

MAIN PRODUCT- PROPERTIES	 In accordance with TL/TP-KOR, Blatt 97 and is subject to regular external control High-grade, quick curing, multi-purpose 2C-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	WIEREC	GEN-M97R-ZB	MIO-c	olours
		M97R-5602 Blue DB 50 M97R-6602 Green DB 6		code number 697.15 code number 697.16
	A:B	Mixing ratio by weigl 20:1 with curing agent D		
		Thinner V-89		

WIEREGEN-M97R-ZB

WIEREGEN-M97R-ZB Guideline MIO-colours ¹⁾					
789÷ 456×	Density (g/mL) 1.6	Solid content (weight %) 75.0	VOC-content (weight %) 25.0	Solid conte (%) 54.0	nt by volume (mL/kg) 360
0,=	DFT * (μm) 80	Calculated wet-film thickness (µm) 148	VOC-content (g/m ²) ²⁾ 7.4	Consumption (kg/m ²) ³⁾ 0.235	Spreading rate (m²/kg) 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
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	4 to 7	0 to 2
Pot life at	10 °C	20 °C	30 °C
	6 hours	4 hours	3 hours
* DFT = Dry film thickness			

D-76676 Graben-Neudorf D-47249 Duisburg D-01683 Nossen

Sofienstraße 36 Obere Kaiserswerther Straße 18 Gewerbestraße 8

Tel. +49 7255 99-0 Tel. +49 203 99707-0 Tel. +49 35242 6565-0 Fax +49 7255 99-123 Fax +49 203 99707-10 Fax +49 35242 6565-29



Drying/Curing times at 80 µm DFT	Ambient air temperature			
	5°C	15°C	30°C	
dust-free:	after ≤ 4	after ≤ 2	after ≤ 1	
	hours	hours	hour	
tack-free:	after ≤ 8	after ≤ 3.5	after ≤ 2	
	hours	hours	hours	
dry to handle:	after ≤ 12	after ≤ 5	after ≤ 3	
	hours	hours	hours	
overcoating interval:	after ≤ 16	after ≤ 6	after ≤ 3	
	hours	hours	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	
	(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 SB	500 g/l	< 500 g/l	

INSTRUCTIONS FOR APPLICATION

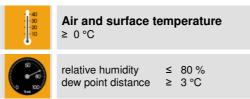
Surface preparation

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products through suitable measures
- At natural weathering or condensation of coated, hot-dip galvanised steelparts and in the application range 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



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

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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-E97R-Metallgrund	70 to 80 80
	Intermediate coats	WIEREGEN-M97R-ZB in 1 to 2 working operations	80 to 160
	Top coats	WIEREGEN-M97R WIEREGEN-M197R	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.

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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