ALKLACK N 1259

PRODUCT DESCRIPTION: Bicomponent phenolic finishing paint, with aluminum pigmentation, offering luminous reflectance and resistance to bad weather. Items which comply with Directive Rohs have the description R in the product name.

INTENDED USES: External painting of tanks and piping, as per the Petrobrás painting system.

PACKAGING:

<table>
<thead>
<tr>
<th>Component</th>
<th>ALKLACK N 1259 Aluminum – 10001861 (17.45 L)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Component B</td>
<td>ALKLACK N 1259 – 10001889 (2.55 L)</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Component</th>
<th>ALKLACK N 1259 Aluminum – 10001862 (3.14 L)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Component B</td>
<td>ALKLACK N 1259 – 10001890 (0.46L)</td>
</tr>
</tbody>
</table>

PRODUCT INFORMATION:

<table>
<thead>
<tr>
<th>Colors</th>
<th>Aluminum.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gloss/Aspect</td>
<td>Metallic</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>52 ± 2% (N 1358)</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>12 months at 25°C</td>
</tr>
<tr>
<td>Dry Film Thickness</td>
<td>25 micrometers dry</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>20.80 m²/liter in thickness of 25 micrometers dry and without dilution. Without considering the loss factors in application.</td>
</tr>
<tr>
<td>Resistance to Dry Heat</td>
<td>Maximum temperature 60°C. Organic coatings can undergo alterations of color, gloss and adherence when exposed to temperatures exceeding 60°C</td>
</tr>
</tbody>
</table>

Drying Information

<table>
<thead>
<tr>
<th>Temp (°C)</th>
<th>10°C</th>
<th>25°C</th>
<th>35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Touch</td>
<td>3.5 hours</td>
<td>2.5 hours</td>
<td>2 hours</td>
</tr>
<tr>
<td>Handling</td>
<td>18 hours</td>
<td>16 hours</td>
<td>14 hours</td>
</tr>
<tr>
<td>Final</td>
<td>96 hours</td>
<td>72 hours</td>
<td>60 hours</td>
</tr>
</tbody>
</table>

Overcoating Data

<table>
<thead>
<tr>
<th>Temp (°C)</th>
<th>10°C</th>
<th>25°C</th>
<th>35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Min</td>
<td>28 hours</td>
<td>24 hours</td>
<td>22 hours</td>
</tr>
<tr>
<td>Max</td>
<td>52 hours</td>
<td>48 hours</td>
<td>44 hours</td>
</tr>
</tbody>
</table>
SURFACE PREPARATION

The performance of this product is associated with the degree of surface preparation. Completely remove oil, grease and fat applying a degreasing product or as per cleaning method with solvent of standard SSPC SP1.

The accumulated dirt must be removed, using a dry brush and the soluble salts must be removed, washing with fresh water at high pressure.

ALKLACK N 1259 must be applied on specific primer in order to compose an appropriate painting system. For the correct application of the primer, see its technical bulletin.

Respect the repainting interval of the primer, before applying the finishing. If the repainting time is exceeded, execute sanding as described in technical bulletin of the primer used.

Note: If the maximum interval indicated for application of the subsequent coat is exceeded, it is necessary to proceed with manual / mechanical sanding using sandpaper to break the gloss. This procedure is necessary to obtain adherence between the layers.

For further information contact the Technical Department of WEG (tintas@weg.net).

APPLICATION

Mixture
Homogenize the contents of component A by means of manual, mechanical or pneumatic stirring. Add component A to component B gradually, in the proportions (volume) indicated, under manual stirring, until complete homogenization, respecting the mixture ratio. If necessary, filter in a screen mesh 60.

Mix Ratio
2.82Kg A X 0.67kg B in weight or 6.8 A x 1B in volume

Thinner
Recommended – Alkyd Diluent 1027.

Thinning
Depending upon the application method, dilute at most 10% in volume.

Do not dilute with solvents which are not allowed by the local legislation or exceed the dilution percentage indicated.

Excessive dilution of the paint can affect the forming of the film, the aspect and make it difficult to obtain the thickness specified.
APPLICATION METHODS

The data below is a guide, similar equipment being able to be used.

Changes in the pressures and sizes of the nozzles may be required to improve the spraying features.

Before application ensure that the equipment and respective components are clean and in the best condition.

Empty the compressed air line to avoid contamination of the paint.

Reinforce all the sharp edges, cracks and weld beads with the wide paintbrush, to avoid premature flaws in these areas. When applying by spraying, make an overlap of 50% of each spray gun application, to avoid having uncovered and unprotected areas, ending with a cross transfer.

Airless spray gun:
Use Airless ...................... 60 : 1
Fluid pressure............. 2000 - 2500 psi
Hose .......................... 3/8” internal diameter
Nozzle .......................... 0.013” to 0.017”
Dilution ......................... Max. 5% in volume

Conventional spray gun:
Spray gun ....................... JGA 502/3 Devilbiss
Fluid nozzle ................... FF or E
Air cover ....................... 704
Atomization pressure ...... 60 to 65 psi
Pressure in tank ............ 10 to 20 psi
Dilution ......................... Max. 10% in volume

Wide Paintbrush:
It is only recommended for finishing touches of small areas or “strip coat” (bolts, nuts, weld bead, sharp edges and finishing touches).

