

GEWITEX-W111F-Tauchgrund
black

1C-AC Hydro Primer

■ **FIELDS OF APPLICATION** Quick-drying dipping primer for cast iron, sheet metal parts and deep drawn components.

■ **PRODUCT PROPERTIES** GEWITEX-W111F-Tauchgrund is specially adjusted for dip coating.

The primer coats achieved by this method show excellent adhesion on cast iron, sheet metal parts and deep drawn components.

Together with suitable top-coats it is possible to produce coating systems for different demands.

GEWITEX-W111F-Tauchgrund - based on waterborne acrylic copolymerisate resin - is suitable for air drying and also for a forced drying, e.g. 30 to 50 °C.

PRODUCT DATA

Product number W111F-921

Colour black

Degree of gloss mat

Viscosity of delivery
DIN 53211/4mm 50 to 70 s

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

Appropriate thinner Demineralised water

Theoretical parameters GEWITEX-W111F-Tauchgrund black, W111F-921

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m ²)	(%)	(mL/kg)
1.3	61	< 3	0.8	50	380
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)		Spreading rate (m ² /kg)	
40	81	0.105		9.5	

- 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

■ **INSTRUCTIONS
FOR APPLICATION**

Surface preparation All parts have to be clean and dry.
Grease, oil and other pollutants have to be removed thoroughly.

Comments on processing

Air and surface temperature Optimal results at temperatures of 15 to 25 °C, not below 10 °C

Relative humidity Optimal results at 40 to 60 %, max. 80 % relative humidity.

Comments on processing

Application methods

Dipping			
Viscosity DIN 53211 / 4mm	35 - 40 s	25 - 35 s	18 - 25 s
Addition of demineralised water	up to 2 part by weight	2 to 4 part by weight	4 to 8 part by weight
dry film thickness	35 to 60 µm	25 to 40 µm	20 to 30 µm

Remarks

- The values above are related to a temperature of approximately 20°C and are recommendations respectively rough guides. In the practice it may be necessary to make modifications.

Drying times Related to a dry film thickness of approx. 40 µm
and a temperature of approx. 20 °C

Air drying
Dry to touch After approx. 30 to 40 minutes
Tack free After 60 to 80 minutes

Forced drying
evaporation/
drying 15 to 30 minutes at 40 to 70 °C

■ **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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