TECHNICAL DATA SHEET

W-POXI BLOCK HPP 402 RL ALUMÍNIO

PRODUCT DESCRIPTION:

Novolac bicomponent epoxy primer of high thickness, high solids and pigmented with aluminum. Tolerant to surfaces treated with manual or mechanical cleaning. Anticorrosive coating with high adhesion on carbon steel properly treated or well adhered aged paint
Excellent chemical resistance, very low solvent content (LOW VOC), and good resistance to abrasion and impact. W-POXI BLOCK HPP 402 RL, provides not only unmatched anti-corrosion protection, but also excellent surface hardness and impermeability.

RECOMMENDED USES:

For initial protection of carbon steel without rolling scales and when corrosion is present and abrasive blasting is not possible. It is especially recommended for environments where the chemical and corrosion resistance is essential.

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	3,05	3,6	L
Component B	0,55	0,9	L

CHARACTERISTICS:

Color: Aluminum

Gloss: Semigloss
VOC content: 120 g/l
Volume solid: 85 ± 3% (ISO 3233).

Flash Point: > 55 °C
Shelf-Life: 12 months at 25°C. (77°F)
Thickness per coat (dry): 120 µm –130 µm
Theoretical coverage: 6,8 m2/l without dilution in the thickness of 125 µm dry. Without considering loss factors in application.

Resistance to dry heat: Maximum temperature 220 °C . The product retains its physical and chemical properties up to the temperature of 220 °C however, variations in the coating color and gloss may occur from 60 ºC (140°F).

Drying:

	10ºC (50°F)	25ºC (77°F)	35ºC (95°F)
Touch:	10 hours	4 hours	2 hours
Handling:	24 hours	10 hours	6 hours
Final:	240 hours	166 hours	168 hours
Pot Life	120 minutes	90 minutes	60 minutes

Overcoating Drying:

	10ºC (50°F)	25ºC (77°F)	35ºC (95°F)
Min	10 hours	4 hours	2 hours
Max	30 hours	24 hours	20 hours

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 the hydroblasting process

We recommend to paint on surfaces hydroblasted to the degree CWJ-2 according to standard SSPC-VIS 4. Allowed application on degree of "moderate flash rust" according to CWJ-2M.

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 85 µm.

Surface treatment through the manual mechanical cleaning process

We recommend coating over surfaces treated by manual cleaning to St 2 or SSPC-SP2 grade or mechanical cleaning to St 3 or SSPC-SP3 grade. Visual Standard ISO 8501-1.
The surface must be clean, dry, and free of contaminants.

New buildings
For new buildings, it is necessary to treat welding spatters and weld seams, damaged areas, edges and sharp corners by abrasive blasting Sa 2 ½ degree or SSPC-SP10, visual standard ISO 8501-1.

Refinishing of surfaces with aged coating in good conservation conditions

In cases where the aged coating has good adhesion to the substrate, we recommend superficial sanding to break the gloss, followed by the cleaning of the dust and residues of the sanding in order to provide better adhesion between the coats.

We recommend the user of this coating to seek ways to make sure the original aged painting is still well bond to the substrate before executing this refinish. Loose aged coatings or not well bonded must be completely removed. We emphasize that the refinishing must only be made on surfaces in good conservation conditions.

It is acceptable to use less demanding surface preparation standards, provided that the absence of contaminants is guaranteed by cleaning with fresh water at high pressure (between 5,000 psi and 10,000 psi) according to SSPC-SP 12/NACE In. 5. If any further explanation is necessary, contact our technical area to determine alternatives for the proper surface preparation on a case by case basis.

Remove all the existing contaminants on the coating. In case the film has spots not well bonded, remove it with brush off grade 1 or according to SSPC-SP7 standard. ISO 8501-1 visual standard.

Corrosion spots, worn or damaged areas and the like shall be prepared by commercial abrasive blasting to Sa 2 of ISO 8501-1 visual standard or according to SSPC-SP 6 / NACE No. 3, SSPC-VIS 1 visual standard. If it is not possible to execute the abrasive blasting, as an alternative the surface can be prepared with rotary power tools according to SSPC-SP 11.

Maintenance and repair

In cases where the aged coating has good adhesion to the substrate, we recommend superficial sanding to break the gloss, followed by the cleaning of the dust and residues of the sanding in order to provide better adhesion between the coats.

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). Ensure that no sediment is settled at the bottom of the package. Add component B to component A, at the recommended mixture proportion, under stirring, until complete homogenization, observing the mixing ratio. Avoid mixing for extended periods, since the heat of the friction will significantly reduce the product pot life.

Mixing ratio (Volume)
5.5 A X 1 B.

Diluent
Epoxy diluent 3005

Dilution
Depending on the application method, dilute at most. 10%

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) (77°F)
1 h 30 min
The pot-life test is conducted in accordance with the ABN NBR 15742 standard where the volume of the mixture is standardized. Higher volumes of catalyzed coating added to different environmental temperatures will influence the pot-life of the mixture, and different times from those mentioned in this technical data sheet may be obtained.
Induction time (25°C)
No induction time required.

APPLICATION FORMS

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

Before application, check if the equipment and its components are clean and in best condition.
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.

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.

Roller:
The appearance of the finish should be controlled in the application.

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.

Cleaning the equipment:
Epoxy diluent 3005
Clean all equipment immediately after use.

NOTE:

Do not leave catalyzed product in contact with the equipment used in the application, because the coating will vary in fluidity at temperatures above specificated in the pot life and will cure faster, making the cleaning difficult.

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:

We recommend surface preparation to grade Sa 2½ or SSPC SP10. We also recommend painting over surfaces treated by manual/mechanical cleaning to grade St 2 or to SSPC-SP2, or, manual/mechanical cleaning to grade St 3 or SSPC-SP3. Visual Standard ISO 8501-1.

The W-POXI BLOCK HPP 402 RL product allows the painting of recently hydroblasted surfaces that show small traces of relatively advanced light corrosion (Flash rust or rust blossom grade) (equivalent to the "moderate" grade described in SSPC VIS4(I) / NACE No. 7 standard) on the surface.

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.

It is not recommended to apply this product over a surface covered with a water film or exposed to rain, neither to expose the freshly painted surface to direct contact with water during the curing process or places with low temperatures or to put the parts to dry outdoors, as staining with changes in color (more noticeable in dark colors), delay in curing and impairment of the product performance may occur.

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.

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

We recommend coating only if the surface temperature is at least 3 °C (37,4°F) above the dew point temperature.

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

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

The product should be stored at 20 - 30 °C(68°F - 86°F) to achieve viscosity for proper application.

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.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.
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.

Do not use excessive air pressure. Adjust the fluid pressure and nozzle properly for a better atomization.

For further information, consult WEG Technical Department.

COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The correct washing and degreasing of the surface for the application of the finishing paint is not dispensed with.
For the application of finishes over the W-POXI BLOCK HPP 402 RL product, the repainting interval must be respected.

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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