





MAIN PRODUCT-PROPERTIES

- 2-pack PUR protective coating with high mechanical resistance for steel buildings, apparatus construction, machine building industry
- With nominal dry film thickness of 80 to 120 µm suitable for corrosivity category C1, C2 and C3 expected durability medium - for steel and galvanised steel constructions
- Third party tested by Fraunhofer Institut IFAM, Bremen. Test report: KT-PB-110-13, A419810
- With suitable priming coats or top coats also suitable for higher corrosion stresses
- Excellent recoatability after cleaning of the surface

PRODUCT DATA

WIEREGEN-M15RN	RAL-colours, flat
	M15RN-F.... (RAL-colours, other colours on request)
	Mixing ratio by weight 17:1 with curing agent DX-10
	Thinner V-89

WIEREGEN-M15RN	Guideline RAL-colours ¹⁾				
	Density (g/mL)	Solid content (weight %)	VOC-content (weight %)	Solid content by volume (%)	Solid content by volume (mL/kg)
	1.45	76.0	24.0	60.0	415
	DFT * (µm)	Calculated wet-film thickness (µm)	VOC-content (g/m ²) ²⁾	Consumption (kg/m ²) ³⁾	Spreading rate (m ² /kg)
	100	166	5.8	0.240	4.2

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)	0.33 to 0.53	1.5 to 2.0	-
Material pressure (bar)	300 to 400	-	-
Atomiser pressure (bar)	-	4.0 to 6.0	-
DFT * per working operation (µm)	100	100	80
Addition of thinner (%)	0 to 2	5 to 10	0 to 4

* DFT = Dry Film Thickness

**COMMENTS ON
PROCESSING**

	Pot life	10 °C	20 °C	30 °C
		4 to 5 hours	2 to 3 hours	1 to 1.5 hours

Crying/Curing times at 100 µm DFT	Ambient air temperature		
	10 °C	20 °C	30 °C
 dust free:	after 90 minutes	after 45 minutes	after 30 minutes
 tack free:	after 4 to 6 hours	after 2 to 3 hours	after 1 to 2 hours
 overcoating interval / dry to handle:	after 10 to 12 hours	after 4 to 5 hours	after 3 to 4 hours

Notes referring to Directive 2004/42/EC „Decopaint-Directive“

Subcategory as referred to in Annex IIA	VOC limit values	Max. VOC content of the product in its ready for use condition (including the max. amount of diluents as given in "Application methods")
	(Phase II from 2010)	
J ("Two-pack reactive performance coatings") Type SB	500 g/l	< 500 g/l

**INSTRUCTIONS
FOR APPLICATION**



Surface preparation

Steel surfaces

- Blast-cleaning Sa 2 ½ according to EN ISO 12944-4

Hot-dip-galvanised steel surfaces

- At natural weathering or condensation:
Sweep blast-cleaning according to EN ISO 12944-4.
After sweep blast-cleaning the surface shall have a uniform dull appearance.
- Chemical conversion layer (chromate, chromate free, phosphating)

	Air and surface temperature ≥ 10 °C
	relative humidity ≤ 80 % dew point distance ≥ 3 °C

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
	Protective coat	WIEREGEN-M15RN	80 to 100
	Optional Top coat	WIEREGEN-M29 WIEREGEN-M97R GEHOTEX-W92	80

Substrate: galvanised steel in accordance with EN ISO 1461, cleaning in accordance EN ISO 12944-4

		Product(s) (other paint systems on request)	NDFT
	Protective coat	WIEREGEN-M15RN	80 to 100

Several paint systems for corrosivity category C2 to C5 according to EN ISO 12944-5 are available. For our special application demand please ask for our technical advice.

SAFETY MEASURES



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

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