

MAIN PRODUCT PROPERTIES	 High-grade 2C-PUR top coat for steel buildings and steel constructions Nominal dry film thicknesses of 80 µm by spraying, of approx. 60 µm by brush application or roller coating Excellent recoatability after cleaning of the surface 			
PRODUCT DATA	WIEREGEN-M923		MIO colours	
		M923-E	MIO colours (according to G+W colour chart)	
	A:B	Mixing ratio by weig	ht	
		12:1 with curing agent D	X-923	
		Thinner V-89		
	WIEREC	GEN-M923	Guide values MIO colours ¹⁾	

7 8 9 ÷ 4 5 6 ×	Density (g/mL) 1.55	Solid content (weight %) 77	VOC-content (weight %) 23	Solid conter (%) 62	nt by volume (mL/kg) 400
1 2 3 + 0 , =	DFT * (µm) 80	Calculated wet-film thickness (µm) 128	Consumption (kg/m ²) ²⁾ 0.200	Spreading rate (m²/kg) 5.0	Spreading rate (m²/L) 7.75

 Guide values averaged data, slight deviations are possible depending on the colour
 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
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

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DFT * per working operation (µm)	80	80	40 to 60
Addition of thinner (%)	0 to 3	4 to 6	0 to 1

* DFT = Dry Film Thickness

Pot life at	10 °C	20 °C	30 °C
Pot life at	10 hours	6 hours	4 hours

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Roller/Brush

application

-



Drying/Curing times at 80 µm DFT		Ambient air temperature		
		7 °C	23 °C	30 °C
StStStS	dust-free:	≤ 5 hours	≤ 2 hours	≤ 1 hour
	tack-free:	≤ 24 hours	≤ 4 hours	≤ 2.5 hours
	dry to handle:	≤ 72 hours	≤ 16 hours	≤ 12 hours
	overcoating interval:	10 °C	20 °C	30 °C
		after approx. 24 hours	after approx. 16 hours	after approx. 12 hours

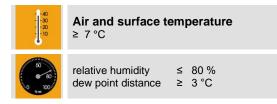
Notes referring to Directive 2004/42/EC "Decopaint-Directive"					
	VOC limit values	Max. VOC content of the product			
Subcategory as referred to in Annex IIA	(Phase II from 2010)	in its ready-for-use condition (including the max. amount of diluents as given in "Application methods")			
J ("Two-pack 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



Further details for processing and execution are described in the relevant applicable instructions.

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PAINT SYSTEMS

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 1/2 in accordance with EN ISO 12944-4

EXAMPLES

		Product(s) (other paint systems on request)	NDFT (µm)
_	Priming coat	RWE Code No.: GB-20-S-1024 GEHOPON-E920-Metallgrund- Rapid	120
	Intermediate coat	RWE Code No.: ZB-22-S-6011 GEHOPON-E922-ZB	120
	Top coat	RWE Code No.: DB-23-S WIEREGEN-M923	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 coat	RWE Code No.: GB-21-S-3009 GEHOPON-E921-Protect	80
	Top coat	RWE Code No.: DB-23-S WIEREGEN-M923	80

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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