

**MAIN PRODUCT-
PROPERTIES**

- Monolayer 2C-PUR Structure Coating with high mechanical durability
- Different structures realizable by variation of spraying parameter
- Excellent absorption of spraying mist

PRODUCT DATA

WIEREGEN-M33S-Struktur, satin glossy



M33S-S...(RAL-colours, other colours on request)




Mixing ratio by weight

15:1 with curing agent DX-10



Thinner V-89

WIEREGEN-M33S-Struktur / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.35	73.0	27.0	59.0	435
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	100	169	0.230	4.3	

**COMMENTS ON
PROCESSING**

Recommendation at
temperatures
of approx. 20 °C



Airmix ¹⁾



**High
pressure**



**Roller/Brush
application**

Application viscosity (s) (8 mm DIN-cup)	20 to 30	20 to 30	15 to 30
Nozzle diameter (mm)	0.33 to 0.43	1.8 to 2.5	-
Material pressure (bar)	150 to 200	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	-
DFT * per working operation (µm)	100	100	80
Addition of thinner (%)	0 to 2	0 to 2	0 to 4




¹⁾ only recommended for precoating in multi-layer process



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 20 minutes
	tack free:	after 4 hours
	ready for overcoating/handling:	after 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	WIEREGEN-M162R-Metallgrund GEHOPON-E90RI-Metallgrund GEHOPON-EW19-Metallgrund
Monolayer / Top coat	WIEREGEN-M33S-Struktur

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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