TECHNICAL DATA SHEET

GALWEG 717

PRODUCT DESCRIPTION

Low-build, two-component aliphatic isocyanate epoxy primer. Adhesion promoter for non-metallic substrates. Free of lead and chromate compounds.

RECOMMENDED USE

Originally indicated as an adhesion primer for non-ferrous metals, such as aluminum, galvanized steel, lead, copper, brass, and also non-metallic substrates like fiberglass, used in yacht manufacturing.

CERTIFICATIONS AND APPROVALS

When supplied to comply with the ROHS Directive (Restriction of Certain Hazardous Substances), this product includes the letter R in its nomenclature description.

PACKAGING

Component A	0.24 US gal Package containing 0.19 US gal 0.95 US gal Package containing 0.76 US gal
Component B	0.07 US gal Package containing 0.05 US gal. 0.24 US gal Package containing 0.19 US gal

CHARACTERISTICS

Color	White.
Gloss	Matte
Volume Solids	19 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	0.4 mils - 0.8 mils
Dry Heat Resistance	Maximum temperature 212 °F. The product maintains its chemical properties up to a temperature of 212 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	516.3 ft²/gal without dilution at a dry film thickness of 0.6 mils. Loss factors during application are not considered.

DRYING

Drying

	50 °F	77 °F	95 °F
Touch	20 min	8 min	4 min
Manipulation	35 min	20 min	10 min
Final	240 hours	168 hours	168 hours

Recoat Drying

	50 °F	77 °F	95 °F
Minimum	8 hours	6 hours	4 hours
Maximum	Extended	Extended	Extended

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.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and fats according to SSPC-SP1.

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.

Hot-Dip Galvanized Surfaces

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Wash the substrate with running water to remove soluble salts resulting from the galvanizing process prior to abrasive blasting. Use a non-woven abrasive pad made of synthetic fibers bonded with resin impregnated with abrasive mineral.

It is recommended to apply the coating over surfaces blasted to Sa 1 (brush-off) according to ISO 8501-1 or SSPC-SP7 standards, using 20-40 mesh steel grit, ensuring the operation only produces a surface roughness between 0.4 and 1.0 mils and a uniform matte appearance (visual standard ISO 8501-1).

For light abrasive blasting (brush-off), hot-dip galvanized carbon steel plates should have a minimum thickness of 1/8 inch and a zinc coating of at least 2.4 mils.

For small areas, it is acceptable to first remove surface oil and grease with clean cloths soaked in Cleaning Thinner in accordance with SSPC-SP1.

Perform a "light sanding" using 100-grit sandpaper, preferably creating cross-hatch (horizontal and vertical) scratches. Clean the surface again with thinner-soaked cloths, changing them frequently. When cleaning with cloths, avoid using rags or colored fabrics.

Note: Hot-dip galvanized carbon steel intended for painting should not undergo passivation to avoid coating defects or failures.

Fiber Surfaces

Remove all dirt and grease from the surface using clean cloths soaked in Cleaning Solvent according to SSPC SP1. Avoid using rags or colored cloths. Proceed with a "light sanding" using 180-grit sandpaper to promote roughness. Whenever possible, make cross-hatch scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent, changing them frequently.

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 5%.
Pot Life	8 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 Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 1500 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.015" - 0.021".
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. 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).
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. 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. In spray application, overlap each gun pass by 50%, finishing with a cross pass. This technique avoids uncovered or unprotected areas and ensures proper aesthetic finish. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use. Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment. It is considered good practice to periodically wash the spraying equipment during the day. The cleaning frequency depends on the amount sprayed, temperature, and elapsed time, including all delays.

APPLICATION PERFORMANCE

Component B must be protected from ambient moisture. Once opened, it is recommended to use it in its entirety or as quickly as possible.

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.

Surface preparation must follow the guidance in the "Surface Preparation" field and according to the type of substrate.

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

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 37,4°F above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

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.

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.

Epoxy-based products are known for their excellent anticorrosive properties and low resistance to sun exposure. When the applied film is exposed to weathering, over time it will lose gloss, a phenomenon known as chalking, which consequently alters its color. It is important to note that, despite this chalking, the film's anticorrosive protection is not compromised.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG#s Technical

Department for more information.

COMPATIBILITY

The primer repainting interval must be respected for the application of the topcoat. If the maximum interval indicated is exceeded, manual/mechanical sanding with sandpaper to remove gloss is necessary. The primer surface must be dry and free of contaminants.

The product accepts a wide range of topcoats, mainly epoxies and polyurethanes; in highly aggressive environments, we recommend using intermediate coatings before the specific topcoat.

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.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services, providing quality solutions to meet the needs of our customers.

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