

W-POXI PISO RVA

PRODUCT DESCRIPTION:	Epoxy finishing coat for metallic structures and floors. Exclusive product for commercialization via resale.
RECOMMENDED USES:	Recommended for the painting of light-traffic commercial floors and structure in general.
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
	Component A	2,88	3,6	L
	Component B	0,72	0,9	L

CHARACTERISTICS: Color:	Ral, Munsell or as per customer standard.		
Gloss:	Not applicable		
Volume solid:	51 ± 2% (ISO 3233).		
Shelf-Life:	12 months at 25°C. (77°F)		
Thickness per coat (dry):	80 µm –120 µm		
Theoretical coverage:	5 m ² /l without dilution in the thickness of 100 µm dry. Without considering loss factors in application.		
Resistance to dry heat:	Maximum temperature 100 °C . The product retains its physical and chemical properties up to the temperature of 100 °C however, variations in the coating color and gloss may occur from 60 °C (140°F).		
Drying:			
	10°C (50°F)	25°C (77°F)	35°C (95°F)
Touch:	2 hours	1 hour	30 minutes
Handling:	10 hours	4 hours	3 hours
Final:	240 hours	168 hours	120 hours
Overcoating Drying:			
	10°C (50°F)	25°C (77°F)	35°C (95°F)
Min	10 hours	4 hours	3 hours
Max	36 hours	24 hours	16 hours

SURFACE PREPARATION	<p>The performance of this product depends on the degree of surface preparation.</p> <p>The surface must be clean, dry and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.</p> <p>Depending on the type of substrate and its initial condition, perform abrasive blasting, grinding with rotary hammer polishing machines with carborundum or diamond stones, acid etching and/or milling depending on the conditions.</p> <p>This coating must be applied over the W-POXI CVS 301 sealer or another primer recommended by the technical department of WEG.</p> <p>Completely remove oils, greases and grease using a degreasing product or according to the solvent cleaning method.</p> <p>Accumulated dirt must be removed using a dry brush and soluble salts must be removed by washing with high pressure fresh water.</p> <p>Concrete Surface Treatment</p>
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Before starting the painting, all masonry or concrete must be cured (28 days for cement or concrete mortar) and dry, without cracks, cracks, alveoli and perfectly adhered to the base or other layers of mortar and coating.

They must be removed from the mold release surfaces, cement cream, grease stains, oil, grease or any other contaminations that have penetrated or been deposited on the surface to be painted in addition to any dust that has accumulated.

Very smooth and glassy surfaces are not suitable for painting and should be treated according to technical guidelines.

If it is old concrete, a technician's inspection is advisable.

For more information, consult the Concrete Surface Preparation and Application Manual.

The product must be used as instructed by our technical department, in order to obtain the best expected performance. Factors such as surface condition, roughness, degree of contaminants, and other details are of fundamental evaluation for the proper execution of the surface preparation.

The W-POXI PISO RVA must be applied over the W-POXI CVS 301 sealer in order to compose an adequate painting system. For the correct application of the sealer, consult its technical data sheet.

Respect the repainting interval of W-POXI CVS 301 sealer for the application of W-POXI PISO RVA coating. If the overcoating time is exceeded, perform sanding as described in the technical data sheet of the sealer used.

Maintenance and repair

NOTE: Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

4 A X 1 B.

Diluent

Epoxy diluent 3013

Dilution

Depending on the application method, dilute at most. 10%

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

Only add the diluent after complete mixing of components A + B.

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

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C) (77°F)

4 h

Induction time (25°C)

Not applicable

APPLICATION FORMS



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

The data below is a guide, and similar equipment may be used. Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics. Before application, check if the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

Recoat 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:	10%

Brush:

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

Roller:

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

We recommend reference 329/5 (Atlas Brushes), it has been shown to be efficient in achieving thickness per coat.

Cleaning the equipment:

Epoxy diluent 3013

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

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.

Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

NOTE:

PERFORMANCE IN THE APPLICATION

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

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

The application of the coating system may require that the coatings used in this scheme be applied in two or more coats so as to obtain a uniform layer, with a dry film thickness suitable for the appearance and expected performance.

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

Do not apply the product after the pot life has expired.

We recommend coating only if the surface temperature is at least 3 °C (37,4°F) above the dew point temperature.

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

Epoxy systems may have longer curing time when exposed to low temperatures. For temperatures below 10 °C, consult WEG Technical Department.

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

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to

sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

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

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 this 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 previous 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 behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, 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.

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