

## MAIN PRODUCT-PROPERTIES

- **High-grade, 2-pack Epoxy High-Solid Intermediate coat**
- **Nominal dry film thicknesses of 80 to 160 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-E5-Protect



E5-7832, Pepple grey approx. RAL 7032  
E5-7601, MIO, grey DB 701  
E5-7602, MIO, grey DB 702  
(other colours on request)




#### Mixing ratio by weight

9:1 with curing agent EX-40



Thinner V-568

### GEHOPON-E5-Protect / Guideline <sup>1)</sup>

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%) (mL/kg)	
	<b>1.45</b>	<b>78.0</b>	<b>22.0</b>	<b>63.0</b>	<b>435</b>
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m <sup>2</sup> ) <sup>2)</sup>	Consumption (kg/m <sup>2</sup> ) <sup>3)</sup>	Spreading rate (m <sup>2</sup> /kg)
	<b>80</b>	<b>125</b>	<b>5.0</b>	<b>0.185</b>	<b>5.4</b>

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

2) Based on consumption in g/m<sup>2</sup> 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 <sup>4)</sup>**

<b>Nozzle diameter (mm)</b>	<b>0.38 to 0.74</b>	<b>1.5 to 1.8</b>	-
<b>Material pressure (bar)</b>	<b>150 to 300</b>	-	-
<b>Atomiser pressure (bar)</b>	-	<b>3.0 to 4.0</b>	-
<b>DFT * per working operation (µm)</b>	<b>80 to 160</b>	<b>60 to 120</b>	<b>60 to 80</b>
<b>Addition of thinner (%)</b>	<b>2 to 4</b>	<b>10 to 15</b>	<b>0 to 2</b>

\* DFT = Dry Film Thickness




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

## COMMENTS ON PROCESSING



### Pot life

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

Drying/Curing times at 160 µm DFT	Ambient air temperature		
	5 to 10°C	10 to 15°C	15 to 20°C
 dust-free:	after 4 hours	after 2 hours	after 1 hour
 tack-free:	after 24 to 48 hours	after 12 to 16 hours	After 6 to 8 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 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 SB	500 g/l	< 500 g/l

## INSTRUCTIONS FOR APPLICATION

### Surface preparation

#### Required Priming coats (see below)

- Remove adhesion-reducing substances

#### Hot-dip galvanised steel surfaces

- New hot-dip galvanised surfaces can be coated directly with GEHOPON-E5-Protect. 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.



### Air and surface temperature

≥ 10 °C




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

**PAINT SYSTEMS**

**EXAMPLES**

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

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> (µm)
	<b>Priming coats</b>	GEHOPON-E87-Zink GEHOPON-E87-Metallgrund GEHOPON-E5-Korrogrund	80
	<b>Intermediate coat</b>	GEHOPON-E5-Protect	80 to 160
	<b>Top coats</b>	WIEREGEN-M87 WIEREGEN-M29 GEHOTEX-W92	80

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

		<b>Product(s)</b> (other paint systems on request)	<b>NDFT</b> (µm)
	<b>Intermediate coat</b>	GEHOPON-E5-Protect	80 to 160
	<b>Top coats</b>	WIEREGEN-M87 WIEREGEN-M29 GEHOTEX-W92	80

**SAFETY MEASURES**



The relevant data can be found in the current material safety data sheets, available at [www.geholti-wierner.de](http://www.geholti-wierner.de).

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