

W-POXI ONP 41

PRODUCT DESCRIPTION

Two-component epoxy primer, fast-drying allowing wet-on-wet application. Excellent anticorrosive protection, flexibility, and hardness. Excellent adhesion on aluminum, galvanized steel, and fiberglass.

RECOMMENDED USE

Recommended for painting machinery and equipment, buses, vehicle bodies, and aircraft, as well as metal structures.

Used as an adhesion promoter on aluminum, galvanized, and fiberglass substrates.

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 3.6L 20L Package containing 20L
Component B	3.6L Package containing 3.6L 20L Package containing 20L

CHARACTERISTICS

Color	Yellow.
Gloss	Ultra-Matte
VOC content	485.40 g/l
Volume Solids	25 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	25 µm - 35 µm
Dry Heat Resistance	Maximum temperature 120 °C. The product maintains its chemical properties up to a temperature of 120 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	8,33 m ² /l without dilution at a dry film thickness of 30 µm. Loss factors during application are not considered.

DRYING

Drying			
	10 °C	25 °C	35 °C
Touch	40 min	5 min	2 min
Manipulation	4 hours	20 min	10 min
Final	168 hours	72 hours	72 hours
Recoat Drying			
	10 °C	25 °C	35 °C
Minimum	Wet-on-wet	Wet-on-wet	Wet-on-wet
Maximum	72 hours	72 hours	72 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.

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Remove accumulated dirt using a dry brush, clean dry cloth, compressed air blow, vacuum, or a combination of these. Remove soluble salts by washing with plenty of fresh water, preferably under low pressure (up to 5,000 psi), according to SSPC-SP12/NACE No. 5 standard.

Maintenance and Repair

NOTE: Respect the recoating interval for subsequent coat application. If exceeded, perform light manual/mechanical sanding to break the previous coat gloss, followed by dust and residue cleaning to ensure better adhesion between paint layers.

Aluminum Surfaces

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

APPLICATION PREPARATION

Mixing	Homogenize the content of each component using mechanical or pneumatic stirring (A and B). Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated mixing ratio under stirring until completely homogenized, respecting the mixing ratio.
Mixing Ratio	By volume: 1 A x 1 B.
Thinner	Not applicable.
Dilution	Ready to use.
Pot Life	4 h The shelf life of the mixture is reduced as the ambient temperature increases. The pot-life test of the mixture is carried out according to ABNT NBR 15742; however, different volumes of paint prepared at once, combined with varying ambient and paint temperatures, will affect the mixture's shelf life, potentially resulting in outcomes different from those stated in this technical bulletin.
Induction Time	Wait 5 minutes before application. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 5 - 15 psi.
Roller	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.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
Cleaning of the equipments:	Not applicable.
Notes	The data presented serves as a guide and similar equipment may be used. Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination. 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. Before application, ensure that the equipment and respective components are clean and in optimal condition. After mixing two-component products, if there are



application stops and the pot life has been exceeded (paint shows variation in flow), it can no longer be re-thinned for later application.
 Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.
 Clean all equipment immediately after use.

APPLICATION PERFORMANCE

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

Do not apply the product after the pot life has been exceeded.

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

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.

Epoxy systems may have longer curing times when exposed to low temperatures. For curing at temperatures below 10°C, consult the WEG Technical Department.

Must not be applied under adverse conditions, such as relative humidity (RH) above 85%, as color and appearance changes may occur.

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.

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.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services, providing quality solutions to meet the needs of our customers.