

HENSOGRUND 1966 E

Solvent based, single pack primer for blasted steel profiles

SUBSTRATES / PROPERTIES

Substrates: **Steel** (Sa 2 ½)

- VOC approx 450 g/l
- Fast drying
- Exposing to natural weathering possible

PRODUCT DATA

HENSOGRUND 1966 E

Colour: red brown, matt | **Packaging:** 6 kg, 13 kg and 25 kg in one-way pails

Preparation: Stir well before use!

Thinning and/or Cleaning with HENSOTHERM® V45

Shelf life: 12 months in unopened original pails at ambient temperatures in dry conditions

HENSOGRUND 1966 E / Reference values (theoretical values without losses)

Specific gravity (g/ml) 1.44	Coverage rate (m²/kg) 8.3–5.2	Volume solid (%) 46
Consumption rate (kg/m²) 0.120–0.190	Wet film thickness (µm) 90–130	Dry film thickness (µm) 40–60

APPLICATION INSTRUCTIONS

Recommendation at temperatures of approx +20 °C



Airless



Roller / Brush

Nozzle size (inch)	0.013	-
Operation pressure (bar)	150–250	-
DFT* per layer (µm)	60–80	40–60
Thinning (%)	3–5	0

*DFT = Dry film thickness


Natural weathering

From 60 µm dry film thickness: up to 3 months

From 80 µm dry film thickness: up to 6 months

After exposure of primed profiles to natural weathering they must be inspected for damages and dry film thickness; if necessary they must be reworked before application of HENSOTHERM®.

Note: Before the application of HENSOTHERM® the surface shall be cleaned to remove contamination and to ensure adhesion. Cleaning by sweep-blasting is mandatory for a later use outdoors and / or at higher humidity.

Drying time at 60 µm DFT	Ambient temperature +20 °C
 Dust dry: Ready for overcoating: Ready for overcoating with HENSOTHERM®:	after approx 1 hour after approx 24 hours after 24 hours
Each layer must be dried through (fingernail test positive) before the next application!	

APPLICATION INSTRUCTIONS

Surface preparation

Steel and cast iron surfaces

- Blasting to surface preparation level Sa 2.5 according to DIN EN ISO 12944-4, surface roughness medium (G) according to DIN EN ISO 8503-1
- Remove all bond damaging substances by e.g. cleaning, washing
- The coverage rate does not consider the correction factor for rough surfaces according to ISO 19840.

Before overcoating with HENSOTHERM®

Before the surface preparation of the HENSOTHERM® fire protection coating all bond damaging substances shall be completely removed. All bond damaging substances shall be removed completely by sweep blasting in case of later use outdoors or in areas with increased relative humidity; adjustment of the dry film thickness if required

Note: For dry film thicknesses (DFT) > 100 µm (max 160 µm) and low temperatures, the drying time may be exceeded up to a minimum of 7 days (!) before overcoating with HENSOTHERM®.



Air and surface temperatures: The temperature of the steel surface and the ambient temperature must remain between +15 °C up to +25 °C during the coating procedure. Not below +10 °C or above +30 °C! During the application, the surface temperature of the coated part must be at least +3 °C above the dew point of the ambient temperature!



Relative humidity max. 80 %

COATING SYSTEMS

Produkte

Primer	HENSOGRUND 1966 E
Fire protection coating	HENSOTHERM® 410 KS, HENSOTHERM® 421 KS, HENSOTHERM® 471 KS, HENSOTHERM® 310 KS, HENSOTHERM® 320 KS, HENSOTHERM® 370 KS
Top coats depending on the system	HENSOTOP SB, HENSOTOP WB, HENSOTOP 2K PU (in RAL, DB, NCS colour shades or in individual colour shades available)

PRECAUTIONS FOR SAFETY USE



Use HENSOTHERM® 1966 E in accordance with all applicable local and national regulations. **Giscode: BS 60**

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