

MAIN PRODUCT PROPERTIES

- 2-pack PUR high-solid primer mainly for wet-on-wet application with suitable high-gloss top coat
- Overcoatable wet-on-wet with WIEREGEN-M77N or WIEREGEN-M177 after approx. 15 minutes and with a wet film thickness of up to 75 µm
- Typical application areas: building machines, mobile cranes, ACE with high optical demands

PRODUCT DATA

WIEREGEN-D177-Metallgrund



D177-701 Silver grey
(other colours on request)




Mixing ratio by weight

5,4:1 with curing agent DX-77N



Thinner V-77N

WIEREGEN-D177-Metallgrund / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.35	77.5	22.5	66.0	490
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	50	75	0.105	9.5	

PROCESSING INSTRUCTIONS

Recommendation at
temperatures
of approx. 20 °C



Airmix



High
pressure



Roller/Brush
application ¹⁾

Application viscosity (s)	30 to 40	30 to 40	30 to 40
Wet-on-wet application (s) (4 mm DIN cup)	20 to 25	20 to 25	-
Nozzle diameter (mm)	0.28	1.3 to 1.5	-
Spraying angle (degree)	40 to 60	-	-
Material pressure (bar)	120 to 150	-	-
Atomiser pressure (bar)	3.0 to 4.0	3.0 to 4.0	-
DFT ²⁾	35 to 60	35 to 60	35 to 60
Wet-on-wet application: WFT ³⁾ per working operation (µm)	60 to 75	60 to 80	-
Addition of thinner (%)	-	-	-
Wet-on-wet application	8 to 10	8 to 10	-






Pot life

45 to 60 minutes (at temperatures of 20 to 25 °C)

¹⁾ only recommended for small surfaces; formation of a product-specific surface structure is possible

²⁾ DFT = Dry Film Thickness

³⁾ WFT = Wet Film Thickness

Drying/curing times at 50 µm DFT with thinner V-77N		Ambient air temperature 20 °C
	touch-dry:	after approx. 30 minutes
	tack-free:	after approx. 80 minutes
	ready for overcoating with WIEREGEN-M77 or WIEREGEN-M177 dry to handle:	after approx. 15 minutes after approx. 5 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e.g. cleaning, washing, phosphating
- Blast cleaning Sa 2 ½ according to EN ISO 12944-4, roughness grade medium (G) according to EN ISO 8503-1

Hot-dip galvanised steel surfaces and aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation load: Sweep blast cleaning according to EN ISO 12944-4. After sweep blast cleaning, the surface must have a uniformly dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



Air and surface temperature

optimal at 15 to 25 °C, not below 10 °C, not above 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

		Product(s) (other paint systems on request)
	Priming coat	WIEREGEN-D177-Metallgrund
	Top coat	WIEREGEN-M77N WIEREGEN-M177

SAFETY MEASURES



The relevant data can be found in the current material safety data sheets, available at www.geholti-wiemer.de.

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