

MAIN PRODUCT-PROPERTIES

- 2C-PUR-HS Primer for subsequent satin glossy up to high-gloss topcoats/monolayer
- Typical application areas: building machines, mobile cranes, machine building with high optical demands

PRODUCT DATA

WIEREGEN-M75-Metallgrund



M75-750 Light grey (other colours on request)



Mixing ratio by weight

9:1 with curing agent DX-10



Thinner V-562

WIEREGEN-M75-Metallgrund / Guideline

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.40	76.0	24	(%)	(mL/kg)
				61.0	435
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	60	98	0.140	7.1	

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application¹⁾

Application viscosity (s) (4 mm DIN-cup)	55 to 75	45 to 65	60 to 75
Nozzle diameter (mm)	0.28 to 0.33	-	-
Material pressure (bar)	80 to 100	-	-
Atomiser pressure (bar)	1.5 to 2.5	-	-
DFT * per working operation (µm)	60	-	40 to 60
Addition of thinner (%)	0 to 3	3 to 7	0 to 2




¹⁾ only recommended for small surfaces



Pot life

3 to 4 hours (relating to temperature)

* DFT = Dry Film Thickness

Drying/Curing times at 60 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 25 minutes
	tack free:	after approx. 3 hours
	ready for overcoating/handling:	after approx. 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 coat	WIEREGEN-M75-Metallgrund
	Monolayer / Top coat	WIEREGEN-D54R or WIEREGEN-D154R WIEREGEN-M163 WIEREGEN-M26

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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