





MAIN PRODUCT PROPERTIES

- High-grade 2C-PUR top coat for steel buildings and steel constructions in different gloss levels
- Nominal dry film thicknesses of 60 to 100 µm by spraying, of approx. 60 µm by brush application or roller coating
- Very good light stability at natural weathering

PRODUCT DATA

WIEREGEN-M90		RAL colours flat, satin glossy
	M90-F.... flat M90-S satin glossy	
	Mixing ratio by weight 6.5:1 with curing agent DX-10	
	Thinner V-77N	

WIEREGEN-M90		Guide values RAL colours flat, satin glossy ¹⁾			
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.35	75.5	24.5	62.0	460
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	80	130	5.2	0.175	5.7

1) Guide values averaged data, slight deviations are possible depending on the colour

2) Based on consumption in g/m² at DFT 10 µm

3) Theoretical consumption related on a smooth surface. Dependent on surface roughness and processing losses, different consumption data will be achieved in practice.

COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C



Airless



High pressure







Roller/Brush application ⁴⁾

Nozzle diameter (mm)	0.38 to 0.48	1.5 to 2.0	-
Material pressure (bar)	200 to 300	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	60 to 100	60 to 100	40 to 60
Addition of thinner (%)	0 to 5	5 to 10	0 to 5

* DFT = Dry Film Thickness

4) recommended only for small areas

	Pot life at	10 °C	20 °C	30 °C
		3 hours	1,5 hours	approx. 45 minutes

Drying/Curing times at 80 µm DFT		Ambient air temperature		
		10 °C	20 °C	30 °C
	dust-free:	90 minutes	40 minutes	30 minutes
	tack-free:	≤ 12 hours	≤ 6 hours	≤ 4 hours
	dry to handle:	≤ 16 hours	≤ 8 hours	≤ 6 hours

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")
J (Two-pack reactive performance coatings) Type Lb	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Required priming coats respectively intermediate coats (see page 3)

- Remove adhesion-reducing substances


	Air and surface temperatures ≥ 7 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C

Further details for processing and execution are described in the relevant applicable instructions.


PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½ in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	Priming coats	GEHOPON-E97R-Zink GEHOPON-E90R-Metallgrund	80 80 to 160
	Intermediate coats	GEHOPON-E97R-ZB WIEREGEN-M97R-ZB GEHOPON-E90R-ZB	80 80 80 to 160
	Top coat	WIEREGEN-M90	80

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, with appropriate surface preparation

		Product(s) (other paint systems on request)	NDFT (µm)
	Intermediate coats	GEHOPON-E60-Korrogrund GEHOPON-E90R-ZB GEHOPON-E97R-ZB GEHOTEX-W91	80 to 160 80 to 160 80 80 to 120
	Top coat	WIEREGEN-M90	80

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES



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

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.