



W-POXI HBA 30

PRODUCT DESCRIPTION

Solvent-free (Low VOC) self-leveling epoxy paint cured with polyamine, suitable for indoor environments. High-gloss, high-build single-coat application, part of flooring systems with excellent abrasion, mechanical, and chemical resistance.

RECOMMENDED USE

The product was developed for protection of floors in food industries, hospitals, laboratories, pulp and paper plants, chemical and petrochemical industries, sugar mills, distilleries, and other industrial floors. This paint should be applied over the W-POXI CVS 301 sealer, W-POXI HSS 301, and W-POXI PRP 301 primer or another primer recommended by WEG's technical department.

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	0.95 US gal Package containing 0.76 US gal 5.28 US gal Package containing 4.23 US gal
Component B	0.24 US gal Package containing 0.19 US gal 1.06 US gal Package containing 1.06 US gal
Note	It is possible to add Mix 30 aggregate to the mixture, ranging from 2.2 to 26.5 lb per gallon. Consult the technical department for more details. Consult the technical department for more details.

CHARACTERISTICS

Color	According to customer standard. RAL and Munsell chart.
Gloss	Gloss
VOC content	1.2 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
Volume Solids	98 ± 2% (ISO 3233)
Flash Point	31 °C
Shelf Life	24 months
Dry Film Thickness	11.8 mils - 39.4 mils
Dry Heat Resistance	Maximum temperature 248 °F. The product maintains its chemical properties up to a temperature of 248 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	61.5 ft ² /gal without dilution at a dry film thickness of 25.6 mils. Loss factors during application are not considered.

DRYING

Drying			
	50 °F	77 °F	95 °F
Touch	8 hours	5 hours	3 hours
Manipulation	18 hours	12 hours	8 hours
Final	240 hours	168 hours	144 hours
Light traffic		3 days	
Heavy traffic		7 days	
Recoat Drying			
	50 °F	77 °F	95 °F
Minimum	24 hours	12 hours	6 hours
Maximum	48 hours	24 hours	12 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.

Concrete Surfaces

No coating or paint should be applied until the concrete (or cement-sand screed) is fully dry and cured for at least 28 days under normal climatic conditions.

No coating or paint should be applied on concrete or cement-sand screed with curing accelerator unless representative tests indicate satisfactory adhesion of the paint system.

For more information, consult the Concrete Surface Preparation and Application Manual.

This product must be applied over a recommended sealer or primer for concrete surfaces to compose an appropriate painting system. For correct application of the sealer/primer, consult its technical bulletin.

Coatings should not be applied over floors contaminated with oils or aggressive products. The floor must be effectively cleaned. Applying over residues of these contaminants may cause coating detachment and other failures.

Respect the recoat interval between sealer or primer coats for applying the product. If the recoat time is exceeded, sand as described in the sealer or primer technical bulletin.

Coating on old concrete only upon recommendation from WEG Technical Department.

Product application must follow guidance from our technical department to achieve the expected performance. Factors such as surface condition, roughness, contaminant level, and other specifics are essential for proper surface preparation.

The performance of this product is associated with surface preparation. The surface must be clean, solid, free of any contaminants, fully dry, and have sufficient roughness to allow adhesion of the applied protection system.

Over Primer

NOTE: Respect the product's recoat interval for the application of the subsequent coat. If the maximum indicated recoat interval is exceeded, it is necessary to perform a light manual or mechanical sanding to break the gloss of the previous coat, followed by cleaning off dust and sanding residues to ensure better adhesion between paint coats.

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.

Homogenize for 1 minute the content of each component by mechanical or pneumatic stirring (A and B). Ensure that no sediment remains at the bottom of the container. Add component B to component A, in the indicated mixing ratio, under agitation, until complete homogenization is achieved, respecting the specified mixing ratio. Consult the technical department for more details.

Mixing Ratio

By weight: 100 A x 15 B.

Thinner

Not applicable.

Dilution

Ready to use.

Pot Life

30 min

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

No induction time required.

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

APPLICATION METHODS

Conventional Spray Gun

Spray gun: Not recommended.

Airless Spray Gun

Airless: not recommended.

Roller

Not recommended.

Brush

Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).

Use a brush 3.0 to 3.94 inches wide for larger surfaces and 0.98 to 1.5 inches for touch-ups.

Squeegee, Spatula and Trowel

Pour the paint onto the floor and spread the material using steel trowels or notched squeegees, followed by the use of a spiked roller, making passes and re-passes over the still-wet film and within the pot-life of the mixture, removing air incorporated during mixing and application of the paint.

The use of a spiked roller is essential for any coat applied of this product.

Cleaning of the equipments:

Not applicable.

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

The recommended layer thickness between 20 to 80 mils depends on the amount of Mix 80 to be used.

The higher the layer, the greater the need for Mix 80.

Without this additive, exceeding 40 mils is not recommended, as film formation defects may occur.

For skirting application, add 5% by weight of Anti-Sag Additive, item 16017086.

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

Light colors may require more than one coat to achieve uniform coverage.

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

During the initial curing (first 24 hours), humidity must not exceed 85%, otherwise the visual appearance may be compromised.



For optimal application properties, the paint temperature must be between 69.8°F - 80.6°F before mixing and application.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 37.4°F above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

We recommend painting only if the measured surface temperature is at least 5.4°F 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 below 50°F, consult WEG Technical Department.

Application of the coating system may require the paints involved to be applied in two or more coats to achieve a uniform layer with dry film thickness suitable for the expected appearance and performance.

Product yield depends on the condition of the surface to be repaired. The theoretical calculation of paint quantity should consider surface condition. To achieve expected yield, control the amount of paint applied per area. Refer to the Application Manual for more information.

Traffic release depends on environmental curing conditions. For floor painting scheduling, consider a 7-day final curing period. Practical tests may allow 3 days for light traffic (people) and a minimum of 7 days for heavy traffic (forklifts, trucks).

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 resin-based self-leveling products for concrete have excellent mechanical properties, but low resistance to exposure to sunlight. When the applied film is exposed to weathering, it will gradually show a loss of gloss, known as chalking, and as a consequence, a change in its color. It should be noted that even with this chalking, the film's anticorrosive protection is not compromised.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

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.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services, providing quality solutions to meet the needs of our customers.