Supplementary sheet to Technical Information
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Industrial coating

GEHOLIT + WIEMER
LACK– UND KUNSTSTOFF– CHEMIE GMBH

WIEREGEN-M33S-Struktur
2C-PUR Structure coating

Advice for structure coating

Coating material: **WIEREGEN-M33S-Struktur, satin glossy**
M33S-S.....(depending on colour)

Viscosity parameters

Viscosity of delivery: 20 - 30 s / 8 mm flowcup (after mixing)
Spraying viscosity: 20 - 30 s / 8 mm flowcup (after mixing)

Application parameters

Structure coating:

Application:	air spray system
Material pressure:	0.5 – 1.0 bar (pressarized cup)
	2.5 – 4.0 bar (piston pump, pressure tank)
Nozzle diameter:	1.5 – 2.5 mm
Atomizer pressure:	3.0 – 4.0 bar
Cross coat :	1.0 – 2.0

Because of high thixotrophy of the paint, painting by gravity flow cup gun is not recommended because of technical reasons.

A typical structure coating (spot effects) can generally only be achieved by low pressure system (pressure spraying).

Please note:

At spraying with airless and air-combi application usually only orange peel effects can be achieved.

Important: The formation and kind of the structural effect strongly depends on the spraying application parameters.
Please contact us for more information.

Dry film thickness: 100 µm – 160 µm   depending on structure