TECHNICAL DATA SHEET

LACKPOXI N 2628

PRODUCT DESCRIPTION

Two-component, high-build, high-solids polyamide epoxy topcoat. Finish for anticorrosive protection in aggressive environments with high humidity and salt spray exposure.

RECOMMENDED USE

Recommended for painting equipment, machinery, structures, and installations exposed to medium to high aggressiveness atmospheres, including maritime environments such as oil exploration and production platforms. Product intended for covered environments.

CERTIFICATIONS AND APPROVALS

Complies with Petrobras Standard N 2628.

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	0.95 US gal Package containing 0.62 US gal 5.28 US gal Package containing 3.44 US gal
Component B	0.24 US gal Package containing 0.19 US gal 1.06 US gal Package containing 1.06 US gal
Component B II	0.24 US gal Package containing 0.19 US gal 1.06#US gal containercontaining 1.06#US gal.
Component C	0.24 US gal Package containing 1.76 lbm 0.95 US gal Package containing 9.59 lbm

CHARACTERISTICS

Color	Aluminum.
Gloss	Metallic
VOC content	2.07 lb/gal lb/gal
Volume Solids	82 ± 2% (ISO 3233)
Shelf Life	24 months
Dry Film Thickness	7.9 mils - 9.4 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	152.0 ft²/gal without dilution at a dry film thickness of 8.7 mils. Loss factors during application are not considered.

DRYING

Drying

	50 °F	77 °F	95 °F
Touch	8 hours	4 hours	2 hours
Pressure	24 hours	16 hours	12 hours
Final	300 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

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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.

Over Primer
The product can be applied over a specific primer in order to form an appropriate coating system.

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 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: 3.3 A x 1 B x 0.7 C.
Thinner	EPOXY DILUENT 3005
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	Do not dilute with solvents that are not allowed by local regulations, and do not exceed the indicated dilution percentage. Only add the thinner after the complete mixing of components A + B + C. The amount of thinner may vary depending on the type of equipment used and the environmental conditions during application. Excessive dilution of the paint 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.

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: 2500 - 3500 psi Hose: 1/4" inner diameter Nozzle: 0.019" - 0.023".
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	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. 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. 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. 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

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.

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.

For the formulation of aluminum-colored paints according to Petrobras color standard 0170, leafing aluminum pigments are used. These pigments migrate to the surface, providing the final color of the product and a metallic finish. This can be observed by the removal of the pigment from the paint film when rubbed, which is a natural characteristic of the pigment and does not affect the final performance of the product. Additionally, these pigments react with moisture, which is a natural property of this type of pigment. When the film is not yet cured, aluminum will absorb moisture by osmosis, which may reach the substrate and cause blistering. This phenomenon does not occur in the cured film, as the barrier (resin + catalyst) prevents moisture penetration.

Based on the above, this paint should not be applied on rainy, foggy, or misty days, or when relative humidity exceeds 85%, nor when such conditions are expected. It should also not be applied to metal surfaces whose temperature is lower than the dew point + 5.4#°F, accordingto items 4.9.7.3 and 4.9.7.2 of Petrobras Standard N-13. These conditions must be respected until the product reaches touch-dry time. To minimize this effect, it is recommended to apply this product in two coats of 4#mils dry film thickness.

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

Polyurethane systems (components A, B, and C) are sensitive to ambient relative humidity, which may cause defects in the dry film and reduce pot-life. After use, keep containers closed and protected.

Paintings performed with varying application methods on the same project may result in differences in gloss and final appearance.

Product not recommended for internal tank painting.

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.

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.

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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