TECHNICAL DATA SHEET

W-LACK ERA 17 EXP

PRODUCT DESCRIPTION: Super-fast-drying alkyd and nitrocellulose resin-based coating with great adhesion.

RECOMMENDED USES: Recommended for coating machines and equipment subject to low physical and chemical aggressiveness.

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	3,6	L

CHARACTERISTICS:

Color: Ral, Munsell or as per customer standard.

Gloss:

Gloss	>80 UB	ERA 171
Semigloss	60 – 80 UB	ERA 172
Semi matte	30 – 60 UB	ERA 173

Volume solid: 35 ± 5% (ISO 3233).

Shelf-Life: 12 months at 25°C.

Thickness per coat (dry): 40 µm –50 µm

Theoretical coverage: 7,7 m2/l without dilution in the thickness of 45 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 60 °C Organic coatings can undergo alterations of color, gloss and adherence when exposed to temperatures exceeding 60 °C

Drying:

	25ºC
Touch:	15 minutes
Handling:	4 hours
Final:	72 hours

Overcoating Drying:

	25ºC
Min	4 hours
Max	24 hours

Oven	Flash off	Temperature	Minutes	**Total Drying**
	10 minutes	60 °C	20 minutes	

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.

Application over primer
The product can be directly applied to a specific primer in order to form a suitable coating system.

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.

The primer surface should be clean, dry and free of any contaminants, and the topcoat should be applied within the specific primer overcoating interval (refer to the primer data sheet).

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of the package by means of mechanical or pneumatic agitation. Ensure that no sediment is settled at the bottom of the package.

Diluent
Alkydic diluent 1027

Dilution
Depending on the application method, dilute at most 25%

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

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

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

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

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.

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

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	25%

Brush:
Not recommended.

Roller:
Not recommended.

Cleaning the equipment:
Alkydic diluent 1027

NOTE:
Clean all equipment immediately after use.

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

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.

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. Light colors may require more than one coat for an even coverage. 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. 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 a good performance of the product, we recommend following the directions below: 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.
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.