

W-LACK IMD 12

PRODUCT DESCRIPTION: Fast-drying, alkyd resin-based direct to metal for the immersion segment.

RECOMMENDED USES: Used for painting steel doors and windows, wheelbarrows, grain storage silos, equipment and metal structures subject to low aggressiveness.

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
	Monocomponent	3,6 20 200	3,6 20 200	L

CHARACTERISTICS: Color: Ral, Munsell or as per customer standard.

Gloss:	Gloss	>80 UB	IMD 121
	Semigloss	60 – 80 UB	IMD 122
	Semi matte	30 – 60 UB	IMD 123
	Matte	15 – 30 UB	IMD 124
	Ultra matte	0 – 15 UB	IMD 126

Volume solid: 40 ± 5% (ISO 3233).

Expiry Date: 12 months at 25°C.

Thickness per coat (dry): 20 µm – 30 µm
Theoretical coverage: 16 m²/l without dilution in the thickness of 25 µm dry. Without considering the loss factors in the application.

Resistance to dry heat: Maximum temperature 60 °C Organic coatings can undergo alterations of color, gloss and adherence when exposed to temperatures exceeding 60 °C

Drying:

25°C

Touch: 30 minutes
Handling: 24 hours
Final: 72 hours

**Repainting
Drying:**

25°C

Min 5 hours
 Max 24 hours

SURFACE PREPARATION The performance of this product is related to 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.

The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.

Surface treatment by the layer conversion process (phosphating)

Execute the layer conversion process, phosphatization using zinc phosphate or tricationic, with mass between 2.0 g/m² and 4.0 g/m². Following the sequential steps: degrease, wash, pickling, wash, refining, phosphate conversion, wash, passivation, wash with deionized water and drying.

NOTE: The surface preparation must be executed according to all the sequential steps relevant to a phosphate conversion process, observing the recommendations of the pre-treatment manufacturer.

Surface treatment by Degreasing with solvents

Completely remove oil from the surface with clean cloths soaked in cleaning solvent according to SSPC SP1. Whenever cleaning a surface with cloths, replace them to avoid saturation. Do not use cotton waste or colored cloths.

Treatment of Steel Carbon Surfaces

Hard superficial layers (for example, layers resulting from flame cut) must be removed by grinding it before beginning the abrasive blasting.

All the welds must be inspected e, if necessary, be repaired before the ending of the abrasive blasting. Porosity, cavities, weld splashes, etc. must be repaired by means of proper mechanical treatment or weld repair; in the other areas, round the sharp edges ($r \geq 2 \text{ mm}$, ISO 8501-3).

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of the package by means of mechanical or pneumatic stirring. Ensure that no sediment is settled at the bottom of the package.

Diluent

Alkydic diluent 1024

Dilution

Depending on the application method, dilute at most 15%

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

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

Excessive dilution of the coating may affect the formation of the film and appearance and hinder the attainment of the specified thickness.

APPLICATION FORMS

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

In the spray application, make a 50% overlap in each gun pass, concluding with a cross pass. This technique is used to avoid uncovered and unprotected areas and to obtain a suitable aesthetic finish.

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

Changes in nozzle sizes and pressures may be necessary to improve the spraying characteristics.

Before the application, make sure the equipment and its components are clean and in the best condition.

Purge the compressed air line to prevent contamination of the coating.

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

Conventional gun:

Gun:	JGA 502 DevilBiss or equivalent
Fluid nozzle:	FX
Air cap:	704
Atomization pressure:	50 - 70 psi
Pressure in the tank:	10 - 20 psi
Dilution:	15%

Immersion:

Tanks duly prepared for coating application by immersion with continuous stirring. We recommend a tank with recirculation and cascade for homogenization and blister elimination.

Brush:

Not recommended.

Roller:

Only recommended for small areas or retouching. Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

NOTE:

For application with brush and/or roller, application in two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

Cleaning the equipment:

Alkydic diluent 1024

Clean all equipment immediately after use.

Do not leave material in the hoses, spray guns and equipment used in the spraying. Thoroughly wash all equipment used.

Furthermore, it is a good working practice to periodically wash the spray equipment along the day. The cleaning frequency will depend on the amount sprayed, temperature and elapsed time, including all delays.

PERFORMANCE IN THE APPLICATION

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

Minor variations in color, appearance and gloss (more noticeable in dark colors) may occur, as well as delay in curing and impairment of surface performance, when applied during periods of high air relative humidity, rainy days, low temperatures or in case the coated parts are put to dry outdoors.

In paintings executed on the seafront, if exposed to the action of sea air, we recommend to wash with fresh water between coats eliminating the settled impurities.

Light colors may require more than one coat for an even coverage.

It should not be applied in adverse conditions, such as air relative humidity above 85% or on condensed surfaces. Small variations in color, appearance and gloss of the coated parts may occur in periods of high air relative humidity, rainy days, at low temperatures or in situations where the coated parts are placed to dry outdoors.

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

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

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

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 applied film may interfere with the product drying time.

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

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 of the 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 prior 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 the behavior, safety, suitability or durability of the product.

Certain information contained in this datasheet 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 datasheet.

The information contained in this technical datasheet 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.

