LACK– UND KUNSTSTOFF– CHEMIE GMBH

TECHNICAL INFORMATION

WIEREGEN-C0030

2C-PUR Monolayer

■ FIELDS OF APPLICATION

Two-pack protective coating with high mechanical resistance for steel structures.
At low corrosion stresses (categories C1, C2 and C3-Medium according to EN ISO 12944-2) as a mono-layer system with a nominal dry film thickness of 100 µm.
At higher corrosion stresses (C3-High or higher according to EN ISO 12944-2) in multi-layer systems together with suitable top coatings (e.g. WIEREGEN-C0050).

■ PRODUCT PROPERTIES

WIEREGEN-C0030 provides excellent adhesion directly on blasted steel and is tack free (ready for transport) after 1,5 to 2 hours (at approx. 80 to 100 µm DFT and 20 °C).

Capacities

Together with suitable primer and if necessary intermediate coatings protective coating systems will be obtained with excellent resistance properties in areas with high humidity or aggressive atmosphere and against different chemicals.

■ PRODUCT DATA

	WIEREGEN-C0030	Curing agent
Product number	C0030-F.... (depending on colour)	DX-10
Colour	RAL colours	
Mixing ratio	16 parts by weight	1 part by weight

The material can also be applied by two-pack application systems. Please feel free for our technical advice.

Degree of gloss flat

Form of delivery Ready for application after mixture with curing agent

Shelf life At least 12 months in original cans at normal temperature

Suitable thinner V-562

Theoretical parameters

WIEREGEN-C0030, C0030-F7201

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)
1.5	76	24	6.0	60	400
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m²)		Spreading rate (m²/kg)	
80	133	0.200		5.0	

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

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

Coating systems

Substrate	Steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4	
	Product	**NDFT (µm)**
Single-layer protective coating	WIEREGEN-C0030	80 to 100

Substrate	Steel	
Surface preparation	Blast-cleaning in preparation grade Sa 2 ½ in accordance with EN ISO 12944-4	
	Product	**NDFT (µm)**
Primer coating	WIEREGEN-C0030	80
Top coating	WIEREGEN-C0050	60 to 80

The coating system/s named are examples proved in practice which usually can be modified. The choice of coating materials as well as their number and film thickness depends on the stress to be expected, existing specifications and the methods of application.

■ INSTRUCTIONS FOR APPLICATION

Surface preparation

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

Air and surface temperature

Optimal results at temperatures of 15 to 25 °C, not below 5 °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. (see basic specification for corrosion protection EN ISO 12944-7)

Comments on processing

Mixing

Mix thoroughly with the enclosed quantity of curing agent, preferably with a mechanical mixer. Material must be stirred again after 15 minutes. Then the mixture is ready for use.

Application methods

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner V-562
Airless spraying Nozzle diameter: 0.33 to 0.43 mm Material pressure: 100 to 150 bar ESTA application is also possible	80 to 100 µm	up to 2 %
Roller coating / brush application	60 to 80 µm	up to 4 %
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.

Pot life 4 to 6 hours (depending on temperature)

Drying and curing times
Drying stage in accordance with DIN 53150 at 100 µm DFT

Air temperature	+ 5 °C	+ 10 °C	+ 20 °C
Drying stage 1 (dry to touch)	≤ 60 min.	≤ 45 min.	≤ 30 min.
Drying stage 3 (tack free)	3 - 4 h	2 - 3 h	1 - 2 h
Drying stage 6 (ready for re-coating)	approx. 8 h	approx. 8 h	3 - 4 h

■ 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.