

W-LACK GND 15

PRODUCT DESCRIPTION: Finished base with modified resin base, monocomponent of excellent corrosion protection.

RECOMMENDED USES: Recommended for coating steel structures, parts and equipment in galvanized steel.

CERTIFICATIONS AND APPROVAL: This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:	Component	Content	Package	Unit of measurement
	Monocomponent	3,6 20	3,6 20	L

CHARACTERISTICS: Color:	Ral, Munsell or as per customer standard.		
Gloss:	Gloss	>80 UB	GND 151
	Semigloss	60 – 80 UB	GND 152
	Semi matte	30 – 60 UB	GND 153
	Matte	15 – 30 UB	GND 154
	Ultra matte	0 – 15 UB	GND 155
Volume solid:	40 ± 5% (ISO 3233).		
Expiry Date:	12 months at 25°C.		
Thickness per coat (dry):	40 µm –50 µm		
Theoretical coverage:	8,8 m ² /l without dilution in the thickness of 45 µm dry. Without considering the loss factors in the application.		
Resistance to dry heat:	Maximum temperature 60 °C Organic coatings can undergo alterations of color, gloss and adherence when exposed to temperatures exceeding 60 °C		
Drying:			
	10°C	25°C	35°C
Touch:	18 hours	3 hours	2 hours
Handling:	48 hours	24 hours	16 hours
Final:	240 hours	168 hours	168 hours
Repainting Drying:			
	10°C	25°C	35°C
Min	48 hours	24 hours	16 hours
Max	72 hours	72 hours	72 hours

SURFACE PREPARATION The performance of this product is related to the degree of surface preparation.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

Surface Treatment for Non-Ferrous Metals and Electrolytically Galvanized Parts

Initially remove any dirt and oil from the surface with clean cloths soaked in cleaning solvent according to SSPC SP1. Whenever cleaning a surface with cloths, avoid the use of cotton waste or colored cloths.

Execute a "light sanding" with sandpaper 180 in order to promote roughness. Whenever possible, create criss-cross scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent and change them frequently.

For further information, consult WEG Technical Department.

PREPARATION FOR **Mixture**

TECHNICAL DATA SHEET



APPLICATION

Homogenize the contents of the package by means of mechanical or pneumatic stirring. Ensure that no sediment is settled at the bottom of the package.

Diluent
Alkydic diluent 1024

Dilution
Depending on the application method, dilute at most 20%

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions during the application.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation of the film and appearance and hinder the attainment of the specified thickness.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

Before the application, make sure the equipment and its components are clean and in the best condition.

The data below is a guide, and similar equipment may be used.
Changes in nozzle sizes and pressures may be necessary to improve the spraying characteristics.

Purge the compressed air line to prevent contamination of the coating.

Reinforce all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	20%

Brush:

Only recommended for retouching small areas or strip coat (screws, nuts, weld beads, sharp edges and retouching). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for retouching.

Roller:

Not recommended.

For application with brush, application in two or more passes may be necessary to obtain a uniform layer according to

Cleaning the equipment:

Alkydic diluent 1024

NOTE:

Do not leave material in the hoses, spray guns and equipment used in the spraying. Thoroughly wash all equipment used.

Clean all equipment immediately after use.

PERFORMANCE IN THE APPLICATION

For a good performance of the product, we recommend following the directions below:

It should not be applied in adverse conditions, such as air relative humidity above 85% or on condensed surfaces. Small variations in color, appearance and gloss of the coated parts may occur in periods of high air relative humidity, rainy days, at low temperatures or in situations where the coated parts are placed to dry outdoors.

For a good performance of the product, we recommend following the directions below:

Light colors may require more than one coat for an even coverage.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

In coatings with variation in the application method in the same job, the final appearance and gloss of the painted surfaces may present differences.

Minor variations in color, appearance and gloss (more noticeable in dark colors) may occur, as well as delay in curing and impairment of surface performance, when applied during periods of high air relative humidity, rainy days, low temperatures or in case the coated parts are put to dry outdoors.

In paintings executed on the seafront, if exposed to the action of sea air, we recommend to wash with fresh water between coats eliminating the settled impurities.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. Keep the container tightly closed and away from sources of heat or ignition.

Use only in well-ventilated areas avoiding the accumulation of flammable vapors. Keep the product away from heat and sources of ignition.

Do not inhale mists / vapors / aerosols generated during handling and / or application.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release of the product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without prior inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for the behavior, safety, suitability or durability of the product.

Certain information contained in this datasheet is merely an estimate, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical datasheet.

The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.