Roller:
Use sheep wool or synthetic wool roller resistant to solvents, of short hair and without sewing.

Note: For application by wide paintbrush or roller, it may be necessary to apply two or more strokes to obtain a uniform layer in accordance with the thickness of the film recommended per coat.

Cleaning of equipment: Use Alkyd Diluent 1027.

Do not leave material in the hoses, spray guns and equipment used in the spraying. Wash all the equipment used completely.
APPLICATION PERFORMANCE

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

- For application by wide paintbrush or roller, it may be necessary to apply two or more strokes to obtain a uniform layer in accordance with the thickness of the film recommended per coat.
- In painting executed on the coast, if exposed to the action of salty air, we recommend washing with fresh water between coats eliminating the impurities deposited.
- We only recommend painting if the temperature measured at the surface is at least 3°C above the dew-point temperature.
- There may occur small variances of color, aspect and gloss of the parts applied in periods of high relative air humidity, rainy days, in places with low temperatures or in situations in which the parts are applied and placed to dry in external environments.
- The temperature of the substratum and climatic and environmental conditions may interfere in the drying time of the product.
- For better application properties, the paint temperature shall be between 21-27°C, before mixing and application.
- It shall not be applied in adverse conditions, as relative air humidity (RH) above 85% or condensed surfaces, as the gloss and color may undergo small alterations. They must not be applied on condensed surfaces.
- In painting executed varying the method of applying paints in the same work, it may generate differences of gloss and final aspect of the parts painted.
- The application in thicknesses above that recommended in one layer may lead to failures in the paint film, as cracking, splitting. Layers in greater thicknesses than those recommended, premature application of the subsequent coat, drops in ambient temperature and increased relative air humidity during drying are factors which can cause delay in the drying and failures in the structure of the film.

For further information contact the Technical Department of WEG (tintas@weg.net).

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

- It is not recommended to apply directly finishing ALKLACK N 1259 on primers rich in zinc with a silicate ethyl base, paints with a coal tar base. When the application of the finishing on one of the aforesaid primers is necessary, we recommend applying an appropriate intermediary product.
- In situations where the nature of the primer is not known, it is advisable to test the compatibility of finishing ALKLACK N 1259 in a small area. It shall be ensured that the original material is well adhered. All the paint not adhering shall be removed. The points with corrosion or the application on old paint shall be treated as per technical guidelines.
- The primer repainting interval shall be respected for applying the finishing. If the maximum interval indicated is exceeded, it is necessary to proceed with manual / mechanical sanding using sandpaper to break the gloss. The surface of the primer shall be dry and free of contaminants.

For further information contact the Technical Department of WEG (tintas@weg.net).
SAFETY PRECAUTIONS

Before handling this product it is essential to read carefully all the information contained in the chemical product safety information sheet (MSDS), available at our site (www.weg.net).

The preparation of the surface, handling and use of paints during the painting and drying, as it concerns inflammable products, must be performed in ventilated places, far from flames, sparks or excessive heat, using appropriate personal protection equipment (PPE) for the stage to be executed.

Contact with the skin can cause irritation. If swallowed, do not induce vomiting. In the case of contact with the eyes, wash them abundantly with water. In either case, seek medical aid immediately.

Do not smoke in the work area.

Ensure that the electrical installations are perfect and do not cause sparks. Do not use diluent to clean the skin, hands and other parts of the body. To clean the hands use alcohol, and then wash with water and appropriate cleaning pastes.

If there is a fire, use CO2 or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint.

Paints and diluents must be stored in ventilated places protected from bad weather. The temperature can oscillate between 10 and 40°C.

If symptoms of intoxication by inhaling chemical vapors occur, the intoxicated person must be removed immediately from the work place to ventilated places. If fainting, call a doctor immediately.

Product intended for use and handling of professionals linked to the painting area.

This product shall be applied and used, in compliance with all the National Health, Safety and Environment standards and regulations.

If it is necessary to remove the paint already applied and hardened from the substratum, the operator and the people who are in the same environment shall use appropriate personal protection equipment (PPE), as indicated in the safety information sheet (MSDS).

In situations where it is necessary to execute processes of welding metallic parts painted with this product, powder and gases will be released (smoke) which will require the use of appropriate personal protection equipment (masks with activated charcoal filters and even remote air supply equipment) in accordance with each environment.

The applications in confined areas require suitable ventilation, besides specific methods and procedures. For these situations contact the safety area of your company.

For further information contact the Technical Department of WEG (tintas@weg.net).

NOTE

The information contained in this technical bulletin 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 bulletin 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 Bulletin.

The information contained in this technical bulletin 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.