



# LACKPOXI N 1585 SHOP PRIMER

<b>PRODUCT DESCRIPTION:</b>	Shop bicomponent polyamide epoxy primer, low thickness, with iron oxide pigmentation. Low cost primer and quick drying.
<b>RECOMMENDED USES:</b>	As an initial protection primer (holding primer) for equipment, sheets and structures in blasted carbon steel. Universal primer, being able to receive a diversified line of painting systems.
<b>CERTIFICATIONS AND APPROVAL:</b>	Meets Petrobras Standard N 1585. 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	20 3,6	20 3,6	L
	Component B	20 3,6	20 3,6	L

<b>CHARACTERISTICS:</b>	<b>Color:</b>	Red oxide
	<b>Gloss:</b>	Matte 15 – 30 UB
	<b>Volume solid:</b>	25 ± 1% (ISO 3233).
	<b>Expiry Date:</b>	12 months at 25°C.
	<b>Thickness per coat (dry):</b>	20 µm –25 µm
	<b>Theoretical coverage:</b>	10 m2/l without dilution in the thickness of 25 µm dry. Without considering the loss factors in the application.
	<b>Resistance to dry heat:</b>	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.
	<b>Drying:</b>	
		<b>10°C      25°C      35°C</b>
	<b>Tackiness:</b>	20 minutes    5 minutes    -
	<b>Pressure:</b>	30 minutes    10 minutes    5 minutes
	<b>Final:</b>	240 hours    168 hours    120 hours
	<b>Repainting Drying:</b>	<b>10°C      25°C      35°C</b>
		Min 12 hours    10 hours    8 hours
		Max 6 months    6 months    6 months

**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.

**Surface treatment through Abrasive Blasting process**  
Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or epoxy putty.

It is recommended a roughness profile between 40 and 85 µm.

### Surface treatment through the manual mechanical cleaning process

Treat the surface mechanically until obtaining at least grade St 3 of the ISO 8501-1 visual standard or according to SSPC-SP 11; the SSPC-VIS 3 visual standard can be used as an aid.

It can be used for situations of parts that have the degrees of oxidation C or D, according to the visual standards ISO 8501-1.

### 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.

**For further information, consult WEG Technical Department.**

### PREPARATION FOR APPLICATION

#### 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)

1 A X 1 B.

#### Diluent

Not applicable

#### Dilution

No dilution required. Product ready for use.

#### Pot life of the mixture (25°C)

8 h

#### 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.**

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

#### Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2000 - 2500 psi
Hose:	¼" internal diameter
Nozzle:	0,015" - 0,021"
Filter:	Mesh 60

#### Cleaning the equipment:

# TECHNICAL DATA SHEET



## NOTE:

Not applicable

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.

Clean all equipment immediately after use.

## 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

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.

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.

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.

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.

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-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.

## 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](http://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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