LACK– UND KUNSTSTOFF– CHEMIE GMBH

TECHNICAL INFORMATION

GEWITEX-W111F-Tauchgrund

red brown

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.

The steel parts preserved with GEWITEX-W111F-Tauchgrund can be welded over using the usual welding processes.

Analysis of the products of combustion (ascertained by gas detection tests when welding) produced readings well under the limits currently prevailing.

TEST REPORTS

Inspection report 20106600011 of the SLV Duisburg, 27.04.2010

- Determination of the porosity level in accordance with the German DVS-guideline 0501
- Trace gas measurement during welding of plates coated with primer GEWITEX-W111F

PRODUCT DATA

Product number W111F-850

Colour red brown

Degree of gloss mat

Viscosity of delivery

DIN 53211/4mm 40 to 50 s

or

EN ISO 2431/5 mm 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, W111F-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	60	4.3	1.2	47.5	357

DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)	Spreading rate (m²/kg)
40	84	0.112	8.9

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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	24 - 35 s	18 - 25 s
Addition of demineralised water	up to 1 part by weight	1 to 3 part by weight	5 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 practce 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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