GEHOPON-E63(-Aluminium)

2C-EP-HS Monolayer

MAIN PRODUCT-PROPERTIES

- **High-grade, flat High-solid Monolayer based on epoxy resin with excellent corrosion protection properties especially for interior coating**
- **Suitable in coating system e. g. with WIEREGEN-M87 for corrosivity category C4 to C5**
- **With dry film thicknesses from 100 to 160 µm suitable for corrosivity categorie C1, C2 and C3 high durability**
- **Excellent chemical and mechanical resistance**

PRODUCT DATA

GEHOPON-E63, GEHOPON-E63-Aluminium	**RAL-colours, flat**
	E63-F.... (RAL-colours, other colours on request) E63-F7701 Aluminium
	**Mixing ratio by weight** 6:1 with curing agent EX-91S
	Thinner V-538

GEHOPON-E63	**Guideline RAL-colours** [1]			
Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.6	**82.0**	**18.0**	**68.0**	**425**
DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [1]	Consumption (kg/m²) [2]	Spreading rate (m²/kg)
100	**145**	**4.2**	**0.235**	**4.3**

GEHOPON-E63-Aluminium	**Guideline RAL-colours** [1]			
Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.45	**76.5**	**23.5**	**60.5**	**415**
DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [2]	Consumption (kg/m²) [3]	Spreading rate (m²/kg)
100	**166**	**5.6**	**0.240**	**4.2**

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

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COMMENTS ON PROCESSING

Recommendation at temperatures of approx. 20 °C

	Airless	Airmix	Roller/Brush application [4]
Nozzle diameter (mm)	**0.38 to 0.74**	**0.34 to 0.69**	**-**
Material pressure (bar)	**150 to 350**	**100 to 150**	**-**
Atomiser pressure (bar)	**-**	**2.0 to 2.5**	**-**
DFT * per working operation (µm)	**100 to 160**	**100 to 160**	**60 to 80**
Addition of thinner (%)	**0 to 4**	**0 to 4**	**0 to 2**

* DFT = Dry Film Thickness

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

Pot life at	**20 °C**
	6 to 8 hours

Drying/Curing times at 160 µm DFT	**Ambient air temperature**
	20 °C
dust-free:	after approx. 30 minutes
tack-free:	after approx. 3 to 4 hours
overcoating interval / dry to handle	after approx. 8 to 10 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

Steel surfaces

- Mechanical or manual derusting in preparation grade PMa respectively St 3 according to EN ISO 12944-4

Existing coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of old coatings compatibility tests are recommended.

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

	Product(s) (other paint systems on request)	NDFT (µm)
Monolayer	GEHOPON-E63 GEHOPON-E63-Aluminium	100 to 160
Optional Top coats	WIEREGEN-M87 WIEREGEN-M97R WIEREGEN-M165R	80

Substrate: steel, mechanical or manual derusting PMa/St3 if applicable with old coating

	Product(s) (other paint systems on request)	NDFT (µm)
Monolayer	GEHOPON-E63-Aluminium	100 to 160
Optional Intermediate coats	GEHOPON-E63 GEHOPON-E63-Aluminium	80
Optional Top coats	WIEREGEN-M87 WIEREGEN-M97R WIEREGEN-M165R	80

Several coating systems for the corrosivity categories C3 to CX according to EN ISO 12944-5 are possible. Please ask for our advice for your special application.

SAFETY MEASURES

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