

MAIN PRODUCT PROPERTIES

- High-gloss 2-pack PUR top coat for nominal dry film thickness of 50 µm
- Typical application areas: building machines, ACE, mobile cranes with high optical demands
- Distinguished light stability at natural weathering
- Can be painted wet-on-wet after 15 minutes in combination with WIEREGEN-D177-Metallgrund (max. wet film thickness 75 µm)

PRODUCT DATA

WIEREGEN-M77N, high-gloss



M77N-H.... (RAL-colours, other on request)



Mixing ratio by weight

2:1 with curing agent DX-77N



Thinner V-77N (standard)
Thinner V-78 (fast: ambient temperature 10 to 20 °C)

WIEREGEN-M77N / Guideline

Calculator icon	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.20	77.5	22.5	(%)	(mL/kg)
				69.0	575
DFT* (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)		
50	69	0.090	11.1		

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airmix



High pressure



Roller/Brush application




Application viscosity (s) (4 mm DIN-cup)	18 to 22	20 to 25	35 to 45
Nozzle diameter (mm) Spraying angle (degree)	0.23 40 to 60	1.2 to 1.5	-
Material pressure (bar)	100 to 120	-	-
Atomiser pressure (bar)	2.5 to 3.5	3.0 to 5.0	-
DFT* per working operation (µm)	30 to 50	30 to 50	30 to 50
Addition of thinner (%)	8 to 12	6 to 10	0 to 2



Pot life

1 to 2 hours (relating to temperature)

* DFT = Dry Film Thickness

Drying/Curing times at 50 µm DFT with thinner V-77N		Ambient air temperature 20 °C
	touch dry:	after 60 to 90 minutes
	tack free:	after 6 to 8 hours
	ready for overcoating/handable:	after 24 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 temperature


optimal at 15 to 25 °C, not below 10 °C, not over 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-M77N

SAFETY MEASURES



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

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