



## W-POXI ONP 415

**PRODUCT DESCRIPTION:** Fast-drying two-component epoxy primer that allows wet over wet application. Excellent corrosion protection, flexibility and hardness. Excellent adhesion to aluminum, galvanized steel and fiberglass.

**RECOMMENDED USES:** Used as an adhesion promoter on aluminum, galvanized and fiberglass substrates.  
Recommended for painting machinery and equipment, buses, trunks, aircraft and metal structures.

**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	3,6 20	3,6 20	L
	Component B	3,6 20	3,6 20	L

**CHARACTERISTICS:**

**Color:** Yellow

**Gloss:** Ultra matte 0 – 15 UB

**Volume solid:** 25 ± 2% (ISO 3233).

**Shelf-Life:** 24 months at 25°C

**Viscosity of Application:** Ready for use.

**Thickness per coat (dry):** 25 µm – 35 µm

**Theoretical coverage:** 8,5 m<sup>2</sup>/l without dilution in the thickness of 30 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 (140°F).

Drying:	10 °C	25°C	35 °C
<b>Touch:</b>	40 minutes	5 minutes	2 minutes
<b>Handling:</b>	4 hours	20 minutes	10 minutes
<b>Final:</b>	168 hours	72 hours	72 hours

Overcoating Drying:	10 °C	25°C	35 °C
Min	Humid/Humid	Humid/Humid	Humid/Humid
Max	72 hours	72 hours	72 hours

**SURFACE PREPARATION** The performance of this product depends on 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.

For better cleaning, use 2000 Cleaning Diluent. For aluminum alloys other than ABNT 3003, 3105 and 5052, they should always be sanded.

**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)**

1 A X 1 B.

**Diluent**

Not applicable

**Pot life of the mixture (25°C)**

4 h

**Induction time (25°C)**

Wait 5 minutes before application.

In hot areas, we recommend consulting WEG Technical Department.

**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.

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.

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:	50 - 70 psi
Pressure in the tank:	5 - 15 psi
Dilution:	Ready for use

**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.

**Cleaning the equipment:**

Not applicable

**NOTE:**

For cleaning use Epoxy Diluent 3005.

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.

Clean all equipment immediately after use.

**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.

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 (50°F), consult WEG Technical Department.

For better application properties, the coating temperature should be between 21°C - 27 °C (69.8°F - 80.6 °F) 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.

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

As this product is a Primer, there may be color variation between batches of this material. 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](http://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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