





MAIN PRODUCT PROPERTIES

- High-grade 2C-PUR top coat for steel buildings and steel constructions
- Nominal dry film thicknesses of 80 µm by spraying, of approx. 60 µm by brush application or roller coating
- Excellent recoatability after cleaning of the surface

PRODUCT DATA

WIEREGEN-M924	RAL colours, satin glossy
 M924-S...	RAL colours (other colours on request)
 Mixing ratio by weight	10:1 with curing agent DX-924
 Thinner V-89	

WIEREGEN-M924	Guide values RAL colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	1.45	78	22	63,5	440
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ² ²⁾	Spreading rate (m ² /kg)	Spreading rate (m ² /L)
	80	124	0.185	5.4	7.85

1) Guide values averaged data, slight deviations are possible depending on the colour
2) 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

Nozzle diameter (mm)	0.33 to 0.58	1.5 to 2.0	-
Material pressure (bar)	150 to 250	-	-
Atomiser pressure (bar)	-	3.0 to 4.0	-
DFT * per working operation (µm)	80	80	40 to 60
Addition of thinner (%)	0 to 3	4 to 6	0 to 1

* DFT = Dry Film Thickness

	Pot life at	10 °C	20 °C	30 °C
		10 hours	6 hours	4 hours

Drying/Curing times at 80 µm DFT		Ambient air temperature		
		7 °C	23 °C	30 °C
	dust-free:	≤ 5 hours	≤ 2 hours	≤ 1 hour
	tack-free:	≤ 24 hours	≤ 4 hours	≤ 2.5 hours
	dry to handle:	≤ 72 hours	≤ 16 hours	≤ 12 hours
	overcoating interval:	10 °C	20 °C	30 °C
		after approx. 24 hours	after approx. 16 hours	after approx. 12 hours

Notes referring to Directive 2004/42/EC "Decopaint-Directive"

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready-for-use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
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 temperature
≥ 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 coat	RWE Code No.: GB-20-S-1024 GEHOPON-E920-Metallgrund-Rapid	120
	Intermediate coat	RWE Code No.: ZB-22-S-6011 GEHOPON-E922-ZB	120
	Top coat	RWE Code No.: DB-24-S... WIEREGEN-M924	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 coat	RWE Code No.: GB-21-S-3009 GEHOPON-E921-Protect	80
	Top coat	RWE Code No.: DB-24-S... WIEREGEN-M924	80

SAFETY MEASURES



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