



Over Primer

The product must be applied over a specific primer. The primer must be clean, dry, and free of contaminants. The topcoat must be applied within the primer recoat interval. Consult the primer technical bulletin for correct application.

Respect the primer recoat interval before applying the product. If exceeded, perform sanding according to the technical bulletin. Painting over primer with exceeded interval may have adhesion lower than specified by Petrobras N2913 and ASTM D4541.

Respect the product recoat interval. If exceeded, perform light manual/mechanical sanding to break gloss and clean dust/residues for better adhesion between coats.

APPLICATION PREPARATION

Mixing	Homogenize the content of the container using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container.
Thinner	DILUENT 1001
Dilution	Depending on the application method, dilute to a maximum of 15%.
Notes	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	Not relevant.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 2500 psi Hose: 3/8" inner diameter Nozzle: 0.013" - 0.017".
Cleaning of the equipments:	DILUENT 1001
Notes	The data presented serves as a guide and similar equipment may be used. 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. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

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.

Light colors may require more than one coat to achieve uniform coverage.

It is recommended to paint only if the measured surface temperature is at least 3°C above the dew point temperature. Do not apply at steel temperatures below 10°C.

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Substrate temperature, climatic and environmental conditions during application and curing, as well



as applied film thickness, may affect drying time.

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

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.

SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING

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.

In situations where the nature of the primer is unknown, it is recommended to test the product's compatibility on a small area; it must be ensured that the original material is well adhered. All non-adhered paint must be removed; areas with corrosion or applications over aged paints must be treated according to technical guidance.

Direct application of the product over zinc-rich primers based on ethyl silicate, alkyd primers, coal tar-based paints, and other single-component primers is not recommended. When topcoat application over any of the above primers is required, we recommend applying a suitable intermediate product.

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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