

#### **TECHNICAL INFORMATION**

Page 1/2 - May 2018 / Vers. 4 **Industrial Coatings** 

# WIEREGEN-M33S-Struktur

**2C-PUR Structure Coating** 

## **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

7	8	9	÷
4	5	6	Х
1	2	3	÷

Density (g/mL) Ĩ.35

(µm)

100

73.0 DFT \* Calculated wet-film thickness (µm) 169

Solid content

(weight %)

**VOC-content** (weight %) 27.0

Consumption  $(kg/m^2)$ 0.230

Solid content by volume (mL//kg) 59.0 435

Spreading rate (m<sup>2</sup>/kg) 4.3

# **COMMENTS ON PROCESSING**

Recommendation at temperatures of approx. 20 °C







Roller/Brush

Airmix 1)	High
	nressure

	Allillix	pressure	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

<sup>1)</sup> only recommended for precoating in multi-layer process



#### Pot life

4 to 6 hours (relating to temperature)

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<sup>\*</sup> DFT = Dry Film Thickness



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# WIEREGEN-M33S-Struktur 2C-PUR Structure Coating

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 ½ according to EN ISO 12944-4,
- Roughness grade medium (G) according to EN ISO 12944-4,

#### 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)



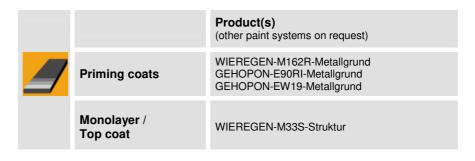
#### Air and surface temperature

optimal at 15 to 25 °C, not below 5 °C, not over 40 °C



max. 80 % relative humidity

# PAINT SYSTEMS EXAMPLES



## **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.

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