



W-THANE HSA 502

PRODUCT DESCRIPTION: Aliphatic acrylic polyurethane finishing paint of high thickness and high solids per volume which provides anticorrosive protection by barrier of high power of impermeabilization, chemical resistance and resistance to continuous bad weather. Items which comply with Directive Rohs have R in the product name.

INTENDED USES: It can be used in aggressive industrial environments, chemical, paper and cellulose, petrochemical industries, metallic structures and in external painting of tanks and equipment.

PACKAGING:

Component A	W-THANE HSA 502 – Gallon (2.88 L)
Component B	W-THANE 5017 – 10744551 (0.72 L)

PRODUCT INFORMATION:	Colors	Ral, Munsell or as per customer standard.			
	Gloss	Semi Gloss 60 – 80 GU			
	Volume Solids	70 ± 2% (ISO 3233 - 1998)			
	Shelf Life	12 months at 25°C – Component A 12 months at 25°C – Component B			
	Dry Film Thickness	75 - 125 micrometers dry.			
	Theoretical Coverage	6.8 m ² /liter in thickness of 100 micrometers dry. Without considering the loss factors in application.			
	Resistance to Dry Heat	Maximum Temperature 90°C. The product maintains its physical and chemical properties up to the temperature of 90°C, but, as of 60°C, variances may occur in the paint color and gloss.			
	Drying Information				
			10°C	25°C	35°C
	Touch		4 hours	6 hours	2 hours
Handle		8 hours	10 hours	5 hours	
Final		180 hours	168 hours	150 hours	
Overcoating Data					
		10°C	25°C	35°C	
	Min.	8 hours	6 hours	5 hours	
	Max.	24 hours	16 hours	12 hours	



SURFACE PREPARATION

The performance of this product is associated with the degree of surface preparation. Completely remove oil, grease and fat applying a degreasing product or as per cleaning method with solvent of standard SSPC SP1.

The accumulated dirt must be removed, using a dry brush and the soluble salts must be removed, washing with fresh water at high pressure.

W-THANE HSA 502 must be applied on specific primer in order to compose an appropriate painting system. For the correct application of the primer, see its technical bulletin.

Respect the repainting interval of the primer, before applying the finishing. If the repainting time is exceeded, execute sanding as described in the technical bulletin of the primer used.

Note: If the maximum interval indicated for applying the subsequent coat is exceeded, it is necessary to proceed with mechanical or manual sanding using sandpaper to break the gloss. This procedure is necessary to obtain adherence between the layers.

For further information contact the Technical Department of WEG (tintas@weg.net).

APPLICATION

Mixing

Homogenize the contents of each one of the components by means of mechanical or pneumatic stirring (A and B). Ensure that no sediment is retained at the bottom of the packaging. Add component B to component A, in the proportions (volume) indicated, under stirring, until complete homogenization, respecting the mixture ratio.

Mix Ratio

4A X 1B in volume.

Thinner

Recommended – **Diluent PU 5006**

Thinning

Depending upon the application method, dilute **at most 10% in volume.**

Note: the dilution can vary in accordance with the requirement of adjustment of viscosity for application.

Only add the Diluent after completing the mixing of components A + B. Do not dilute with solvents which are not allowed by the local legislation or exceed the dilution percentage indicated.

Excessive dilution of the paint can affect the forming of the film, the aspect and make it difficult to obtain the thickness specified.

Pot Life

4 hours at 25°C.

Induction Period (25°C)

Induction not required.

Note: In places of great heat, we recommend contacting the Technical Department of WEG.



APPLICATION METHODS

The data below is a guide, similar equipment being able to be used.

Changes in the pressures and sizes of the nozzles may be required to improve the spraying features.

Before application ensure that the equipment and respective components are clean and in the best condition.

Empty the compressed air line to avoid contamination of the paint.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the paint has variance in its fluidity), it can no longer be diluted again for later application.

Reinforce all the sharp edges, cracks and weld beads with the wide paintbrush, to avoid premature flaws in these areas. When applying by spraying, make an overlap of 50% of each spray gun application, to avoid having uncovered and unprotected areas, ending with a cross transfer.

