



LACKPOXI N 1195 TIPO I

PRODUCT DESCRIPTION:	Two-component, high-thickness polyamine epoxy finish paint.			
RECOMMENDED USES:	Painting of new machines and equipment or maintenance services in different industries. Product intended for indoor environments.			
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. Meets Petrobras Standard N 1195 Type I.			
PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	2,88 16	3,6 20	L
	Component B	0,72 4	0,9 4	L

CHARACTERISTICS:	Color:	Ral, Munsell or as per customer standard.			
	Gloss:	Semigloss 60 – 80 UB			
	Volume solid:	62 ± 2% (N 1358).			
	Expiry Date:	12 months at 25°C.			
	Thickness per coat (dry):	120 µm –130 µm			
	Theoretical coverage:	5 m ² /l without dilution in the thickness of 120 µm dry. Without considering the loss factors in the application.			
	Resistance to dry heat:	Maximum temperature 120 °C . The product retains its physical and chemical properties up to the temperature of 120 °C however, variations in the coating color and gloss may occur from 60 °C.			
	Drying:				
		10°C	25°C	35°C	
	Touch:	8 hours	4 hours	2 hours	
	Pressure:	24 hours	16 hours	12 hours	
	Final:	240 hours	168 hours	144 hours	
	Repainting				
	Drying:	10°C	25°C	35°C	
		Min	24 hours	16 hours	8 hours
		Max	48 hours	24 hours	16 hours

SURFACE PREPARATION The performance of this product is related to 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.

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

Observe the primer overcoating interval before applying the product. If the primer overcoating time is exceeded, sand as described in the primer data sheet. In coatings made on a primer after the overcoating interval, the adhesion values according to ASTM D 4541 may present lower values than those specified by Petrobras standard N 2913.

Maintenance and repair
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.

PREPARATION FOR APPLICATION

For further information, consult WEG Technical Department.

Mixture

Homogenize the contents of each component by means of mechanical or pneumatic stirring (A and B). Ensure that no sediment is settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

4 A X 1 B.

Diluent

Epoxy diluent 3005

Dilution

Depending on the application method, dilute at most 15%

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

Excessive dilution of the coating may affect the formation of the film and appearance and hinder the attainment of the specified thickness.

Only add the diluent after the complete mixing of components A + B.

Pot life of the mixture (25°C)

2 h

The pot life is reduced with a higher room temperature.

Induction time (25°C)

Wait 15 to 20 minutes before application.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

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

The data below is a guide, and similar equipment may be used. Changes in nozzle sizes and pressures may be necessary to improve the spraying characteristics.

Before the application, make sure the equipment and its components are clean and in the best condition.

Purge the compressed air line to prevent contamination of the coating.

After mixing the 2-pack products, if there are stops in the application, and the pot life is exceeded (the coating presents variation in its fluidity), it can no longer be diluted for further application.

Reinforce all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

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:	15%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2500 – 3500 psi
Hose:	¼" internal diameter
Nozzle:	0,019" - 0,023"
Dilution:	Max. 5%

Brush:

Only recommended for retouching small areas or stripe coat (screws, nuts, weld beads, sharp edges and retouching). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for retouching.

Roller:

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

For application with brush and/or roller, application in two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

Cleaning the equipment:

Epoxy diluent 3005

Clean all equipment immediately after use.

Do not leave the catalyzed product in contact with the equipment used in the application, because the coating will present variations in fluidity at temperatures above the specification in the pot life and will harden, making the cleaning difficult.

NOTE:**PERFORMANCE IN THE APPLICATION**

For a good performance of the product, we recommend following the directions below:

Product not recommended for painting the interior of tanks

Light colors may require more than one coat for an even coverage.

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

Do not apply the product after the pot life has expired.

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

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 applied film may interfere with the product drying time.

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

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

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

Epoxy-based products are known to have excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

In coatings with variation in the application method in the same job, the final appearance and gloss of the painted surfaces may present differences.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The direct application of the product on zinc-rich ethyl silicate-based primers, alkyd primers, coal tar-based coatings and other single-component primers is not recommended. When it is necessary to apply the topcoat over one of the primers mentioned above, we recommend the application of an appropriate intermediate coating.

In situations where the nature of the primer is unknown, it is recommended to test the compatibility of the product in a small area. Make sure the original material is well bonded. All loose coating must be removed. Points with corrosion or application over aged coatings should be treated according to technical guidance.

The primer overcoating interval should be observed 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.

In highly aggressive environments, we recommend using intermediate coatings before the specific topcoat.

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 of the 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 prior 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 the behavior, safety, suitability or durability of the product.

Certain information contained in this datasheet 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 datasheet.

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