MAIN PRODUCT-PROPERTIES

- **1C-AY Hydro Monolayer for high-grade corrosion protection of steel constructions, e. g. steel hall construction, apparatus construction, crane construction**
- **Application in the shop by airless-spraying with nominal dry film thicknesses of 80 to 120 µm, e. g. in automatic systems**
- **As monolayer with 100 µm suitable for corrosivity category C1, C2, high durability**
- **Third party tested by IKS Dresden GmbH report PB300/272/12**
- **For higher corrosion stress in multi-layered systems together with suitable optional top coats**

PRODUCT DATA

GEHOTEX-W9	**RAL-colours, mat**
	W9-M.... (RAL-colours, other colours on request)
	**Mixing ratio by weight** not relevant
	Demineralised water

GEHOTEX-W9	**Guideline RAL-colours** [1]			
	Density (g/mL) **1.3**	Solid content (weight %) **62.0**	VOC-content (weight %) **< 6**	Solid content by volume (%) **50.0** / (mL/kg) **385**
	DFT * (µm) **100**	Calculated wet-film thickness (µm) **200**	VOC-content (g/m²) [2] **1.6**	Consumption (kg/m²) [3] **0.260**	Spreading rate (m²/kg) **3.8**

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** [4]
Nozzle diameter (mm)	**0.33 to 0.58**	**-**	**-**
Material pressure (bar)	**200 to 300**	**-**	**-**
Atomiser pressure (bar)	**-**	**-**	**-**
DFT * per working operation (µm)	**80 to 120**	**-**	**60 to 80**
Addition of thinner (%)	**0 to 5**	**-**	**0 to 2**

*) DFT = Dry film thickness

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

COMMENTS ON PROCESSING

Pot life
Not relevant

Drying/Curing times at 100 µm DFT	Ambient air temperature 20 °C
dust-free:	after 45 to 60 minutes
tack-free:	after 1.5 to 2 hours
dry to handle: overcoating interval with 1C-paint: overcoating interval with 2C-paint:	after 6 to 8 hours after 8 hours after 5 days

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

- Sweep blast-cleaning according to EN ISO 12944-4 alternatively in industrial application areas
- Remove adhesion-reducing substances, e. g. cleaning, washing, phosphating

Existing (Pre-Fab-)coatings

- Remove adhesion-reducing substances, e. g. cleaning, washing
- Before overcoating of other priming coats compatibility tests are recommended

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 in accordance with EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT (µm)
	**Priming coat / Monolayer**	GEHOTEX-W9	80 to 120
	Optional Top coats	WIEREGEN-M87 WIEREGEN-M97R GEHOTEX-W92	80

SAFETY MEASURES

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