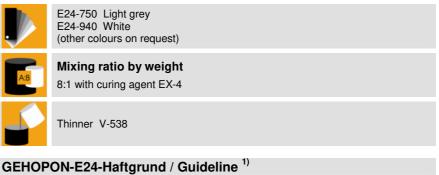


MAIN PRODUCT-PROPERTIES

- 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



Density Solid content VOC-content Solid content by volume

7 8 9 +	(g/mL)	(weight %)	(weight %)	(%)	(mL/kg)
4 5 6 x	1.55	75.0	25.0	55.0	355
123+ 0,=	DFT * (μm) 80	Calculated wet-film thickness (µm) 145	VOC-content (g/m ²) ²⁾ 7.5	Consumption (kg/m ²) ³⁾ 0.225	Spreading rate (m²/kg) 4.4

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

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

Recommendation at

temperatures of approx. 20 °C

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

	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
	10 °C	20 °C	30 °C
Pot life at	8 hours	6 hours	4 hours

* DFT = Dry film thickness

D-76676 Graben-Neudorf D-47249 Duisburg D-01683 Nossen Sofienstraße 36 Obere Kaiserswerther Straße 18 Gewerbestraße 8 Tel. +49 7255 99-0 Tel. +49 203 99707-0 Tel. +49 35242 6565-0 Fax +49 7255 99-123 Fax +49 203 99707-10 Fax +49 35242 6565-29



GEHOPON-E24-Haftgrund

2C-EP Adhesion primer

Drying/Curing times at 80 μm DFT		Ambient air temperature		
		7 °C	23°C	30°C
StStStS	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"

Subactorery on referred	VOC limit values	Max. VOC content of the product
Subcategory as referred to in Annex IIA	(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

- 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.

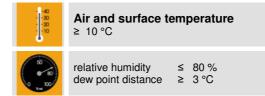
The surface must have a uniform dull appearance after surface preparation.

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.



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

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PAINT SYSTEMS

EXAMPLES

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

7		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.

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.

D-76676 Graben-Neudorf D-47249 Duisburg D-01683 Nossen

Sofienstraße 36 Obere Kaiserswerther Straße 18 Gewerbestraße 8

Tel. +49 7255 99-0 Tel. +49 203 99707-0 Tel. +49 35242 6565-0 Fax +49 7255 99-123 Fax +49 203 99707-10 Fax +49 35242 6565-29