

■ **FIELDS OF APPLICATION**

Together with suitable primer coatings as high-grade top-coating for corrosion protection of steel building and constructions.

■ **PRODUCT PROPERTIES**

WIEREGEN-M924 contains a polyacrylate binder with a special polyisocyanate as curing agent.

Preferably, the material is applied by airless spraying, where a dry film thickness up to 80 µm can be attained in a single working operation. Coatings can also be applied by brush or roller coating. In this case the dry film thickness will be approximately 60 µm.

Capacities

Together with suitable epoxy coating materials (see coating systems) a protective coating system will be obtained with both excellent mechanical resistance properties and stability against aggressive atmosphere, de-icing salt, etc.
Temperature stress until 120 °C is possible (dry heat).

■ **PRODUCT DATA**

WIEREGEN-M924

RWE-Code-
No.

Curing agent

Product number M924-S.... (je nach Farbton)

DB-24-S-....

DX-924

Mixing ratio 10 parts by weight

1 part by weight

Degree of gloss satin glossy

Form of delivery ready for brush application after mixture with curing agent

Shelf life at least 12 months in original cans at normal temperature

Suitable thinner V-89

Theoretical parameters

WIEREGEN-M924, M924-S3031

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	per 10 µm DFT* (g/m²)	Solid content by volume (%)	(mL/kg)
1.4	77	23	5.1	63	440
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
80	127	0.180		5.5	

Remarks

- All values are relevant for the mixture in case of two-pack materials
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour).
The values may differ slightly for other colours.
- * baseline for calculation: consumption in g/m² at DFT 10 µm

**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 SB	500 g/l	< 500 g/l

■ **COATING SYSTEMS**

The coating systems must be taken from the valid RWE-Standard for the corrosion protection.

■ **INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Coatings:

Adhesion-reducing substances must be removed.

**Air and surface
temperature**

optimal results at temperatures of 5 to 25 °C, not below 0 °C

Relative humidity

max. 80 % relative humidity

The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air throughout the application. (see basic specification for corrosion protection EN ISO 12944-7)

Comments on processing

Mixing

Mix thoroughly with the enclosed quantity of curing agent, preferably with a mechanical mixer. Material must be stirred again after 15 minutes. Then the mixture is ready for use.

Application methods

Means of application / parameters	attainable dry film thickness per working operation (approx.)	Addition of thinner V-89
Airless spraying Nozzle diameter: 0.38 to 0.58 mm Material pressure: 150 to 250 bar	80 to 100 µm	up to 3 %
High pressure/air spraying Nozzle diameter 1.5 to 2.0 mm Pressure 3 to 4 bar	80 to 100 µm	4 to 6 %
Roller coating / brush application	40 to 60 µm	up to 1 %
In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.		

Remarks

- The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

Cleaning of equipment

with thinner V-562 or V-89

Pot life

4 to 6 hours (depending on temperature)

Curing and drying times At a temperature of 20 °C and a dry film thickness of 60 µm

Dry to touch:	after 30 minutes
Tack free:	after 4 to 5 hours
Ready for over-coating:	after 12 to 16 hours

■ **SAFETY MEASURES**

The relevant data concerning safety measures can be found in the material safety data sheet of this product.
The valid issue of the material safety data sheet is available from our website 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 of 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.