RWE-Code-No. GB-9-S-3009
GEHOLIT-K909-Metallgrund

MAIN PRODUCT-PROPERTIES

- **1C-AK-HS Priming coat for high-grade corrosion protection of steel- and hot dip galvanised steel constructions**
- **Brush application will be recommended**
- **GEHOLIT-K909-Metallgrund with a dry film thickness of up to 80 µm shows excellent adhesion on galvanised steel parts and excellent corrosion protection on steel parts**

PRODUCT DATA

GEHOLIT-K909-Metallgrund		**RWE-Code-No.**
K909-309 oxide red	approx. RAL 3009	GB-9-S-3009

Mixing ratio by weight
Not relevant

Thinner V-50

GEHOLIT-K909-Metallgrund / Guideline [1)]

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL//kg)
1.6	**80.5**	**19.5**	**61.5**	**385**

DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²) [2)]	Spreading rate (m²/kg)	Spreading rate (m²/L)
80	**130**	**0.210**	**4.8**	**77**

1) Guideline averaged data, slight deviation are possible depending on the colour
2) 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**
Application viscosity (s) (Epprecht, MKC 25 °C)	**400 to 480**		
Nozzle diameter (mm)	-	-	-
Material pressure (bar)	-	-	-
Atomiser pressure (bar)	-	-	-
DFT * per working operation (µm)	-	-	**80**
Addition of thinner (%)	-	-	**0 to 2 at low temperatures**

Pot life
Not relevant

* DFT = Dry Film Thickness

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Drying/Curing times at 80 µm DFT		Ambient air temperature 20 °C
	touch dry:	after approx. 5 hours
	tack free:	after approx. 16 hours
	ready for overcoating/handling: walkable:	after 24 hours after 72 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

- Please note the currently available version of the RWE-guideline

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4 alternatively
- Mechanical or manual derosting at preparation grade St 2 according to EN ISO 12944-4

Hot-dip-galvanised steel surfaces

- Remove adhesion-reducing substances, particularly zinc salts alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
  After sweep blast-cleaning the surface shall have a uniform dull appearance.

Existing old coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing and if applicable
- Mechanical or manual derosting at preparation grade PMa respectively PSt 2 according to EN ISO 12944-4.

	**Air and surface temperature** 5 to 40 °C
	Relative humidity ≤ 80 % Dew point distance ≥ 3 K

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	**Priming coat**	RWE-Code-No. GB-9-S-3009 GEHOLIT-K909-Metallgrund
	Top coat	RWE-Code-No. DB-11-S-.... GEHOLIT-K911

SAFETY MEASURES

The relevant data can be found in the current material safety data sheets, available at www.geholit-wiemer.de.

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