

ALKLACK N 1259

PRODUCT DESCRIPTION

Phenolic topcoat paint, two-component, with aluminum pigmentation, offering light reflectance and weather resistance.

RECOMMENDED USE

Recommended for external painting of tanks and pipelines, according to Petrobras painting system.

CERTIFICATIONS AND APPROVALS

When supplied to comply with the ROHS Directive (Restriction of Certain Hazardous Substances), this product includes the letter R in its nomenclature description.

PACKAGING

Component A	3.6L Package containing 3.14L 20L Package containing 17.45L
Component B	0.9L Package containing 0.46L 3.6L Package containing 2.55L

CHARACTERISTICS

Color	Aluminum.
Gloss	Metallic
Volume Solids	52 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	20 µm - 30 µm
Dry Heat Resistance	Maximum temperature 90 °C. The product maintains its chemical properties up to a temperature of 90 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	20,80 m ² /l without dilution at a dry film thickness of 25 µm. Loss factors during application are not considered.

DRYING

Drying	<hr/>		
	10 °C	25 °C	35 °C
Touch	3,5 hours	150 min	120 min
Pressure	18 hours	16 hours	14 hours
Final	96 hours	72 hours	60 hours
Recoat Drying	<hr/>		
	10 °C	25 °C	35 °C
Minimum	28 hours	24 hours	22 hours
Maximum	52 hours	48 hours	44 hours

SURFACE PREPARATION

Standard Surface Preparation

The performance of this product is related to the degree of surface preparation. In case of doubts, for more information, consult WEG's Technical Department.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and fats according to SSPC-SP1.

Over Primer

The product must be applied over a specific primer. The primer must be clean, dry, and free of contaminants. The topcoat must be applied within the primer recoat interval. Consult the primer technical bulletin for correct application.

Respect the product recoat interval. If exceeded, perform light manual/mechanical sanding to break gloss and clean dust/residues for better adhesion between coats.



APPLICATION PREPARATION

Mixing	Homogenize the content of component A using mechanical or pneumatic stirring. Gradually add component A to component B. Homogenize slowly using manual or pneumatic stirring until a smooth, lump-free mixture is obtained. The indicated mixing proportion for paint preparation must be respected. If necessary, filter through a 60-mesh screen.
Mixing Ratio	By volume: 6.8 A x 1 B.
Thinner	DILUENT SL 12
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	<p>Dilute according to recommendation.</p> <p>Only add the thinner after the A + B components are completely mixed.</p> <p>Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness.</p> <p>The amount of Diluent may vary depending on the type of equipment used and environmental conditions during application. Only add Diluent after complete mixing of the other components. Do not dilute with solvents not allowed by local legislation, and do not exceed the indicated dilution percentage. Excessive dilution may affect film formation, appearance, and make it difficult to achieve the specified thickness.</p>
Pot Life	Not relevant.

APPLICATION METHODS

Conventional Spray Gun	<p>Spray gun: JGA 502/3 Devilbiss or equivalent</p> <p>Fluid nozzle: FF or E</p> <p>Air cap: 704</p> <p>Atomization pressure: 60 - 65 psi</p> <p>Tank pressure: 10 - 20 psi.</p>
Airless Spray Gun	<p>Airless: Use minimum pump 60:1</p> <p>Fluid pressure: 1500 - 2500 psi</p> <p>Hose: 3/8" inner diameter</p> <p>Nozzle: 0.013" - 0.017".</p>
Roller	<p>Use a short-haired, seamless wool or synthetic roller for epoxy paints.</p> <p>For application with brush and/or roller, it may be necessary to apply two or more coats to achieve a uniform layer and the recommended film thickness.</p>
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
Cleaning of the equipments:	DILUENT SL 12
Notes	<p>The data presented serves as a guide and similar equipment may be used.</p> <p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.</p> <p>Do not allow catalyzed product to remain in contact with application equipment, as at temperatures above the indicated "pot life", the paint will show variation in flow and will harden, making cleaning difficult.</p> <p>Before application, ensure that the equipment and respective components are clean and in optimal condition.</p> <p>In spray application, overlap each gun pass by 50%, finishing with a cross pass. This technique avoids</p>



uncovered or unprotected areas and ensures proper aesthetic finish.
 Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.
 Clean all equipment immediately after use.
 It is considered good practice to periodically wash the spraying equipment during the day. The cleaning frequency depends on the amount sprayed, temperature, and elapsed time, including all delays.

APPLICATION PERFORMANCE

Application of thickness above the recommended value in a single coat, additional coats beyond those specified, premature application of subsequent coats, drop in ambient temperature, and increased relative humidity during drying are factors that can cause delayed drying and defects in the film structure such as wrinkling, cracking, and delamination.

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 3°C above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

Painting is recommended only if surface temperature is at least 3°C above the dew point.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

Paintings performed with varying application methods on the same project may result in differences in gloss and final appearance.

Small variations in color, appearance, and gloss (more noticeable in dark colors), as well as delayed curing and performance compromise, may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING

The primer repainting interval must be respected for the application of the topcoat. If the maximum interval indicated is exceeded, manual/mechanical sanding with sandpaper to remove gloss is necessary. The primer surface must be dry and free of contaminants.

In situations where the nature of the primer is unknown, it is recommended to test the product's compatibility on a small area; it must be ensured that the original material is well adhered. All non-adhered paint must be removed; areas with corrosion or applications over aged paints must be treated according to technical guidance.

Direct application of the product over zinc-rich primers based on ethyl silicate, alkyd primers, coal tar-based paints, and other single-component primers is not recommended. When topcoat application over any of the above primers is required, we recommend applying a suitable intermediate product.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals. Carefully read all information contained in the SDS of this product, available at: www.weg.net.

Store in a covered and well-ventilated place. 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. Use protective gloves/protective clothing/eye protection/face protection.

Empty containers and materials with paint residues must be disposed of according to current legislation. Take care of the environment.

NOTE

The information contained in this technical bulletin is based on the experience and knowledge acquired in the field by WEG's technical team.



In the event of using the product without prior consultation with WEG regarding its suitability for the purpose for which the customer intends to use it, the customer acknowledges that the use will be at their own exclusive responsibility, and WEG is not liable for the behavior, safety, suitability, or durability of the product.

Some information mentioned in this bulletin is only an estimate and may vary due to factors beyond the manufacturer's control. Therefore, WEG does not guarantee and assumes no responsibility for performance, efficiency, or any material or personal damages resulting from the incorrect use of the products in question or from the information contained in this Technical Bulletin.

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