TECHNICAL DATA SHEET

W-POXI RRP 325

PRODUCT DESCRIPTION: Two-component, cycloaliphatic amine epoxy primer with fast drying and excellent anticorrosive protection. W-POXI RRP provides quick repainting and excellent finishing with great wetting and leveling.

RECOMMENDED USES: Used as primer and finishing with excellent adhesion and anti-corrosion protection on phosphatized or degreased carbon steel surfaces. Recommended for painting machinery, equipment, agricultural implements and metallic structures.

CERTIFICATIONS AND APPROVAL: This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:

Component	Content	Package	Unit of measurement
Component A	3,15	3,6	
	17,5	20	L
	190	200	
Component B	0,45	0,9	
	2,5	4	L
	190	200	

CHARACTERISTICS:

Color: Gray, White, Beige

Gloss: Matte

Volume solid: 45 ± 3% (ISO 3233).

Shelf-Life: 12 months at 25°C.

Thickness per coat (dry): 50 µm –70 µm

Theoretical coverage: 7,5 m2/l without dilution in the thickness of 60 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 100 °C . The product retains its physical and chemical properties up to the temperature of 100 °C however, variations in the coating color and gloss may occur from 60 ºC.

Drying:

	10ºC	25ºC	35ºC
Touch:	2 hours	90 minutes	45 minutes
Handling:	6 hours	3 hours	2 horas
Final:	7 days	5 days	4 days

Overcoating Drying:

	10ºC	25ºC	35ºC
Min	40 minutes	30 minutes	20 minutes
Max	14 days	10 days	7 days

Obs The wet/wet repainting of various finishes (upon request), over the W-POXI RRP 325 primer, can be done with minimum intervals of 5 minutes at 25°C. For further information, please contact the WEG Technical Department.

SURFACE PREPARATION The performance of this product depends on the degree of surface preparation.

The surface must be clean, dry and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

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

Surface treatment through Abrasive Blasting process

We recommend painting on surfaces blasted to Sa 2½ or according to SSPC SP10. ISO 8501-1 visual standard.

Evaluate the surface after blasting, observing the presence of surface defects revealed after treatment, adopting appropriate practices to minimize defects through grinding or filling.

It is recommended a roughness profile between 40 and 60 µm.

Surface treatment through the manual mechanical cleaning process

Treat the surface mechanically until obtaining at least grade St 3 of the ISO 8501-1 visual standard or according to SSPC-SP 11; the SSPC-VIS 3 visual standard can be used as an aid.

Areas that cannot be prepared by this method should be subjected to localized abrasive blasting to Sa 2 grade or SSPC-SP6. Visual standard ISO 8501-1.

NOTE: Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

Treatment of Steel Carbon Surfaces

The surface must be clean, dry and free from contaminants.
Completely remove oils, greases and grease using a degreasing product or according to the solvent cleaning method SSPC SP1. Wash with fresh water at high pressure.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component by means of mechanical or pneumatic stirring (A and B). Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

7 A **X** 1 B.

Diluent
Pu diluent 5007

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C)
4 h

Induction time (25°C)
Wait 15 to 20 minutes before application.

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.
Before application, check if the equipment and its components are clean and in best condition.
Purge the compressed air line to prevent contamination of the coating.

After mixing two-component products, if there are stops in the application, and pot life is exceeded (the coating shows variation in fluidity) it can no longer be diluted for further application.

Recoat all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	20%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	2000 - 2500 psi
Hose:	¼" internal diameter
Nozzle:	0,015“ - 0,021“
Filter:	Mesh 60

Brush:
Only recommended for touch up small areas or stripe coat (screws, nuts, weld and sharp edges). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for touch up.

Cleaning the equipment:
Pu diluent 5007

NOTE:
For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.
Do not leave material in the hoses, spray guns and equipment used in the spraying. Thoroughly wash all equipment used.

Clean all equipment immediately after use.

PERFORMANCE IN THE APPLICATION

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

For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.
For paint schemes used in immersion condition, 2 coats of 150 µm dry thickness should be used.

Product not recommended for painting the interior of tanks

In paintings carried out in front of the sea, if exposed to sea air, we recommend to wash with fresh water between coats eliminating settled impurities.

We recommend surface preparation to Sa 2½ or SSPC SP10. ISO 8501-1 visual standard. It is acceptable to use less demanding surface preparation standards, as long as the absence of contaminants is guaranteed, and the blasting is complemented with high pressure water cleaning (the surface preparation alternatives suitable for each case must be evaluated).

Do not apply the product after the pot life has expired.

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the coat may interfere in the product drying time.

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

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

Epoxy-based products are known by having excellent anti-corrosion properties and low resistance to sunlight exposure. In situations of exposure of the film to the weather, over time it will present a loss of gloss known as chalking and its shade will change as a consequence. Remember that even undergoing such chalking, the film anti-corrosion protection is not impaired.

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

To apply topcoat over the product, the overcoating interval should be observed. The surface must be dry and free of any contaminants.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release this product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

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

If using the product without previous inquiry to WEG Coating 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 behavior, safety, suitability or durability of the product.

Some information contained in this datasheet are estimated, 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 datasheet.

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