



W-LACK ACA 111

PRODUCT DESCRIPTION: Modified alkyd resin based finishing paint, high performance, good coverage, color retention in external environments. Items which comply with Directive Rohs have R in the product name.

INTENDED USES: Indicated for the painting of metallic structures, agricultural and road implements.

PRODUCT INFORMATION:	Colors	Ral, Munsell or as per customer standard.	
	Gloss/ Aspect	ACA 111 – Gloss	> 80 UB
		ACA 113 – Semi Gloss	30 – 60 UB
	Volume Solids	40 ± 5% (Depending on the color)	
	Shelf Life	12 months	
	Application Method	Conventional spray gun, Airless spray gun, Wide paintbrush and roller.	
	Dry Film Thickness	30 – 40 micrometers dry	
	Theoretical Coverage	11,40m ² / liters in thickness of 35 micrometers dry. Without considering the loss factors in application.	
	Resistance to Dry Heat	Maximum Temperature 60°C. Organic coatings can undergo alternations of color, gloss and adherence when exposed to temperatures higher than 60°C.	
	Drying Information		
		25°C	
Toque		3 hours	
Handle		24 hours	
Final		72 hours	
Overcoating Data			
		25°C	
	Min.	5 hours	
	Max.	24 hours	

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SURFACE PREPARATION

W-LACK ACA 111 must be applied on specific primer in order to compose an appropriate painting system.

The surface of the primer shall be clean, dry and free of oil, grease and dust. The finish shall be applied within the specific primer interval (consult its technical data sheet).

Note: If the maximum interval indicated for the application of the subsequent coat is exceeded, it is necessary to proceed with superficial sanding. This procedure is necessary to obtain adherence between coats.

For further information contact the Technical Department of WEG (tintas@weg.net).

APPLICATION

Mixture

Homogenize the content of the package, ensure that no sediment is retained at the bottom of the package.

Thinner

Recommended – Alkyd Diluent 1024

Thinning

Depending on the application method, dilute at maximum 25% in volume.

Note: The amount of diluent may vary depending on the type of equipment used and the ambient conditions during application.

APPLICATION METHODS

The data below is a guide, similar equipment being able to be used.

Changes in the pressures and sizes of the nozzles may be required to improve the spraying features.

Before application, ensure that the equipment and respective components are clean and in the best condition.

Empty the compressed air line to avoid contamination of the coating.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the coating has variance in its fluidity), it can no longer be diluted again for later application.

Reinforce all the sharp edges, cracks and weld beads with the wide paintbrush, to avoid premature flaws in these areas. When applying by spraying, make an overlap of 50% of each spray gun application, to avoid having uncovered and unprotected areas, ending with a cross transfer.

Airless Spray Gun:

Nozzle.....0,013” – 0,015”
 Fluid Pressure.....1800 – 2200 psi
 Hose.....1/4” internal diameter

Conventional Spray Gun:

Spray Gun.....JGA 502
 Air Cover.....704
 Fluid Nozzle.....FX

Wide Paintbrush:

It is only recommended for finishing touches of small areas or “strip coat” (bolts, nuts, weld bead, sharp edges and finishing touches). Use a 75 a 100 mm wide paintbrush for wider surfaces.

Roller:

Recommended only for finishing touches. Use sheep wool or synthetic wool rollers that are resistant to solvent.

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Equipment Cleaning: Use Alkyd Diluent 1024.

Do not let the catalyzed product remain in contact with the hoses, spray guns and equipment used in the spraying.

Wash all the equipment used completely.

Note: The theoretical coverage is calculated on the basis of volume solids without dilution, and does not include losses due to surface roughness, type of geometry of parts, application methods used, application conditions, inadequate thickness or application techniques.

APPLICATION PERFORMANCE

For a good product performance, we recommend following the guidelines below:

For application by wide paintbrush or roller, it may be necessary to apply in two or more coats to obtain a uniform layer in accordance with the thickness of the film recommended per coat.

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

In painting executed on the coast, if exposed to the action of salty air, we recommend washing with fresh water between coats eliminating the impurities deposited.

We only recommend painting if the temperature measured at the surface is at least 3°C above the dew-point temperature.

There may occur small variances of color, aspect and gloss of the parts applied in periods of high relative air humidity, rainy days, in places with low temperatures or in situations in which the parts are applied and placed to dry in external environments.

The temperature of the substratum and climatic and environmental conditions may interfere in the drying time of the product.

For better application properties, the paint temperature shall be between 21-27°C, before mixing and application.

It shall not be applied in adverse conditions, as relative air humidity (RH) above 85% or condensed surfaces, as the gloss and color may undergo small alterations. They must not be applied on condensed surfaces.

In recently coated surfaces in direct contact with water, during the cure process localized staining may occur with alteration in color (most visible in dark colors), delay in the cure and impairment in product performance.

In painting executed varying the method of applying paints in the same work, it may generate differences of gloss and final aspect of the parts painted.

For further information contact the Technical Department of WEG (tintas@weg.net).

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

For further information contact the Technical Department of WEG (tintas@weg.net).



SAFETY PRECAUTIONS

Before handling this product it is essential to read carefully all the information contained in the chemical product safety information sheet (MSDS), available at our site (www.weg.net).

The preparation of the surface, handling and use of paints during the painting and drying, as it concerns inflammable products, must be performed in ventilated places, far from flames, sparks or excessive heat, using appropriate personal protection equipment (PPE) for the stage to be executed.

Contact with the skin can cause irritation.

If swallowed, do not induce vomiting. In the case of contact with the eyes, wash them abundantly with water. In either case, seek medical aid immediately.

Do not smoke in the work area.

Ensure that the electrical installations are perfect and do not cause sparks.

Do not use diluent to clean the skin, hands and other parts of the body. To clean the hands use alcohol, and then wash with water and appropriate cleaning pastes.

If there is a fire, use CO2 or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint.

Paints and diluents must be stored in ventilated places protected from bad weather. The temperature can oscillate between 10 and 40°C.

If symptoms of intoxication by inhaling chemical vapors occur, the intoxicated person must be removed immediately from the work place to ventilated places.

If fainting, call a doctor immediately.

Product intended for use and handling of professionals linked to the painting area.

This product shall be applied and used, in compliance with all the National Health, Safety and Environment standards and regulations.

If it is necessary to remove the paint already applied and hardened from the substratum, the operator and the people who are in the same environment shall use appropriate personal protection equipment (PPE), as indicated in the safety information sheet (MSDS).

In situations where it is necessary to execute processes of welding metallic parts painted with this product, powder and gases will be released (smoke) which will require the use of appropriate personal protection equipment (masks with activated charcoal filters and even remote air supply equipment) in accordance with each environment.

The applications in confined areas require suitable ventilation, besides specific methods and procedures. For these situations contact the safety area of your company.

For further information contact the Technical Department of WEG (tintas@weg.net).

NOTE

The information contained in this technical bulletin is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without prior inquiry to WEG concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for the behavior, safety, suitability or durability of the product.

Certain information contained in this bulletin is merely an estimate, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting from the incorrect use of the products concerned or the information contained in this Technical Bulletin.

The information contained in this technical bulletin is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.

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