

- **FIELDS OF APPLICATION** Together with suitable corrosion protection primer coatings and if applicable with intermediate coatings GEHOTEX-W17 offers excellent, weather resistant corrosion protection systems for tanks, steel hangars, cranes and other steel constructions. For individually hot-dip galvanised steel surfaces suitable adhesion primers are used.

- **PRODUCT PROPERTIES** GEHOTEX-W17 is a one-pack coating material based on waterborne acrylic resin copolymerisate.

GEHOTEX-W17 has an excellent colour- and glossfirmness within natural weathering and is at least comparable with high-class polyurethane topcoatings.

The material can be applied by brush, roller coating, airless-spraying or compressed air spraying. In case of airless-spraying usually a dry film thickness of 80 to 100 µm can be achieved, in case of brush, roller and compressed air coating 50 to 70 µm. The coating systems show excellent adhesion and elasticity.

Temperature resistance: up to 80 °C

■ PRODUCT DATA	<u>GEHOTEX-W17</u>	<u>GEHOTEX-W17</u>	<u>GEHOTEX-W17</u>
Product number	W17-E.... (depending on colour)	W17-F.... (depending on colour)	W17-S.... (depending on colour)
Colour	G+W-Eisenglimmer (MIO) colours	RAL colours (Other colours on request)	RAL colours (Other colours on request)
Degree of gloss		silk mat	satin glossy
Form of delivery	Ready for airless-spraying	Ready for airless-spraying	Ready for airless-spraying
Shelf life	At least 6 months in original cans at normal temperature		
Suitable thinner	Demineralsised water or water of low water hardness		

Theoretical parameters

GEHOTEX-W17, W17-E7602 grey DB 702 (MIO)

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.35	61	< 5	1.4	47	350
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
80	170	0.230		4.4	

Theoretical parameters

GEHOTEX-W17, W17-F9010 pure white RAL 9010 flat

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.35	61	< 5	1.4	47	370
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
80	170	0.230		4.4	

GEHOTEX-W17, W17-S9010 pure white RAL 9010 satin glossy

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.15	52	< 5	1.3	44	385
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
60	135	0.155		6.5	

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 WB	140 g/l	< 140 g/l

Coating systems

Substrate	Steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4	
	Product	NDFT (µm)
Primer coating	GEHOPON-E87-Zink or GEHOTEX-W92-Metallgrund or GEWITEX-W113-Metallgrund	80 80 60
Intermediate coating	GEHOTEX-W92-ZB	80 - 100
Top coating	GEHOTEX-W17	60 - 80

Substrate	Steel with hot-dip galvanising in accordance with EN ISO 1461	
Surface preparation	Cleaning in accordance with EN ISO 12944-4	
	Product	NDFT (µm)
Intermediate coating	GEHOTEX-W91	80 - 100
Top coating	GEHOTEX-W17	60 - 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

The necessary primers and intermediate coatings must be intact as well as dry and clean.

Adhesion-reducing substances must be removed.

Air and surface temperature

Optimal results at temperatures of 15 to 25 °C, not below 10 °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.)	W17-E.... W17-F.... Addition of demineralised water	W17-S.... Addition of demineralised water
Airless spraying Nozzle diameter: 0.33 to 0.58 mm Material pressure: 150 to 250 bar	80 to 100 µm	up to 3 %	up to 3 %
Airmix spraying Nozzle diameter: 0.38 to 0.45 mm Material pressure: 50 to 70 bar Atomiser pressure: 3 to 4 bar	80 to 100 µm	3 to 5 %	up to 3 %
Compressed air spraying Nozzle diameter: 1.3 to 1.5 mm Atomiser pressure: 3 to 4 bar	50 to 70 µm	3 to 5 %	up to 3 %
Roller coating / brush application	50 to 70 µm	undiluted	undiluted

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 DFT of 80 µm

Normal climate (20 °C, 60 % relative humidity)

Dry to touch: After approx. 50 minutes

Tack-free: After approx. 2 to 3 hours

Ready for over-coating: After 16 hours

Dried through: After 48 hours

Forced drying

Dust-off-time: 10 minutes, 25 to 40 °C

Drying: 15 to 20 minutes, 50 to 70 °C

Ready for over-coating: After cooling of the parts

■ **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.