TECHNICAL DATA SHEET

W-ESTER HIDRO HPP 71

PRODUCT DESCRIPTION

High-performance waterborne primer based on epoxy ester resins. Excellent mechanical and anticorrosive performance.

RECOMMENDED USE

Excellent product for painting machinery, parts, and industrial equipment.

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

Single Component

3.6L Package containing 3.6L
20L Package containing 20L
200L Package containing 200L

CHARACTERISTICS

Color

According to customer standard.
RAL and Munsell chart.

Gloss

Matte

Volume Solids

38 ± 2% (ISO 3233)

Shelf Life

6 months

Dry Film Thickness

40 µm - 60 µm

Dry Heat Resistance

Maximum temperature 120 °C.
The product maintains its chemical properties up to a temperature of 120 °C, but from 60°C, color and gloss variations in the paint may occur.

Theoretical Coverage

without dilution at a dry film thickness of 50 µm. Loss factors during application are not considered.

DRYING

Drying

	10 °C	25 °C	35 °C
Touch	3 hours	2 hours	1 hour
Manipulation	4 hours	3 hours	2 hours
Final	168 hours	168 hours	168 hours

Recoat Drying

	10 °C	25 °C	35 °C
Minimum	10 hours	6 hours	4 hours
Maximum	36 hours	24 hours	16 hours

Oven Drying

60 °C

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.

Degreasing

Completely remove oils and greases by applying a degreasing product or according to the solvent cleaning method. Whenever cleaning surfaces with cloths, replace them to avoid saturation. Do not

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use cotton waste or colored cloths.

Recommended Surface Profile
It is recommended a roughness profile between 40 and 60 micrometers.

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.

If oxidation occurs between the end of abrasive blasting and coating application, the surface must be blasted again until the specified visual standard is achieved.

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.

APPLICATION PREPARATION

Mixing	Homogenize the content of the container using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container.
Mixing Ratio	By volume: - A x - B.
Thinner	WATER
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	Water-based paints are naturally thixotropic, requiring caution during the dilution process.
Pot Life	Not relevant.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502 Devilbiss or equivalent Fluid nozzle: FX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 40:1 Fluid pressure: 1200 - 2200 psi Hose: 1/4" inner diameter Nozzle: 0.013" - 0.017".
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
Immersion	Tanks properly prepared for paint application by immersion with continuous agitation. We recommend a tank with recirculation and cascade for homogenization and bubble removal. The product must be maintained at a pH of 8.5 - 9.5. If variations occur, correct the product pH using WEG pH adjustment solution. We recommend internal tank cleaning every 3 months.
Cleaning of the equipments:	WATER
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.

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.

APPLICATION PERFORMANCE

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

Painting is recommended only if surface temperature is at least 3°C above the dew point.

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.

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.

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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