

W-POXI ENG 082

PRODUCT DESCRIPTION: Two-component modified epoxy primer. It provides excellent corrosion protection and adhesion to hot-dipped and electrolyte galvanized steel, aluminum, carbon steel and blasted cast iron.

RECOMMENDED USES: Recommended as primer for bus body supporting structure with excellent adhesion. This product has good adhesion and bonding compatibility with Sikaflex glue and 3M double sided adhesive tape, between the frame and the aluminum sheet.

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	12 2,4	20 3,6	L
	Component B	6 1,2	6 1,6	L

CHARACTERISTICS:	Color:	Black		
	Gloss:	Ultra matte		
	Volume solid:	21 ± 3% (ISO 3233).		
	Shelf-Life:	12 months at 25 °C - Component A 06 months at 25 °C - Component B		
	Thickness per coat (dry):	30 µm –40 µm		
	Theoretical coverage:	6 m ² /l without dilution in the thickness of 35 µm dry. Without considering loss factors in application.		
	Resistance to dry heat:	Maximum temperature 90 °C . The product retains its physical and chemical properties up to the temperature of 90 °C however, variations in the coating color and gloss may occur from 60 °C.		
	Drying:			
		10°C	25°C	35°C
	Touch:	20 minutes	10 minutes	8 minutes
	Handling:	40 minutes	30 minutes	20 minutes
	Final:	7 days	7 days	7 days
	Overcoating			
	Drying:	10°C	25°C	35°C
	Min	6 hours	5 hours	4 hours
	Max	24 hours	24 hours	24 hours

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.

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 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 each component with mechanical or pneumatic stirring (A and B). Check there are no sediment settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

2 A X 1 B.

Diluent Epoxy diluent 3001

Dilution

Depending on the application method, dilute at most. 5%

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 and aspect of the film and not allow to reach the specified thickness.

Pot life of the mixture (25°C)

8 h

The pot life is reduced with a higher room temperature.

The pot-life test is performed according to the Brazilian standard ABNT NBR 15742; however, different volumes of coating prepared at once combined with different ambient and coating temperatures will influence the pot life, and different results than those mentioned in this data sheet may be found.

Induction time (25°C)

No induction time required.

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:	5%

Airless Gun:

TECHNICAL DATA SHEET



Use Airless:
Fluid pressure:
Hose:
Nozzle:

Use at least pump 60: 1
1200 – 2200 psi
¼" internal diameter
0,013" - 0,017"

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:

Not recommended.

NOTE: For application by cutting it may be necessary to apply two or more passes to obtain a uniform layer according to the film thickness recommended by others.

Cleaning the equipment:

Epoxy diluent 3001

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 specified in the pot life and will cure faster, making the cleaning difficult.

PERFORMANCE IN THE APPLICATION

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

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.

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 above the dew point temperature.

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.

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.

Due to technical characteristics, the product may present a slight reduction in viscosity during the validity period.

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.

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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