:	≤ 24 hours	≤ 4 hours	≤ 2.5 hours
dry to handle:	≤ 72 hours	≤ 16 hours	≤ 12 hours
	10 °C	**20 °C**	**30 °C**
overcoating interval:	after approx. 24 hours	after approx. 16 hours	after approx. 12 hours

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values (Phase II from 2010)	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in “Application methods”)
J (“Two-pack reactive performance coatings”) Type SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Required priming coats respectively intermediate coats (see page 3)

- Remove adhesion-reducing substances

Air and surface temperature
≥ 10 °C

relative humidity ≤ 80 %
dew point distance ≥ 3 °C

Further details for processing and execution is described in the relevant applicable instructions.

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

	Product(s) (other paint systems on request)	NDFT (µm)
Priming coats	GEHOPON-E87-Zink GEHOPON-E87-Metallgrund GEHOPON-E90R-Metallgrund	80 80 80 to 160
Intermediate coats	GEHOPON-E87-ZB or GEHOPON-E97R-ZB WIEREGEN-M87-ZB in 1 to 2 working operations	80 to 160
Top coat	WIEREGEN-M20	80

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, with appropriate surface preparation

	Product(s) (other paint systems on request)	NDFT (µm)
Intermediate coats	GEHOPON-E5-Protect in 1 to 2 working operations	80 to 160
	GEHOPON-E97R-ZB GEHOPON-E87-ZB GEHOTEX-W91	80 80 80 to 120
Top coat	WIEREGEN-M20	80

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES

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