*TECHNICAL DATA SHEET*

# PRIMER EPOXI MONO PRETO

**PRODUCT DESCRIPTION:** Quick drying monocomponent epoxy primer. Offers good corrosion protection, flexibility, hardness and excellent applicability by immersion process.

**RECOMMENDED USES:** Developed for the foundry segment.

**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 |
|---|---|---|---|
| Monocomponent | 3,6<br>20 | 3,6<br>20 | L |

**CHARACTERISTICS:**

**Color:** Black

**Gloss:** Matte

**Volume solid:** 46 ± 5% (ISO 3233).

**Shelf-Life:** 06 months at 25°C

**Thickness per coat (dry):** 25 µm –45 µm

**Theoretical coverage:** 13,0 m2/l without dilution in the thickness of 35 µm dry. Without considering loss factors in application.

**Resistance to dry heat:** Maximum temperature 90 °C . The product retains its physical and chemical properties up to the temperature of 90 °C however, variations in the coating color and gloss may occur from 60 ºC.

**Drying:**

| | 25ºC |
|---|---|
| **Handling:** | 3 hours |
| **Final:** | 72 hours |

**Overcoating Drying:**

| | 25ºC |
|---|---|
| Min | 10 hours |
| Max | 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.

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.

**Surface treatment through Abrasive Blasting process**

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

**For further information, consult WEG Technical Department.**

PREPARATION FOR **Mixture**

APPLICATION

Homogeneíze o conteúdo manualmente, assegurando-se que nenhum pigmento fique no fundo da embalagem.

**Diluent**
**Diluente epoxi 3007**
**Epoxy Diluent 3005**

**Dilution**
Depending on the application method, dilute at most 30%

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

**Pot life of the mixture (25°C)**
Not relevant

**APPLICATION FORMS**

**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 the equipment and its components are clean and in best condition.
Purge the compressed air line to prevent contamination of the coating.

After mixing 2-pack 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 DevilBiss or equivalent |
| Fluid nozzle: | FX |
| Air cap: | 704 |
| Dilution: | 30% |

**Immersion:**
Tanks duly prepared for coating application by immersion with continuous stirring. We recommend a tank with recirculation and cascade for homogenization and blister elimination.

**Cleaning the equipment:**
Diluente epoxi 3007

**NOTE:**
Do not leave material in the hoses, spray guns and equipment used in the spraying. Thoroughly wash all equipment used.

**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.

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 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.

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.

Polyurethane systems (component A and B) present when exposed to air relative humidity, which can cause flaws in the dry film and reduction of pot life. Therefore, we recommend that the packages of each component be properly closed after use and kept in dry places protected from bad weather.

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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