MAIN PRODUCT PROPERTIES

- **High-grade, matt 2C-PUR top coat for steel buildings and steel constructions in different gloss levels**
- **Nominal dry film thicknesses of 60 to 100 µm by spraying, of approx. 60 µm by brush application or roller coating**
- **Very good light stability at natural weathering**

PRODUCT DATA

WIEREGEN-M90, matt	**RAL colours, matt**
	M90-M... matt
	**Mixing ratio by weight** 8:1 with curing agent DX-10
	Thinner V-562

WIEREGEN-M90, matt	**Guide values / RAL colours, matt** [1]			
	Density (g/mL) **1.45**	Solid content (weight %) **77.5**	VOC-content (weight %) **22.5**	Solid content by volume (%) **63.0** / (mL/kg) **435**
	DFT * (µm) **80**	Calculated wet-film thickness (µm) **121**	VOC-content (g/m²) [2] **5.2**	Consumption (kg/m²) [3] **0.185**	Spreading rate (m²/kg) **5.4**

1) Guide values averaged data, slight deviations 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** [4]
Nozzle diameter (mm)	**0.33 to 0.43**	**1.5 to 2.0**	**-**
Material pressure (bar)	**250 to 300**	**-**	**-**
Atomiser pressure (bar)	**-**	**3.0 to 4.0**	**-**
DFT * per working operation (µm)	**60 to 100**	**60 to 100**	**40 to 60**
Addition of thinner (%)	**0 to 5**	**4 to 7**	**0 to 5**

* DFT = Dry Film Thickness
4) recommended only for small areas

	10 °C	**20 °C**	**30 °C**
Pot life at	90 minutes	45 minutes	30 minutes

Drying/Curing times at 80 µm DFT	**Ambient air temperature**		
	10 °C	**20 °C**	**30 °C**
dust-free:	ca. 180 minutes	ca. 90 minutes	ca. 60 minutes
tack-free:	≤ 12 hours	≤ 6 hours	≤ 4 hours
dry to handle:	≤ 16 hours	≤ 8 hours	≤ 6 hours

Notes referring to Directive 2004/42/EC "Decopaint-Directive"

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

INSTRUCTIONS FOR APPLICATION

Surface preparation

Required priming coats respectively intermediate coats (see page 3)

- Remove adhesion-reducing substances

Air and surface temperatures
≥ 7 °C

relative humidity ≤ 80 %
dew point distance ≥ 3 °C

Further details for processing and execution are 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-E97R-Zink GEHOPON-E90R-Metallgrund	80 80 to 160
	Intermediate coats	GEHOPON-E97R-ZB WIEREGEN-M97R-ZB GEHOPON-E90R-ZB	80 80 80 to 160
	Top coat	WIEREGEN-M90	80

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, with appropriate surface preparation

		Product(s) (other paint systems on request)	NDFT (µm)
	**Intermediate coats**	GEHOPON-E60-Korrogrund GEHOPON-E90R-ZB GEHOPON-E97R-ZB GEHOTEX-W91	80 to 160 80 to 160 80 80 to 120
	Top coat	WIEREGEN-M90	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-wiemer.de.

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