GEHOPON-E24-Haftgrund

2C-EP Adhesion primer

MAIN PRODUCT-PROPERTIES

- **High-grade, multi-purpose 2-pack Epoxy Adhesion primer on hot-dip galvanising, stainless steel, concrete, fibre cement and mineral plaster**
- **Excellent adhesion directly on previously mentioned substrates after appropriate surface preparation**
- **Nominal dry film thicknesses up to 80 µm by spraying, of approx. 60 µm by brush or roller coating**

PRODUCT DATA

GEHOPON-E24-Haftgrund

E24-750 Light grey
E24-940 White
(other colours on request)

Mixing ratio by weight
8:1 with curing agent EX-4

Thinner V-538

GEHOPON-E24-Haftgrund / Guideline [1]

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.55	**75.0**	**25.0**	**55.0**	**355**

DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [2]	Consumption (kg/m²) [3]	Spreading rate (m²/kg)
80	**145**	**7.5**	**0.225**	**4.4**

1) Guideline averaged data, slight deviation 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
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**	**50**	**50 to 70**
Addition of thinner (%)	**0 to 3**	**5 to 10**	**0 to 1**
Pot life at	**10 °C**	**20 °C**	**30 °C**
	8 hours	6 hours	4 hours

* DFT = Dry film thickness

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Drying/Curing times at 80 µm DFT		Ambient air temperature		
		7 °C	**23°C**	**30°C**
	dust-free:	after ≤ 2 hours	after ≤ 1 hour	after approx. 30 minutes
	tack-free:	after ≤ 12 hours	after ≤ 6 hours	after ≤ 3 hours
	dry to handle:	after ≤ 20 hours	after ≤ 10 hours	after ≤ 6 hours
	overcoating interval:	**10 °C**	**20°C**	**30°C**
		after approx. 16 hours	after approx. 12 hours	after approx. 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 SB	500 g/l	< 500 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances and zinc reaction products through suitable measures
- At natural weathering or expected condensation stress of coated, hot-dip galvanised steelparts:
  Sweep blast-cleaning according to EN ISO 12944-4.
  The surface must have a uniform dull appearance after surface preparation.

Existing Priming coat or old coating

- Remove adhesion-reducing substances, e. g. cleaning, washing

Cement and asbest cement

- Must be dry as well as free of oil and grease. Loose and mellow components on the surface have to be removed.
- Since the surface properties of the individual materials can be different, we recommend test coats with the entire coating system, especially for larger series or objects.

Air and surface temperature
≥ 10 °C

relative humidity ≤ 80 %
dew point distance ≥ 3 °C

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

PAINT SYSTEMS

EXAMPLES

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, sweep blast-cleaning in accordance with EN ISO 12944-4

	Product(s) (other paint systems on request)	**NDFT (µm)**
Priming coat	GEHOPON-E24-Haftgrund	80
Optional Intermediate coats	GEHOPON-E87-ZB WIEREGEN-M87-ZB	80
Top coats	WIEREGEN-M87	80

SAFETY MEASURES

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