



W-POXI FURNACE VARNISH

PRODUCT DESCRIPTION

Single-component epoxy varnish, stove-dried.

RECOMMENDED USE

Indicated for painting cast parts and general steel tooling.

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

Single Component 5L Package containing 5L

CHARACTERISTICS

Color	Colorless.
Gloss	Gloss
VOC content	624.51 g/l
Volume Solids	33 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	25 µm - 30 µm
Theoretical Coverage	without dilution at a dry film thickness of 28 µm. Loss factors during application are not considered.

DRYING

Drying	150 °C
Flash off	15 min

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.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and fats according to SSPC-SP1.

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.

APPLICATION PREPARATION

Mixing	Homogenize the content of the container using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container.
Thinner	EPOXY DILUENT 3005
Dilution	Ready to use.
Notes	Dilution is recommended only under special circumstances, depending on the application method. The amount of Diluent may vary depending on the type of equipment used and environmental conditions during application. Only add Diluent after complete mixing of the other components. Do not dilute with solvents not allowed by local legislation, and do not exceed the indicated dilution percentage. Excessive dilution may affect film formation, appearance, and make it difficult to achieve the specified thickness.



Pot Life Not relevant.

APPLICATION METHODS

Conventional Spray Gun Spray gun: JGA 502/3 Devilbiss or equivalent
 Fluid nozzle: EX
 Air cap: 704
 Atomization pressure: 60 - 65 psi
 Tank pressure: 10 - 20 psi.

Brush Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
 Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch-ups.

Immersion Ready to use.

Cleaning of the equipments: EPOXY DILUENT 3005

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.
 Before application, ensure that the equipment and respective components are clean and in optimal condition.
 Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.
 Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

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.

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.

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.

On freshly painted surfaces in direct contact with water during the curing process, localized staining with color change (more visible in darker colors), curing delay, and compromised product performance may occur.

Product not recommended for internal tank painting.

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.

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