Airless spray gun:

- Use Airless 60 : 1
- Fluid pressure..... 1800 - 2200 psi
- Hose 1/4" of internal diameter
- Nozzle..... 0.015" a 0.019"
- DilutionMax 5%

Conventional spray gun:

- Spray gunJGA 502/3 Devilbiss
- Fluid nozzle EX
- Air cover 704
- Atomization pressure 60 to 65 psi
- Pressure in tank 10 to 20 psi
- DilutionMax 10%

Flooding

Dilute at most 30% in volume.

Wide paintbrush:

Only recommended for finishing touches of small areas or "strip coat" (bolts, nuts, weld bead, sharp edges and finishing touches).

Roller:

Only recommended for finishing touches of small areas.

Note: For application by wide paintbrush, it may be necessary to apply in two or more strokes to obtain a uniform layer in accordance with the thickness of the film recommended per coat.

Cleaning of equipment: Use Diluent PU 5006.

Note: Do not let the catalyzed product remain in contact with the hoses, spray guns and equipment used in the spraying, as for temperatures above those described in the pot life table, the paint will have variance in its fluidity and will harden making cleaning difficult.

Wash all the equipment used completely.



APPLICATION PERFORMANCE

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

In painting executed on the coast, if exposed to the action of salty air, we recommend washing with fresh water between coats eliminating the impurities deposited.

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

Do not apply the product after the mixture pot life, if this time is exceeded.

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

There may occur small variances of color, aspect and gloss of the parts applied in periods of high relative air humidity, rainy days, in places with low temperatures or in situations in which the parts are applied and placed to dry in external environments.

The temperature of the substratum and climatic and environmental conditions may interfere in the drying time of the product.

For better application properties, the paint temperature shall be between 21-27°C, before mixing and application.

It shall not be applied in adverse conditions, as relative air humidity (RH) above 85% or condensed surfaces, as the gloss and color may undergo small alterations. It must not be applied on condensed surfaces.

Polyurethane systems (component A and B) have sensitivity when exposed to relative air humidity, able to cause defects in the dry film and reduce the pot-life. Therefore, we recommend that the packaging of each one of the components, after use, is duly closed and maintained in dry places protected from bad weather.

In recently painted surfaces in direct contact with water, during the cure process localized staining may occur with alteration in color (most visible in dark colors), delay in the cure and impairment in product performance.

In painting executed varying the method of applying paints in the same work, it may generate differences of gloss and final aspect of the parts painted.

For further information contact the Technical Department of WEG (tintas@weg.net).

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

For further information contact the Technical Department of WEG (tintas@weg.net).



SAFETY PRECAUTIONS

Before handling this product it is essential to read carefully all the information contained in the chemical product safety information sheet (MSDS), available at our site, at the electronic address indicated at the end of this technical bulletin.

The preparation of the surface, handling and use of paints during the painting and drying, as it concerns inflammable products, must be performed in ventilated places, far from flames, sparks or excessive heat, using appropriate personal protection equipment (PPE) for the stage to be executed.

Contact with the skin can cause irritation.
If swallowed, do not induce vomiting. In the case of contact with the eyes, wash them abundantly with water. In either case, seek medical aid immediately.

Do not smoke in the work area.

Ensure that the electrical installations are perfect and do not cause sparks.
Do not use diluent to clean the skin, hands and other parts of the body. To clean the hands use alcohol, and then wash with water and appropriate cleaning pastes.

If there is a fire, use CO2 or chemical powder extinguishers. It is not recommended to use water to extinguish the fire produced by burning paint.
Paints and diluents must be stored in ventilated places protected from bad weather. The temperature can oscillate between 10 and 40°C.

If symptoms of intoxication by inhaling chemical vapors occur, the intoxicated person must be removed immediately from the work place to ventilated places.
If fainting, call a doctor immediately.

Product intended for use and handling of professionals linked to the painting area.

This product shall be applied and used, in compliance with all the National Health, Safety and Environment standards and regulations.

If it is necessary to remove the paint already applied and hardened from the substratum, the operator and the people who are in the same environment shall use appropriate personal protection equipment (PPE), as indicated in the safety information sheet (MSDS).

In situations where it is necessary to execute processes of welding metallic parts painted with this product, powder and gases will be released (smoke) which will require the use of appropriate personal protection equipment (masks with activated charcoal filters and even remote air supply equipment) in accordance with each environment.

The applications in confined areas require suitable ventilation, besides specific methods and procedures. For these situations contact the safety area of your company.

For further information contact the Technical Department of WEG (tintas@weg.net).

NOTE

The information contained in this technical bulletin 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 bulletin 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 Bulletin.

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