

**W-POXI TBA 30**

**PRODUCT DESCRIPTION**

Two-component polyamine epoxy finish. Used in tumbling (concrete mixer) process. Excellent adhesion and flexibility.

**RECOMMENDED USE**

Used on small metal surfaces, such as screws, zippers, eyelets, rivets, etc.

**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**

<b>Component A</b>	3.6L Package containing 3.6L
<b>Component B</b>	1.5L Package containing 1L

**CHARACTERISTICS**

<b>Color</b>	According to customer standard. RAL and Munsell chart.
<b>Gloss</b>	Gloss
<b>VOC content</b>	541.30 g/l
<b>Volume Solids</b>	53 ± 5% (ISO 3233)
<b>Shelf Life</b>	12 months
<b>Dry Film Thickness</b>	20 µm - 30 µm
<b>Dry Heat Resistance</b>	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.
<b>Theoretical Coverage</b>	21,20 m <sup>2</sup> /l without dilution at a dry film thickness of 25 µm. Loss factors during application are not considered.

**DRYING**

**25 °C**

<b>Touch Dry:</b>	1 h
<b>Handle Dry:</b>	5 h
<b>Full Cure:</b>	3 days
<b>Minimum recoat drying time:</b>	5 h
<b>Maximum recoat drying time:</b>	INDEFINIDO

**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.

Completely remove oils and greases by applying a degreasing product or according to the solvent cleaning method. Whenever cleaning surfaces with cloths, replace them to avoid saturation. Do not use cotton waste or colored cloths.

**APPLICATION PREPARATION**

**Mixing**

Homogenize the content of each component using manual or mechanical stirring (A and B). Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated (volume) proportion under stirring until completely homogenized.



Add Diluent 3026 and mix well. Add slip solution and mix thoroughly.

**Mixing Ratio** By volume: 10 A x 1 B.

**Thinner** DILUENT EPOXI 3026

**Dilution** Depending on the application method, dilute to a maximum of 50%.

**Pot Life** 3 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 minutes before application.

In very hot locations, we recommend consulting WEG's Technical Department.

**APPLICATION METHODS**

**Cleaning of the equipments:** DILUENT EPOXI 3026

**Notes** 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. Preheat the parts for approximately 4 minutes. Application time may vary depending on the spray gun fan opening and desired dry film thickness. Clean all equipment immediately after use.

**APPLICATION PERFORMANCE**

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

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.

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

On freshly painted surfaces in direct contact with water during the curing process, localized staining with color change (more visible in darker colors), curing delay, and compromised product performance may occur.

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.

**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.  
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