

MAIN PRODUCT- PROPERTIES	 High-grade, 2C-Epoxy High-Solid priming coat Nominal dry film thicknesses of 80 to 120 µm per working operation paintable Direct coating of new hot-dip galvanised surfaces without sweeping with excellent adhesion is possible even under high atmospheric stress 			
PRODUCT DATA	GEHOPON-C0034			
	C0034-850 Red brown (other colours on request)			
	Mixing ratio by weight 7:1 with curing agent EX-40			

AB

GEHOPON-C0034 / Guideline ¹⁾

Thinner V-74

7 8 9 ÷ 4 5 6 × 1 2 3 + 0 , =	Density (g/mL) 1.45	Solid content (weight %) 81.0	VOC-content (weight %) 19.0	Solid conte (%) 68.0	nt by volume (mL/kg) 465
	DFT * (μm) 80	Calculated wet-film thickness (µm) 120	VOC-content (g/m ²) ²⁾ 4.1	Consumption (kg/m ²) ³⁾ 0.175	Spreading rate (m²/kg) 5.7

1) Guideline averaged data, slight deviation are possible depending on the colour

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

Recommendation at

temperatures

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

of approx. 20 °C			
	Airless	Low pressure	Roller/Brush application 4)
Nozzle diameter (mm)	0.33 to 0.43	2.5 to 3.0	-
Material pressure (bar)	150 to 250	20 to 30	-
Atomiser pressure (bar)	•	6.0 to 8.0	-
DFT * per working operation (μm)	80 to 120	80 to 120	60 to 80
Addition of thinner (%)	0 to 2	0 to 2	0 to 2

* DFT = Dry Film Thickness

4) recommended only for smaller areas, formation of a product-specific surface structure is possible

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Pot life

GEHOPON-C0034

2C-EP-HS Priming coat

COMMENTS ON PROCESSING



approx. 4 hours (relating on 20 to 25 °C)

Drying/Curing times at 80 μm DFT		Ambient air temperature			
		5 to 10°C	10 to 15°C	15 to 20°C	
<u>StStStS</u>	dust-free:	after 4 hours	after 2 hours	after 1 hour	
	tack-free:	after 24 to 48 hours	after 8 to 12 hours	After 4 to 6 hours	
	overcoating interval / dry to handle:	after 3 to 4 days	after 2 days	after 1 day	

The maximum waiting time until application of the top coat must not exceed 5 days, particularly in the case of natural weathering. Coated surfaces that should be recoated after waiting times> 5 days must be roughened by lightly oversweeping or grinding.

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

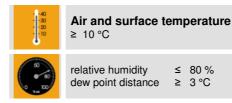
Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product	
	(Phase II from 2010)	in its ready for use condition (including the max. amount of diluents as given in "Application methods")	
J ("Two-pack reactive performance coatings") Type SB	500 g/l	< 500 g/l	

INSTRUCTIONS FOR APPLICATION

Surface preparation

Hot-dip galvanised steel surfaces

- Freshly hot-dip galvanised surfaces can be coated directly with GEHOPON-C0034. Assumptions are dry, clean surfaces without visible zinc reaction products (white rust, etc.)
- In the case of special loads for inaccessible areas and in the presence of visible zinc reaction products: Sweep blasting in accordance with EN ISO 12944-4. The surface must have a uniform dull appearance after surface preparation.



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PAINT SYSTEMS	Substrat	ate: hot-dip galvanised steel in accordance with EN ISO 1461, sweep blast-cleaning in accordance with EN ISO 12944-4			
EXAMPLES	Protective coating		Product(s) (other paint systems on request)	NDFT (µm)	
		Protective coating	GEHOPON-C0034	80	

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.

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