# TECHNICAL DATA SHEET

# W-POXI RRP 32

## PRODUCT DESCRIPTION

Fast-drying two-component cycloaliphatic amine epoxy primer. W-POXI RRP provides quick repainting and excellent finish with optimal wetting and leveling.

## RECOMMENDED USE

Used as a primer and finish with excellent adhesion and anticorrosive protection on phosphated or degreased carbon steel surfaces. Recommended for painting machinery, equipment, agricultural implements, and metal structures.

## 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

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| **Component A** | 0.95 US gal Package containing 0.83 US gal<br>5.28 US gal Package containing 4.61 US gal<br>52.83 US gal Package containing 50.17 US gal |
| **Component B** | 0.24 US gal Package containing 0.12 US gal<br>1.06 US gal Package containing 0.66 US gal<br>52.83 US gal Package containing 50.17 US gal |

## CHARACTERISTICS

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| **Color** | Beige.<br>White.<br>Gray. |
| **Gloss** | Ultra-Matte |
| **VOC content** | 3.2 (lb/gal).<br>Note: The average of VOC on the line can vary depending on the color. |
| **Volume Solids** | 45 ± 2% (ISO 3233) |
| **Dry Film Thickness** | 2.0 mils - 2.8 mils |
| **Dry Heat Resistance** | Maximum temperature 212 °F.<br>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** | 305.6 ft²/gal without dilution at a dry film thickness of 2.4 mils. Loss factors during application are not considered. |

## DRYING

**Drying**

| | 50 °F | 77 °F | 95 °F |
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| **Touch** | 2 hours | 90 min | 45 min |
| **Manipulation** | 6 hours | 3 hours | 2 hours |
| **Final** | 7 days | 5 days | 4 days |

**Recoat Drying**

| | 50 °F | 77 °F | 95 °F |
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| **Minimum** | 40 min | 30 min | 20 min |
| **Maximum** | 14 days | 10 days | 7 days |

## 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.



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Accumulated dirt must be removed using a dry brush, and soluble salts must be removed by washing with fresh water under high pressure.

**Recommended Surface Profile**
It is recommended a roughness profile between 1.57 and 2.36 mils.

**Abrasive Blasting**
For other applications, it is recommended to paint on surfaces blasted to Sa 2½ or Sa 3 grade, according to SSPC-SP10 or SSPC-SP5, respectively. Visual standard ISO 8501-1.

Evaluate the surface after blasting, observing revealed defects and adopt practices to minimize them, such as grinding or filling.

**Hand and Power Tool Cleaning**
If manual mechanical cleaning is not possible, alternatively perform commercial abrasive blasting, Sa 2 grade according to ISO 8501-1 visual standard (C Sa 2 and D Sa 2) or SSPC-SP 6/NACE No. 3, visual standard SSPC-VIS 1 (C SP 6, D SP 6).

Mechanically treat the surface until achieving at least St 3 grade according to ISO 8501-1 visual standard or SSPC-SP 11, using SSPC-VIS 3 visual standard as guidance.

Respect the product's 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.

**Carbon Steel Surfaces**
Completely remove oils, greases, soluble salts, and other contaminants according to SSPC SP1 solvent cleaning method. Rinse with high-pressure fresh water.

The surface must be clean, dry, and free of contaminants.

## APPLICATION PREPARATION

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| **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: 7 A x 1 B. |
| **Thinner** | EPOXY DILUENT 3005 |
| **Alternative Thinners** | PU 5007 Diluent<br>PU 5008 Diluent. |
| **Dilution** | Depending on the application method, dilute to a maximum of 10%. |
| **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.<br>Only add the diluent after completely mixing components A and B. |
| **Pot Life** | 4 h<br><br>The shelf life of the mixture is reduced as the ambient temperature increases.<br><br>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. |

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| | **Induction Time** | Wait 15 to 20 minutes before application.<br><br>In very hot locations, we recommend consulting WEG's Technical Department. |

## APPLICATION METHODS

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| **Conventional Spray Gun** | Spray gun: JGA 502/3 Devilbiss or equivalent<br>Fluid nozzle: EX<br>Air cap: 704<br>Atomization pressure: 60 - 65 psi<br>Tank pressure: 10 - 20 psi. |
| **Airless Spray Gun** | Airless: Use minimum pump 60:1<br>Fluid pressure: 2000 - 2500 psi<br>Hose: 1/4" inner diameter<br>Nozzle: 0.015" - 0.021". |
| **Brush** | Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).<br>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. |
| **Cleaning of the equipments:** | EPOXY DILUENT 3005 |
| **Notes** | The data presented serves as a guide and similar equipment may be used.<br>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.<br>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.<br>Before application, ensure that the equipment and respective components are clean and in optimal condition.<br>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.<br>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.<br>Clean all equipment immediately after use.<br>Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment. |

## APPLICATION PERFORMANCE

For painting schemes used under immersion conditions, 2 coats of 6 mils dry thickness should be used.

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.

Surface preparation is recommended to Sa 2½ or SSPC SP10 (ISO 8501-1 visual standard). Less stringent standards are acceptable as long as there are no contaminants, supplemented with high-pressure water cleaning.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

Do not apply under adverse conditions, such as RH above 70% or on condensed surfaces. Small variations in color, appearance, and gloss may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

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

When applying by brush or roller, two or more coats may be necessary to achieve a uniform layer and recommended film thickness.

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.

**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.

**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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