



W-POXI GEL COAT

PRODUCT DESCRIPTION: Epoxy-amine, bicomponent, used for the manual finishing/refinement of the laminated surfaces, providing excellent sanding.

INTENDED USES: This product was developed for application on wind turbine blades.

PACKAGING:

Component A	W-POXI GEL COAT – BUCKET (19,2 Kg)
Component B	W-POXI GEL COAT - (4,8Kg)

PRODUCT INFORMATION:

Color	Colorless
Gloss/ Aspect	Glossy
Volume Solids	98% (ISO 3233 – 1998)
Shelf Life	12 months at 25°C
Typical Film Thickness	200 micrometers dry
Theoretical Coverage	4.,9 m ² /kg without considering the loss factors in application.
Resistance to Dry Heat	Maximum Temperature 50°C of Mould The product maintains its physical and chemical properties up to the temperature of 120°C, but as of 60°C, variances may occur in the paint color and gloss.

Drying Information

	40°C	45°C	50°C
Final	1 hour	40min	30min



SURFACE PREPARATION

The performance of this product is associated with the degree of surface preparation where the substrate must be clean, in good condition, leveled and regular, free of oil, dust or any other type of contaminants.

Completely remove oil, grease and fat applying a degreasing product according to the cleaning method with the solvent of SSPC SP1 standard.

The accumulated dirt must be removed, using a dry brush and the soluble salts must be removed, washing with fresh water at high pressure.

For the application of the W-POXI GEL COAT it must be applied according to guidance of our technical department, in order to obtain the best performance expected. Factors like the surface state, roughness, the degree of contaminants and other details are of fundamental evaluation for the appropriate surface preparation.

For further information contact the Technical Department of WEG (tintas@weg.net).

APPLICATION

Mixture

Homogenize the content of each components by means of mechanical or pneumatic stirring. Ensure that no sediment is retained at the bottom of the packaging. If necessary use a temperature heater until 45°C for component A.

Mix Ratio

4A X 1B in volume

Thinner

No diluent required

Pot Life

40 minutes at 25°C

Induction Period (25°C)

No induction required

Note: In places of great heat, we recommend to consult the Technical Department of WEG.



APPLICATION METHODS

The data below is a guide, similar equipment being able to be used.

Changes in the pressures and sizes of the nozzles may be required to improve the spraying features.

Before application ensure that the equipment and respective components are clean and in the best condition.

Empty the compressed air line to avoid contamination.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the paint has variance in its fluidity), it can no longer be diluted again for later application.

Reinforce all the sharp edges, cracks and weld beads with the wide paintbrush, to avoid premature flaws in these areas. When applying by spraying, make an overlap of 50% of each spray gun application, to avoid having uncovered and unprotected areas, ending with a cross transfer.

Airless spray gun Graco Pro-Mix – Cat or similar:

Use Airless 100 : 1
Fluid pressure..... 1500 - 3000psi
Hose 1/4" internal diameter
Nozzle 0,017"to 0,035"
Dilution Not recommended

Conventional spray gun:

Not recommended.

Wide paintbrush:

It is only recommended for finishing touches of small areas.

Roller:

Recommended.

Spatula or Plain Trowel:

Apply by spreading.

Cleaning of Equipment: Use EP Diluent 3005.

Note: Do not let the catalyzed product remain in contact with the hoses, spray guns and equipment used in the spraying, as for temperatures above those described in the pot life table, the paint will have variance in its fluidity and will harden making cleaning difficult.

Wash all the used equipment completely.



APPLICATION PERFORMANCE

For a better performance of this product, please follow the orientations below:

In paintings executed on the seafloor, if exposed to the action of the sea, we recommend to wash with fresh water between coats eliminating the impurities.

Do not apply the product after the mixture pot life, if time is exceeded.

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

There may occur small variances of color, aspect and gloss of the parts applied in periods of high relative air humidity rainy days, in places with low temperatures or in situations in which the parts are applied and placed to dry in external environments.

The temperature of the substratum and climatic and environmental conditions may interfere in the drying time of the product.

For better application properties, the paint temperature shall be between 21-27°C, before mixing and application.

It shall not be applied in adverse conditions, such as relative air humidity (URA) above 85%, as the gloss and color may undergo small alterations. It must not be applied on condensed surfaces.

On freshly painted surfaces in direct contact with water during curing process, it may occur spotting along with changes in the color (more visible in dark colors), delayed healing and compromising the performance of the product.

For further information contact the Technical Department of WEG (tintas@weg.net).

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

The primer repainting interval must be respected for finishing application. If the indicated interval is exceeded, it is necessary to carry out manual/mechanical sanding using a sandpaper to reduce gloss. The primer surface should be dry and free of contaminants.

For further information contact the Technical Department of WEG (tintas@weg.net).



SAFETY PRECAUTIONS

Before handling this product it is essential to read carefully all the information contained in the chemical product safety information sheet (MSDS), available at our site (www.weg.net).

The preparation of the surface, handling and use of paints during the painting and drying, as it concerns inflammable products, must be performed in ventilated places, far from flames, sparks or excessive heat, using appropriate personal protection equipment (PPE) for the stage to be executed.

Contact with the skin can cause irritation.

If swallowed, do not induce vomiting. In the case of contact with the eyes, wash them abundantly with water. In either case, seek medical aid immediately.

Do not smoke in the work area.

Ensure that the electrical installations are perfect and do not cause sparks.

Do not use diluent to clean the skin, hands and other parts of the body. To clean the hands use alcohol, and then wash with water and appropriate cleaning pastes.

If there is a fire, use CO2 or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint.

Paints and diluents must be stored in ventilated places protected from bad weather. The temperature can oscillate between 10 and 40°C.

If symptoms of intoxication by inhaling chemical vapors occur, the intoxicated person must be removed immediately from the work place to ventilated places.

If fainting, call a doctor immediately.

Product intended for use and handling of professionals linked to the painting area.

This product shall be applied and used, in compliance with all the National Health, Safety and Environment standards and regulations.

If it is necessary to remove the paint already applied and hardened from the substratum, the operator and the people who are in the same environment shall use appropriate personal protection equipment (PPE), as indicated in the safety information sheet (MSDS).

In situations where it is necessary to execute processes of welding metallic parts painted with this product, powder and gases will be released (smoke) which will require the use of appropriate personal protection equipment (masks with activated charcoal filters and even remote air supply equipment) in accordance with each environment.

The applications in confined areas require suitable ventilation, besides specific methods and procedures. For these situations contact the safety area of your company.

For further information contact the Technical Department of WEG (tintas@weg.net).

NOTE

The information contained in this technical bulletin is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without prior inquiry to WEG 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 the behavior, safety, suitability or durability of the product.

Certain information contained in this bulletin is merely an estimate, 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 Bulletin.

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