



W-POLI ALM 452 PUTTY

PRODUCT DESCRIPTION: Polyaspartic resin-based putty High-solids and fast-drying product. It can be applied in a high-build single coat directly to the substrate.

RECOMMENDED USES: Recommended for wind turbine blades with airless application.

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	30 kg	20	L
	Component B	3,75 kg	5	L

CHARACTERISTICS: **Color:** Gray

Gloss:	Matte					
Volume solid:	96 ± 1% (ISO 3233).					
Shelf-Life:	24 months at 25°C.					
Thickness per coat (dry):	500 µm –3.000 µm					
Theoretical coverage:	0,63 m ² /l without dilution in the thickness of 1.525 µm dry. Without considering loss factors in application.					
Resistance to dry heat:	Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C.					
Drying:						
	15°C	25°C	35°C			
Final:	216 hours	168 hours	144 hours			
Overcoating Drying:	10°C	25°C	35°C			
	Min 70 minutes	50 minutes	40 minutes			
	Max -	-	-			

SURFACE PREPARATION The performance of this product depends on the degree of surface preparation.

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.

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.

Fiber Surface Treatment

Sanding with # 80/120 sandpaper until the gloss is removed. Clean the surface with cloths soaked in thinner, changing them frequently, to remove dust and sanding residue.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of the components with a spatula. Ensure that no pigments are settled at the bottom of the package. Add component B to component A, observing the mixing ratio. Mix thoroughly with the spatula.

If necessary, use a heater at a temperature of up to 45 ° C for component A.

Mixing ratio (Volume)

3 A X 1 B.

Mixing ratio

100gA X 25gB em Peso

Diluent

Not applicable

Dilution

No dilution required. Product ready for use.

Pot life of the mixture (25°C)

8 min

The pot life is reduced with a higher room temperature.

Induction time (25°C)

No induction time required.

Pot life of the mixture / Exothermic peak at 25°C

Time (min)	Temperatures (°C)
0 min	24 °C
2 min	36 °C
4 min	46 °C
5 min	49 °C
7 min	51 °C
8 min	52 °C

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

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

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.

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.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

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

Airless Gun:

Use Airless:

Use at least pump 100: 1

Fluid pressure:

2000 – 3000 psi

Hose:

¼" internal diameter

Nozzle:

0,031" a 0,035"

Note:

Heater: 45°C

Spatula or Trowel

Apply by spreading.

Cleaning the equipment:

Not applicable

Clean all equipment immediately after use.

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specified in the pot life and will cure faster, making the cleaning difficult.

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:

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.

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.

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.

We recommend coating only if the surface temperature is at least 3 °C above the dew point temperature.

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

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

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.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The primer overcoating interval should be respected before applying the topcoat. If the maximum recommended overcoating interval is exceeded, manual/mechanical sanding is necessary to break the gloss. The primer surface must be dry and free of any contaminants.

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.

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.

