TECHNICAL INFORMATION

GEWITEX-W110F-Tauchgrund

1C-AK Hydro Primer

■ FIELDS OF APPLICATION

Quick-drying dipping primer on cast iron, e.g. gearboxes.

■ PRODUCT PROPERTIES

GEWITEX-W110F-Tauchgrund is specially adjusted for dip coating. The primer coats thus produced show excellent adhesion on blasted parts made of cast iron.
Together with suitable top-coats it is possible to produce coating systems for different demands.
GEWITEX-W110F-Tauchgrund is air-drying, for industrial uses however we recommend a forced drying at 40 to 80 °C.

Capacities

The fastness of the coating against stresses while being manufactured, e.g. filing works using cooling lubricants, followed by cleaning in laundering facilities, can be achieved only when complying with the drying conditions mentioned in the instructions for application.
When completely dried through, GEWITEX-W110F-Tauchgrund is resistant against many gear-oils and grease even at temperatures up to 120 °C.
Temperature resistance of the coating: 150 °C (dry heat)

■ TECHNICAL DATA

Product Number W110F-850

Colour red brown as sample 8050
(other colours on request)

Degree of gloss mat

Form of delivery 40 to 60 seconds / 4-mm-cup in accordance with DIN 53211
50 to 80 seconds / 5-mm-cup in accordance with EN ISO 2431

Shelf life At least 6 months in original cans at normal temperature

Appropriate Thinner Demineralised water, ≤ 20 µSiemens

Theoretical parameters

GEWITEX-W110F-Tauchgrund, W110F-850

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	VOC-content per 10 µm DFT* (g/m²)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.3	58	5.3	1.5	45	345
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
30	66	0.087		11.2	

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

The choice of primers and their number and thickness of layer is depend on the stress to be expected, existing prescriptions and application methods.

We recommend to issue written specifications with different coating systems specially adapted to the various fields of application.

■ INSTRUCTIONS FOR APPLICATION

Surface Preparation

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

Comments on processing

Applikation methods

dipping

Viscosity by application

20s/4mm	DIN 53211	for DFT approx. 15 to 20µm
20 to 30 s/4mm	DIN 53211	for DFT approx. 20 to 30µm
30 to 35 s/4mm	DIN 53211	for DFT approx. 30 to 40µm

Addition of 8 to 12 % demineralised water to the coating material in form of delivery

Air and surface temperature

minimal: 15°C
maximal: 30°C
optimal: 18 to 23 °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)

Forced drying

Flash-off-time
10 to 15 minutes at 40 °C
Drying
25 to 35 minutes at 70 to 80 °C
Curing time
At least 48 hours at 20 to 25 °C with a relative humidity of ≤ 60 %

■ PROTECTIVE 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.