

1C-EPE Zinc rich Primer, quick curing
BASF-No.: 3343 154

■ **FIELDS OF APPLICATION** High-grade zinc-rich primer for protective coatings of grit-blasted steel surfaces.

■ **PRODUCT PROPERTIES** GEHOLIT-K330R-Zink is a highly pigmented zinc-rich primer coating based on epoxy ester. GEHOLIT-K330R-Zink has an excellent adhesion on blasted steel surfaces also as temperature resistance and corrosion protection properties.

Due to its special composition, a quick drying process will be achieved. Therefore GEHOLIT-K330R-Zink is particularly suitable for economic spraying methods. Depending on setting of viscosity dry film thicknesses of 80 to 100 µm can be achieved in one working operation.

■ **PRODUCT DATA**

Product number and colour K330R-590
blue

Form of delivery Ready for brush application, lightly thixotrope

Shelf life At least 6 months in original cans - store dry and cool (contact with humidity has absolutely to be avoided)

Suitable thinner V-74 for brush application and spraying

Theoretical parameters

GEHOLIT-K330R-Zink, K330R-590

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
2.6	84	16	7.6	55	210
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
80	145	0.379		2.6	

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")
i ("One-pack performance coatings") Type SB	500 g/l	< 500 g/l

Coating systems

Substrate	Steel	
Surface preparation	Blast-cleaning in surface preparation grade Sa 2 ½ medium (G) in accordance with EN ISO 12944-4	
	Product	BASF-Nr.
Primer coating	GEHOLIT-K330R-Zink	3343 154
Intermediate coating	GEHOPAL-L330-Füllgrund	3343 456
Top coating	GEHOPAL-L330	3343 460-485

The coating system/s named are examples proved in practice which usually can be modified. The choice of coating materials as well as their number and film thickness depends on the stress to be expected, existing specifications and the methods of application.

■ **INSTRUCTIONS FOR APPLICATION**

Surface preparation

Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4. G-grade medium roughness in accordance with EN ISO 8503-1.

Air and surface temperature

Optimal results at temperatures of 15 to 25 °C, not below 5 °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

Application methods

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner V-74
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 250 bar	80 µm	up to 1 %
High pressure/air spraying Nozzle diameter: 1.5 to 2.0 mm Air pressure: 3 to 4 bar	80 µm	1 to 2 %

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

Immediately after use with thinner V-74

Drying and curing times

At a DFT of 80 µm and a temperature of 20 °C

Dry to touch: After approx. 30 min.

Tack free: After 6 h

Ready for over-coating: After approx. 16 h

■ **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.