LACK– UND KUNSTSTOFF– CHEMIE GMBH

TECHNICAL INFORMATION

WIEREGEN-ACU-Metallgrund

2C-PUR Primer
light grey, M4-708

■ FIELDS OF APPLICATION

Protective primer coating for subsequent PUR-based two-pack coating systems, for machines, geared motors, installations and devices in aggressive atmosphere, in nuclear power plants and the like.

■ PRODUCT PROPERTIES

As a binder, WIEREGEN-ACU-Metallgrund contains a polyacrylate resin combined with a special polyisocyanate as hardening agent.

Capacities

Due to its composition WIEREGEN-ACU-Metallgrund is excellently suitable for subsequent two-pack coating systems. Together with suitable two-pack top coats, coatings can be produced with excellent resistance against chemicals, aggressive atmosphere, light- and weather fastness.

Temperature resistance (dry heat): 120 °C long term
150 °C short term resistance

■ TECHNICAL DATA

	WIEREGEN-ACU-Metallgrund	Curing Agent
Product Number and Colour	M4-708 light grey	DX-10
Mixing ratio	14 parts by weight	1 part by weight

Shelf life At least 18 months in original cans at normal temperature

Appropriate Thinner V-562

Theoretical parameters

WIEREGEN-ACU-Metallgrund light grey, M4-708

Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	VOC-content per 10 µm DFT* (g/m²)	Solid content by volume (%)	Solid content by volume (mL/kg)
1.35	69	31	8.0	52	390
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
50	95	0.128		7.8	

Remarks
- All values are relevant for the mixture in case of two-pack materials
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour). The values may differ slightly for other colours.

* baseline for calculation: consumption in g/m² at DFT 10 µm

Suitable coating Systems The choice of primers and top coats as well as their number and thickness of layer depends on the stress to be expected, the existing prescriptions (specifications) and the methods of application.

It is recommended to specify the coating systems, which must be adjusted to the intended use, in instructions and specifications.

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■ INSTRUCTIONS FOR APPLICATION

Surface Preparation Blast-cleaning in accordance with EN ISO 12944-4, surface preparation grade Sa 2 ½.

Processing Temperature (Air and Surface) Optimal at 15 to 25 °C, not below 10 °C

Relative Humidity max. 80% relative humidity

The surface temperature of the parts to be coated must be at least 3°C above the dew point of the surrounding air throughout the application. (cf. basic specification for Corrosion protection EN ISO 12944-7)

Comments on processing

Mixing Mix with the pre-packed quantity of hardener, preferably with a mechanical stirrer. Material must be stirred again after 15 minutes. Then the mixture is ready to use

Application methods

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner V-562
Airmix spraying Nozzle diameter 0.33 to 0.38 mm Material pressure 70 to 90 bar Atomiser pressure 1,5 bis 2,5 bar	50 µm	5 to 10 %
High pressure/air spraying Nozzle diameter 1.2 to 1,5 mm Air pressure 3 to 4 bar	50 µm	10 – 15 %
Roller coating / brush application	50 µm	up to 2 %
In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.		

Remarks

- The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

Cleaning of equipment Use thinner V-562

Pot life 4 to 6 hours (dependent on temperature)

Curing times Related to a temperature of 20 °C and 50 µm of dry film thickness

Dry to touch: after ca. 30 minutes

Tack free: after 2 to 3 hours

Ready for re-coating with WIEREGEN-ACU, M26- after 20 to 30 minutes

■ SAFETY MEASURES

The relevant data concerning safety measures can be found in the material safety data sheet of this product.
The valid issue of the material safety data sheet is available from our website www.geholit-wiemer.de.