TECHNICAL DATA SHEET

W-POXI SP 301

PRODUCT DESCRIPTION

Low-build, two-component aliphatic isocyanate epoxy shop primer. Adhesion primer for non-ferrous substrates.

RECOMMENDED USE

Indicated as an adhesion primer for ferrous and non-ferrous metals, such as aluminum, galvanized steel, brass, stainless steel, and also non-metallic substrates like fiberglass. Widely used on transmission towers, roofs, pipelines, and galvanized steel 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

Component A	3.6L Package containing 3.4L
Component B	0.25L Package containing 0.2L.

CHARACTERISTICS

Color	Red Oxide.
Gloss	Matte
VOC content	890.18 g/l
Volume Solids	19 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	15 µm - 20 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	9,50 m2/l without dilution at a dry film thickness of 20 µm. Loss factors during application are not considered.

DRYING

Drying

	16 °C	25 °C	35 °C
Touch	6 hours	4 hours	2 hours
Manipulation	16 hours	12 hours	8 hours
Final	240 hours	168 hours	120 hours

Recoat Drying

	10 °C	25 °C	35 °C
Minimum	8 hours	6 hours	4 hours
Maximum	240 hours	168 hours	144 hours

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.

Hot-Dip Galvanized Surfaces

It is recommended to carry out the coating application on surfaces blast-cleaned to grade Sa 1 (brush off) or according to SSPC-SP7, using 20 to 40 mesh abrasive grit, limiting the operation only to produce a surface profile between 10 to 25 micrometers and dulling of the surface (ISO 8501-1 visual standard).

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Non-Ferrous and Electro-Galvanized Surfaces
Remove all dirt and grease from the surface using clean cloths soaked in Cleaning Solvent according to SSPC SP1. Avoid using rags or colored cloths during cleaning.

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: 3.5 A x 0.3 B.
Thinner	DILUENT SL 30
Dilution	Depending on the application method, dilute to a maximum of 10%.
Notes	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	5 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.
Induction Time	Wait 15 to 20 minutes before application. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Conventional Spray Gun	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.
Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 2000 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.013" - 0.017". Filter: mesh 60.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).
Cleaning of the equipments:	DILUENT SL 30

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. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use.

APPLICATION PERFORMANCE

Component B must be protected from ambient moisture. Once opened, it is recommended to use it in its entirety or as quickly as possible.

Do not apply the product after the pot life has been exceeded.

Surface preparation must follow the guidance in the "Surface Preparation" field and according to the type of substrate.

As this is a primer, color variation between batches of this material may occur.

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.

Epoxy systems may have longer curing times when exposed to low temperatures. For curing at temperatures below 10°C, consult the WEG Technical Department.

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.

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providing quality solutions to meet the needs of our customers.