





## 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)			
	<b>Mixing ratio by weight</b> 12:1 with curing agent DX-923				
	Thinner V-89				
WIEREGEN-M923		Guide values MIO colours <sup>1)</sup>			
	Density (g/mL) <b>1.55</b>	Solid content (weight %) <b>77</b>	VOC-content (weight %) <b>23</b>	Solid content by volume (%) (mL/kg) <b>62</b> <b>400</b>	
	DFT * (µm) <b>80</b>	Calculated wet-film thickness (µm) <b>128</b>	Consumption (kg/m²) <sup>2)</sup> <b>0.200</b>	Spreading rate (m²/kg) <b>5.0</b>	Spreading rate (m²/L) <b>7.75</b>

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

2) 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	80	40 to 60
Addition of thinner (%)	0 to 3	4 to 6	0 to 1

\* DFT = Dry Film Thickness

	<b>Pot life at</b>	10 °C	20 °C	30 °C
		10 hours	6 hours	4 hours

Drying/Curing times at 80 µm DFT		Ambient air temperature		
		7 °C	23 °C	30 °C
	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:	<b>10 °C</b>	<b>20 °C</b>	<b>30 °C</b>
		after approx. 24 hours	after approx. 16 hours	after approx. 12 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 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 temperature**  
≥ 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**

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

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

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT (µm)</b>
	<b>Intermediate coat</b>	RWE Code No.: GB-21-S-3009 GEHOPON-E921-Protect	80
	<b>Top coat</b>	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-wierner.de](http://www.geholit-wierner.de).

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