





## 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

WIEREGEN-M97R-ZB	MIO-colours
	M97R-5602 Blue DB 502 code number 697.15 M97R-6602 Green DB 602 code number 697.16
	<b>Mixing ratio by weight</b> 20:1 with curing agent DX-10
	Thinner V-89

WIEREGEN-M97R-ZB	Guideline MIO-colours <sup>1)</sup>				
	Density (g/mL) <b>1.6</b>	Solid content (weight %) <b>75.0</b>	VOC-content (weight %) <b>25.0</b>	Solid content by volume (%) <b>54.0</b>	(mL/kg) <b>360</b>
	DFT * (µm) <b>80</b>	Calculated wet-film thickness (µm) <b>148</b>	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup> <b>7.4</b>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup> <b>0.235</b>	Spreading rate (m <sup>2</sup> /kg) <b>4.2</b>

1) Guideline averaged data, slight deviation are possible depending on the colour

2) Based on consumption in g/m<sup>2</sup> 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**

	Airless	High pressure	Roller/Brush application
<b>Nozzle diameter (mm)</b>	0.33 to 0.58	1.5 to 2.0	-
<b>Material pressure (bar)</b>	150 to 250	-	-
<b>Atomiser pressure (bar)</b>	-	3.0 to 4.0	-
<b>DFT * per working operation (µm)</b>	80 to 100	80 to 100	40 to 60
<b>Addition of thinner (%)</b>	0 to 5	4 to 7	0 to 2
	<b>Pot life at</b>		
	10 °C	20 °C	30 °C
	6 hours	4 hours	3 hours

\* DFT = Dry film thickness

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



**Air and surface temperature**  
≥ 0 °C



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

Further details for processing and execution is 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</b> (µm)
	<b>Priming coats</b>	GEHOPON-E97R-Zink GEHOPON-E97R-Metallgrund	70 to 80 80
	<b>Intermediate coats</b>	WIEREGEN-M97R-ZB in 1 to 2 working operations	80 to 160
	<b>Top coats</b>	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-wierner.de](http://www.geholit-wierner.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.