



**PRIMER EPOXI W-POXI HPP 43**

<b>PRODUCT DESCRIPTION</b>	Fast-drying single-component epoxy primer with anticorrosive pigments.	
<b>RECOMMENDED USE</b>	Developed for the foundry segment.	
<b>PACKAGING</b>	<b>Component A</b>	0.95 US gal Package containing 0.95 US gal 5.28 US gal Package containing 5.28 US gal
<b>CHARACTERISTICS</b>	<b>Color</b>	Black.
	<b>Gloss</b>	Matte
	<b>VOC content</b>	4.42 lb/gal
	<b>Volume Solids</b>	44 ± 2% (ISO 3233)
	<b>Shelf Life</b>	12 months
	<b>Dry Film Thickness</b>	1.2 mils - 1.6 mils
	<b>Dry Heat Resistance</b>	Maximum temperature 194 °F. The product maintains its chemical properties up to a temperature of 194 °F, but from 140°F, color and gloss variations in the paint may occur.
	<b>Theoretical Coverage</b>	512.2 ft <sup>2</sup> /gal without dilution at a dry film thickness of 1.4 mils. Loss factors during application are not considered.

<b>DRYING</b>	<b>Drying</b>	<b>77 °F</b>
	<b>Manipulation</b>	3 hours
	<b>Final</b>	72 hours
	<b>Recoat Drying</b>	<b>77 °F</b>
	<b>Minimum</b>	10 hours
	<b>Maximum</b>	72 hours

<b>SURFACE PREPARATION</b>	<b>Standard Surface Preparation</b> 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.
	<b>Abrasive Blasting</b> Sa 2½ blasting recommended for cast iron.

<b>APPLICATION PREPARATION</b>	<b>Mixing</b>	Homogenize the content manually, ensuring no pigment remains at the bottom of the container.
	<b>Thinner</b>	EPOXY DILUENT 3005
	<b>Dilution</b>	Depending on the application method, dilute to a maximum of 30%.
	<b>Notes</b>	Dilute according to recommendation.  Only add the thinner after the A + B components are completely mixed.



Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness.

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 Devilbiss or equivalent  
 Fluid nozzle: FX  
 Air cap: 704.

**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.

**Cleaning of the equipments:** EPOXY DILUENT 3005

**Notes** 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. Clean all equipment immediately after use. 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.

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.

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](http://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.

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**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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