

**MAIN PRODUCT-
PROPERTIES**

- Monolayer 2C-PUR structure coating with high mechanical and chemical durability
- Different structures realizable
- Excellent absorption of overspray

PRODUCT DATA

WIEREGEN-D133S-Struktur, satin glossy



D133S-S...(RAL-colours, other colours on request)



Mixing ratio by weight

6:1 with curing agent DX-10



Thinner V-562 (Standard: air temperature 5 to 25 °C)
Thinner V-560 (Slow: air temperature 25 to 40 °C)

WIEREGEN-D133S-Struktur / Guide values

	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume	
				(%)	(mL/kg)
	1.40	77.0	23.0	63.0	450
	DFT * (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m ²)	Spreading rate (m ² /kg)	
	100	153	0.220	4.5	

**COMMENTS ON
PROCESSING**

Recommendation at
temperatures
of approx. 20 °C



Airmix ¹⁾



High
pressure



Roller/Brush
application

Application viscosity (s) (8 mm DIN-cup)	12 to 16	12 to 16	12 to 16
Nozzle diameter (mm)	0.33 to 0.43	2.0 to 3.0	-
Material pressure (bar)	150 to 200	-	-
Atomiser pressure (bar)	2.0 to 3.0	3.0 to 4.0	-
DFT * per working operation (µm)	100	100	80
Addition of thinner (%)	0 to 2	0 to 2	0 to 4

¹⁾ only recommended for precoating in multi-layer process



Pot life

75 to 90 minutes (relating to temperature)

* DFT = Dry Film Thickness

Drying/Curing times at 100 µm DFT		Ambient air temperature 20 °C
	touch dry:	after 20 minutes
	tack free:	after 3 to 4 hours
	ready for overcoating / handling:	after 5 to 6 hours

INSTRUCTIONS FOR APPLICATION

Surface preparation

Steel surfaces and cast iron

- Remove adhesion-reducing substances e. g. cleaning, washing, phosphating
- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4, Roughness grade medium (G) according to EN ISO 8503-1

Hot-dip galvanised steel surfaces and aluminium/cast aluminium

- Remove adhesion-reducing substances, e. g. cleaning, washing
- At natural weathering or condensation:
Sweep blast-cleaning according to EN ISO 12944-4.
After sweep blast-cleaning the surface shall have a uniformly dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)



Air and surface temperature

optimal between 15 and 25 °C, not below 5 °C, not above 40 °C



max. 80 % relative humidity

PAINT SYSTEMS

EXAMPLES

	Product(s) (other paint systems on request)
 Priming coats	GEHOPON-E44R-Metallgrund GEHOPON-E45R-Metallgrund GEHOPON-E90RI-Metallgrund GEHOPON-EW19-Metallgrund
Monolayer / Top coat	WIEREGEN-D133S-Struktur

SAFETY MEASURES



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

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision or construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.