



W-POXI 711 NOBAC

PRODUCT DESCRIPTION: High-solids 2-pack polyamide epoxy direct to metal. It has low content of volatile organic compounds (Low VOC) and antimicrobial with anti-corrosion pigments. Studies have shown that some microorganisms are resistant to cleaning processes and disinfection agents. Staphylococcus aureus has been shown to survive for more than three years, and the bacterium Listeria monocytogenes can survive for more than 10 months. Therefore, WEG created an alternative to protect the surfaces that are in contact with harmful microorganisms, which eliminates them in up to 18 hours. W-POXI NOBAC was formulated so that its antimicrobial system is polymerically interconnected inside the coating, and thus it will never be removed by bleach. W-POXI NOBAC is permanently active throughout the coating life. Its application produces a continuous, hygienic and easy-to-clean film. Approved in IPT in accordance with technical report n. 83 133-205 sample LMI 162/05 B.

RECOMMENDED USES: Medical and dental equipment, food processing equipment, air conditioning units, steel furniture and kitchens, household appliances and household utensils, veterinary equipment, bathroom fittings, door locks, stair handrails and others.

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	3,6 20	3,6 20	L
	Component B	3,6 20	3,6 20	L

CHARACTERISTICS:

Color: Ral, Munsell or as per customer standard.

Gloss: Semigloss

VOC content: 170 g/l

Volume solid: 83 ± 2% (ISO 3233).

Expiry Date: 12 months at 25°C.

Thickness per coat (dry): 120 µm –200 µm

Theoretical coverage: 6,9 m²/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	6 hours	5 hours
Handling:	15 hours	12 hours	10 hours
Final:	216 hours	168 hours	144 hours

Repainting Drying:

	10°C	25°C	35°C
Min	28 hours	24 hours	20 hours
Max	52 hours	48 hours	40 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.

Surface treatment through Abrasive Blasting process

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

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.

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

Epoxy diluent 3005

Dilution

Depending on the application method, dilute at most 10%

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.

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

Induction time (25°C)

Wait 15 to 20 minutes before application.

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:	10%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2500 – 3500 psi
Hose:	¼" internal diameter

Filter: Mesh 60

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:

The use of a velvety sheepskin roller bonded to the tube by a hot-melt process without glues, reference 329/5 or sheepskin roller (5 mm high nap) or made of polyamide fibers bonded to the tube by the process of thermal fusion without glues, reference 321/10 (10 mm high nap). Reference information (consult WEG Technical Department for further information)

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

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.

PERFORMANCE IN THE APPLICATION

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

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

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.

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.

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

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

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

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.

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.

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.

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.

