

■ **FIELDS OF APPLICATION**

Quick-drying corrosion protection primer coating for steel girder constructions, appliances, conveyor systems, building machines and the like, for efficient application methods.

■ **PRODUCT PROPERTIES**

GEHOLIT-K913-Metallgrund is based on specially modified alkyd resins and contains proven corrosion protection pigments, free of lead and chromate.

The material is preferably applied by airless-spraying. Brush application or high pressure/air spraying are also possible.

In a single working operation a dry film thickness of 80 to 100 µm can be applied.

Due to the rapid initial drying and the quick drying process, top coatings can be applied in quick succession which means economically efficient application methods. Together with suitable top coatings, high-grade corrosion protection systems can be achieved.

Capacities Temperature resistance (dry heat): 120 °C permanently
140 °C short term

■ **PRODUCT DATA**

RWE-Code-No.

Product number and colour	K913-309	oxide red	approx. RAL 3009	GB-13-L-3009
	K913-701	silver grey	approx. RAL 7001	GB-13-L-7001

Form of delivery Ready for brush application

Standard packaging 20 litres

Shelf life At least 18 months in original cans at normal temperature

Suitable thinner V-89 (also for cleaning of equipment)

Theoretical parameters GEHOLIT-K913-Metallgrund, K913-309

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.45	69	31	9.4	48	331
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
100	208	0.302		3.3 = 4.8 m ² /l	

- 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

The paint systems can be found in the current version of the RWE directive for corrosion protection.

**■ INSTRUCTIONS
FOR APPLICATION**

Surface preparation

Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4.

**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	attainable dry film thickness per working operation (approx.)	Addition of thinner V-89
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 200 bar	80 to 100 µm	up to 3 %
Roller coating / brush application	60 to 80 µm	up to 2 %

In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.

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.

Drying and curing times

Related to a temperature of 20 °C and a DFT of 80 µm

Dry to touch: after 45 to 60 minutes

Tack free: after 4 to 5 hours

Ready for over-coating: with WIEKORANT-A911 after 12 to 16 hours

■ 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.

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