

MAIN PRODUCT- PROPERTIES

- In accordance with TL/TP-KOR-Stahlbauten, Blatt 87 and is subject to regular external control
- High-grade, multi-purpose 2-pack PUR Intermediate coat for steel buildings and steel constructions
- Excellent recoatability after simply cleaning of surfaces also after natural weathering
- Nominal dry film thicknesses of 80 to 100 µm by spraying, of approx. 60 µm by brush application or roller coating

PRODUCT DATA

WIEREGEN-M87-ZB



M87-7602 Grey DB 702 code number 697.17
M87-6601 Green DB 601 code number 697.18




Mixing ratio by weight

15:1 with curing agent DX-4



Thinner V-89

WIEREGEN-M87-ZB / Guideline ¹⁾

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	(mL/kg)
	1.6	75.0	25.0	54.0	360
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) ²⁾	Consumption (kg/m²) ³⁾	Spreading rate (m²/kg)
	80	148	7.4	0.235	4.2

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**

	Airless	High pressure	Roller/Brush application
Nozzle diameter (mm)	0.33 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)	80 to 100	80 to 100	40 to 60
Addition of thinner (%)	0 to 5	5 to 10	0 to 2
	10 °C	20 °C	30 °C
	8 hours	6 hours	4 hours

* DFT = Dry film thickness

Drying/Curing times at 80 µm DFT		Ambient air temperature		
		7°C	23°C	30°C
	dust-free:	after ≤ 3 hours	after ≤ 1 hour	after approx. 30 minutes
	tack-free:	after ≤ 16 hours	after ≤ 8 hours	after ≤ 5 hours
	dry to handle:	after ≤ 24 hours	after ≤ 12 hours	after ≤ 8 hours
	overcoating interval:	10°C	20°C	30°C
		after approx. 24 hours	after approx. 12 hours	after approx. 8 hours

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

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

**INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products through suitable measures
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steelparts and in the application area of ZTV-ING: Sweep blast-cleaning according to EN ISO 12944-4 required. The surface must have a uniform dull appearance after surface preparation.

Existing Priming coat or old coating

- Remove adhesion-reducing substances, e. g. cleaning, washing



Air and surface temperature
≥ 7 °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	70 to 80 80
	Intermediate coats	WIEREGEN-M87-ZB in 1 to 2 working operations	80 to 160
	Top coat	WIEREGEN-M87	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-wierner.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.