






## MAIN PRODUCT-PROPERTIES

- In accordance with TL/TP-KOR, Blatt 97 and is subject to regular external control
- High-grade, quick curing 2C-PUR topcoat for steel buildings and steel constructions
- Nominal dry film thicknesses of 80 to 100 µm by spraying, from approx. 60 µm by brush application or roller coating
- Excellent recoatability after cleaning of the surface

## PRODUCT DATA

WIEREGEN-M97R		MIO-colours RAL-colours, satin glossy
	M97R-E.... MIO-colours (according to G+W-colours)	M97R-S.... RAL-colours (other colours on request) satin glossy
	<b>Mixing ratio by weight</b> 14:1 with curing agent DX-10	<b>Mixing ratio by weight</b> 9:1 with curing agent DX-10
	Thinner V-89	

WIEREGEN-M97R		Guideline MIO-colours <sup>1)</sup>			
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.5	74.5	25.5	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	80	143	6.9	0.215	4.7

WIEREGEN-M97R		Guideline RAL-colours <sup>1)</sup>			
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
	1.35	72.5	27.5	(%)	(mL/kg)
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	80	139	6.4	0.185	5.4

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
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 3	4 to 6	0 to 1

\* DFT = Dry Film Thickness

	<b>Pot life at</b>	<b>5 °C</b>	<b>15 °C</b>	<b>30 °C</b>
		6 hours	4 hours	3 hours

	<b>Drying/Curing times at 80 µm DFT</b>	<b>Ambient air temperature</b>		
		<b>5 °C</b>	<b>15 °C</b>	<b>30 °C</b>
	dust-free:	≤ 4 hours	≤ 2 hours	≤ 1 hour
	tack-free:	≤ 10 hours	≤ 4 hours	≤ 2.5 hours
	overcoating interval / dry to handle	≤ 16 hours	≤ 6 hours	≤ 4 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**

**Required priming coats respectively intermediate coats (see page 3)**

- Remove adhesion-reducing substances


	<b>Air and surface temperature</b> ≥ 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**

		Product(s) (other paint systems on request)	NDFT (µm)
	<b>Priming coats</b>	GEHOPON-E97R-Zink GEHOPON-E97R-Metallgrund GEHOPON-E90RI-Metallgrund	80 80 80 to 160
	<b>Intermediate coats</b>	GEHOPON-E97R-ZB GEHOPON-E97RX-ZB WIIEGEN-M97R-ZB WIIEGEN-M97RX-ZB in 1 to 2 working operations	80 to 160
	<b>Top coat</b>	WIIEGEN-M97R	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)
	<b>Intermediate coats</b>	GEHOPON-E5-Protect in 1 to 2 working operations GEHOPON-E97R-ZB GEHOPON-E97RX-ZB GEHOTEX-W91	80 to 160 80 80 to 120
	<b>Top coat</b>	WIIEGEN-M97R	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.geholti-wierner.de](http://www.geholti-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.