

LACKPOXI N 2678

PRODUCT DESCRIPTION

High-build, two-component aluminum-pigmented polyamide epoxy primer. Tolerant to surfaces prepared by manual or mechanical cleaning. Anticorrosive coating with high adhesion on properly treated carbon steel or aged but adherent coatings.

RECOMMENDED USE

Recommended for initial protection of carbon steel without mill scale and when corrosion makes abrasive blasting impractical.

CERTIFICATIONS AND APPROVALS

Complies with Petrobras Standard N 2678.

PACKAGING

Component A	0.95 US gal Package containing 0.76 US gal
Component B	0.24 US gal Package containing 0.19 US gal

CHARACTERISTICS

Color	Aluminum.
Gloss	Semi-Matte
VOC content	2.39 lb/gal
Volume Solids	76 ± 1% (N 1358)
Shelf Life	24 months
Dry Film Thickness	4.7 mils - 5.1 mils
Dry Heat Resistance	Maximum temperature 248 °F. The product maintains its chemical properties up to a temperature of 248 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	1 without dilution at a dry film thickness of 4.9 mils. Loss factors during application are not considered.
Specific Gravity	Min: 1.5 Max: 1.6 g/cm³

DRYING

Drying

	50 °F	77 °F	95 °F
Pressure	24 hours	16 hours	12 hours
Final	288 hours	240 hours	168 hours

Recoat Drying

	50 °F	77 °F	95 °F
Minimum	24 hours	16 hours	12 hours
Maximum	72 hours	48 hours	36 hours

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.

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.

Recommended Surface Profile

It is recommended a roughness profile between 1.57 and 3.35 mils.

Abrasive Blasting



Perform abrasive blasting to near-white metal, Sa 2½ grade, according to ISO 8501-1 visual standard (A Sa 2½, B Sa 2½, C Sa 2½, D Sa 2½), or according to SSPC-SP10/NACE No. 2, visual standard SSPC-VIS 1 (A SP10, B SP10, C SP10, D SP10, G1 SP10, G2 SP10, G3 SP10).

Inspect the freshly blasted surface, observing defects that may appear after treatment. Correct them by grinding, filling with welds and/or epoxy putty.

Hand and Power Tool Cleaning

Mechanically treat the surface until achieving at least St 3 grade according to ISO 8501-1 visual standard or SSPC-SP 11, using SSPC-VIS 3 visual standard as guidance.

Maintenance and Repair

NOTE: Respect the recoating interval for subsequent coat application. If exceeded, perform light manual/mechanical sanding to break the previous coat gloss, followed by dust and residue cleaning to ensure better adhesion between paint layers.

Over Aged Coating

Remove all contaminants from the existing paint. Areas where the film is not adhered must be removed with light blasting grade Sa 1 (brush off) or according to SSPC-SP7, ISO 8501-1 visual standard. Corrosion points, worn, or damaged areas must be prepared by commercial abrasive blasting grade Sa 2, ISO 8501-1 standard or SSPC-SP6/NACE No.3, SSPC-VIS 1 standard. If not possible, use rotary-mechanical tools according to SSPC-SP 11.

APPLICATION PREPARATION

Mixing	Homogenize the content of each component using mechanical or pneumatic stirring (A and B). Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated mixing ratio under stirring until completely homogenized, respecting the mixing ratio.
Mixing Ratio	By volume: 4 A x 1 B.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 15%.
Notes	Dilute according to recommendation. Only add the thinner after the A + B components are completely mixed. Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness. 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	2 h The shelf life of the mixture is reduced as the ambient temperature increases. The pot-life test of the mixture is carried out according to ABNT NBR 15742; however, different volumes of paint prepared at once, combined with varying ambient and paint temperatures, will affect the mixture's shelf life, potentially resulting in outcomes different from those stated in this technical bulletin.
Induction Time	Wait 15 to 20 minutes before application. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX
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	Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 2700 - 3000 psi Hose: 1/4" inner diameter Nozzle: 0.019" - 0.023".
Roller	For better product performance, we recommend application with Super Flock roller or similar. For application with brush and/or roller, it may be necessary to apply two or more coats to achieve a uniform layer and the recommended film thickness.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups). For application with brush and/or roller, it may be necessary to apply two or more coats to achieve a uniform layer and the recommended film thickness.
Cleaning of the equipments:	EPOXY DILUENT 3005
Notes	Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination. Do not allow catalyzed product to remain in contact with application equipment, as at temperatures above the indicated "pot life", the paint will show variation in flow and will harden, making cleaning difficult. Before application, ensure that the equipment and respective components are clean and in optimal condition. After mixing two-component products, if there are application stops and the pot life has been exceeded (paint shows variation in flow), it can no longer be re-thinned for later application. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use.

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.

Do not apply the product after the pot life has been exceeded.

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

For optimal application properties, the paint temperature must be between 69.8°F - 80.6°F before mixing and application.

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

Epoxy systems may have longer curing times when exposed to low temperatures.
For curing below 50°F, consult WEG Technical Department.

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.

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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