MAIN PRODUCT-PROPERTIES

- **1C-AY Hydro Monolayer in particular for reconstruction of interior steel constructions, e. g. steel halls for production, logistics, automotive industry etc.**
- **Excellent adhesion on steel and hot-dip galvanised steel**
- **High compatibility with plenty of intact, sustainable old coatings**
- **Especially adjusted for the processing by roller coating respectively brush application of 50 to 70 µm**
- **At large-area damage of old coating, spotting with the optional priming coat GEHOTEX-W5-Korrogrund is recommended**

PRODUCT DATA

GEHOTEX-W23B	**RAL-colours, flat**
	W23B-F... (RAL-colours, other colours on request)
	**Mixing ratio by weight** not relevant
	Demineralised water or water of low hardness

GEHOTEX-W23B **Guideline RAL-colours** [1)]

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.35	**63.0**	**< 4**	**50.0**	**370**

DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m²) [2)]	Consumption (kg/m²) [3)]	Spreading rate (m²/kg)
60	**120**	**1.1**	**0.165**	**6.1**

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)	**0.35 to 0.53**	**-**	**-**
Material pressure (bar)	**150 to 250**	**-**	**-**
Atomiser pressure (bar)	**-**	**-**	**-**
DFT * per working operation (µm)	**60 to 100**	**-**	**50 to 70**
Addition of thinner (%)	**0 to 3**	**-**	**-**

*) DFT = Dry film thickness

COMMENTS ON PROCESSING

Pot life
Not relevant

Drying/Curing times at 60 µm DFT		Ambient air temperature 20 °C
	dust-free:	after 60 to 90 minutes
	tack-free:	after approx. 3 to 4 hours
	overcoating interval / dry to handle:	after 16 to 24 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”)
i (“One-pack performance coatings”) Type WB	140 g/l	< 140 g/l

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces with existing old coating

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At partial corrosion: mechanical or manual derusting in preparation grade PMa respectively PSt 2 according to EN ISO 12944-4
- Before overcoating of old coatings compatibility tests are recommended

Weathered, hot-dip galvanised steel surfaces

- Remove adhesion-reducing substances, especially zinc salts, e. g. cleaning, washing, alcaline wetting agent washing, alternatively
- Sweep blast-cleaning according to EN ISO 12944-4.
  The surface must have a uniform dull appearance after surface preparation.

Air and surface temperature
10 to 40 °C

relative humidity ≤ 80 %
dew point distance ≥ 3 °C
Ensure sufficient air movement during drying

PAINT SYSTEMS

EXAMPLES

Substrate: steel, blast-cleaning in surface preparation grade Sa 2 ½, mechanical or manual derusting St 2 in accordance with EN ISO 12944-4 if applicable with old coating

	Product(s) (other paint systems on request)	NDFT (µm)
Optional Priming coat	GEHOTEX-W5-Korrogrund	40 to 60
Monolayer	GEHOTEX-W23B	50 to 70

Substrate: hot-dip galvanised steel in accordance with EN ISO 1461, if applicable with old coating

	Product(s) (other paint systems on request)	NDFT (µm)
Optional Priming coat	GEHOTEX-W5-Korrogrund	40 to 60
Monolayer	GEHOTEX-W23B	50 to 70

Several coating systems 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.