

W-POXI CVA 31

PRODUCT DESCRIPTION: 2-pack epoxy polyamide topcoat. Fast drying, great adhesion and flexibility. Product developed to complement the corrosion protection combined with the primer.

RECOMMENDED USES: Used for painting machines and equipment, metal structures in environments of medium 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
	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:	Gloss	>80 UB	CVA 311	
	Semigloss	60 – 80 UB	CVA 312	
	Semi matte	30 – 60 UB	CVA 313	
	Matte	15 – 30 UB	CVA 314	
	Ultra matte	0 – 15 UB	CVA 315	
Volume solid:	62 ± 2% (ISO 3233).			
Expiry Date:	12 months at 25°C.			
Thickness per coat (dry):	50 µm – 100 µm			
Theoretical coverage:	8 m ² /l without dilution in the thickness of 75 µm dry. Without considering the loss factors in the application.			
Resistance to dry heat:	Maximum temperature 90 °C . The product retains its physical and chemical properties up to the temperature of 90 °C however, variations in the coating color and gloss may occur from 60 °C.			
Drying:		10°C	25°C	35°C
Touch:	8 hours	3 hours	2 hours	
Handling:	36 hours	16 hours	12 hours	
Final:	240 hours	168 hours	168 hours	
Repainting Drying:		10°C	25°C	35°C
	Min	24 hours	12 hours	8 hours
	Max	48 hours	48 hours	36 hours

SURFACE PREPARATION The performance of this product is related to the degree of surface preparation.

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.

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.

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

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 of the film and appearance and hinder the attainment of the specified thickness.

Pot life of the mixture (25°C)

4 h

The pot life is reduced with a higher room temperature.

The pot-life test is performed according to the Brazilian standard ABNT NBR 15742; however, different volumes of coating prepared at once combined with different ambient and coating temperatures will influence the pot life, and different results than those mentioned in this data sheet may be found.

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.

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.

Reinforce 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 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.

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:	50 - 70 psi
Pressure in the tank:	10 - 20 psi
Dilution:	15%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	1500 - 2500 psi
Hose:	¼" internal diameter

Nozzle: 0,015" - 0,021"
 Dilution: Max. 10%

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.

Cleaning the equipment:

Epoxy diluent 3005
 Clean all equipment immediately after use.

NOTE:

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.

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:

Minor variations in color, appearance and gloss (more noticeable in dark colors) may occur, as well as delay in curing and impairment of surface performance, when applied during periods of high air relative humidity, rainy days, low temperatures or in case the coated parts are put to dry outdoors.

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.

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.

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.

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

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

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

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

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

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.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

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 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 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.

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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