

■ **FIELDS OF APPLICATION**

Protective coating for hot-dip galvanised steel structures, e.g. for power line masts and poles along roads and railways, the structures of halls and hangars, etc.

Together with suitable protective primers to be used as top coating for non-galvanised steel structures.

The use of GEHOPAL-L77 in the application range of the Directive 2004/42/EG "Decopaint-Directive" is not allowed (e.g. coating of buildings or building parts).

■ **PRODUCT PROPERTIES**

GEHOPAL-L77 is a one-pack coating material based on PVC/acrylic resin with special pigmentation.

The material can be applied by brush, roller coating or airless spraying. Usually, a dry film thickness of 80 to 100 µm is obtained by airless-spraying, 60 to 80 µm by brush application or roller coating.

Temperature resistance: up to 80 °C (dry heat)

**Test certificates**

- GEHOPAL-L77 is subject to regular external quality control.

■ **PRODUCT DATA**

GEHOPAL-L77

GEHOPAL-L77

**Product number**

L77-E....(depending on colour)

L77-F.... (depending on colour)

**Colour**

G+W MIO colours

RAL colours

(other colours available on request)

**Degree of gloss**

Flat

**Form of delivery**

Ready for brush application

Ready for brush application

**Shelf life**

At least 12 months in original cans at normal temperature

**Suitable thinner**

For brush application: thinner V-89

For spray application: thinner V-74

**Theoretical parameters**

GEHOPAL-L77, L77-F9010

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m <sup>2</sup> )	(%)	(mL/kg)
1.3	62	38	11.8	42	325
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )		Spreading rate (m <sup>2</sup> /kg)	
80	189	0.246		4.1	

**Theoretical parameters**

GEHOPAL-L77, L77-E7602

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m <sup>2</sup> )	(%)	(mL/kg)
1.4	64	36	12.0	42	307
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )		Spreading rate (m <sup>2</sup> /kg)	
80	190	0.260		3.8	

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/m<sup>2</sup> at DFT 10 µm

**Coating systems**

<b>Substrate</b>	Steel	
<b>Surface preparation</b>	Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4	
	<b>Product</b>	<b>NDFT (µm)</b>
<b>Primer coating</b>	GEHOPAL-L77-Metallgrund	80
<b>Intermediate coating(s)</b>	GEHOPAL-L77 (MIO)	80
<b>Top coating</b>	GEHOPAL-L77	80

<b>Substrate</b>	Steel with hot-dip galvanising in accordance with EN ISO 1461	
<b>Surface preparation</b>	Cleaning in accordance with EN ISO 12944-4	
	<b>Product</b>	<b>NDFT (µm)</b>
<b>Top coating</b>	GEHOPAL-L77 (MIO)	80
<b>Top coating</b>	GEHOPAL-L77	80

The coating system/s named are examples proven 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**

Coatings

Adhesion-reducing substances must be removed.

Hot-dip galvanised surfaces:

Dry and clean surfaces are essential for good adhesion of coating materials. Besides contaminants like grease, oil, dust, etc. especially zinc salts (zinc corrosion products) have to be removed totally.

**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
Roller coating / brush application	60 µm	up to 2 % V-89
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.		
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 250 bar	80 to 100 µm	up to 5 % V-74

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** At a temperature of approx. 20 °C and a dry film thickness of 80 µm.

Dry to touch: after approx. 30 minutes

Tack free: after 1 to 2 hours

Ready for over-coating: after 6 hours with GEHOPAL-L77

#### ■ 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](http://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.