



W-THANE HBA 851

PRODUCT DESCRIPTION: Bicomponent polyester glossy finishing paint, high solids per volume. Product developed to compose an anticorrosive protection system, high impermeabilization power, excellent chemical and natural weathering resistance. Items which comply with Directive Rohs have R in the product name.

INTENDED USES: The W-THANE HBA 851 system can be used where high resistance is required, especially weathering resistance. This product can be used in chemical, petrochemical, pulp and paper, sugar and alcohol industries, transportation industries among others.

PACKAGING:	Component A	W-THANE HBA 851 - CD 17463 (2,7 L)
	Component B	W-THANE 5057 – CD 17462 (0,9 L)
	Component A	W-THANE HBA 851 - CD 17463 (15 L)
	Component B	W-THANE 5057 – CD 17462 (5 L)

PRODUCT INFORMATION:	Colors	Ral, Munsell or as per customer standard.			
	Gloss / Aspect	Gloss > 85 UB			
	Volume Solids	75 ± 2% (N 1358)			
	Shelf Life	12 months at 25°C			
	Dry Film Thickness	80 - 100 micrometers dry.			
	Theoretical Coverage	8,3 m ² /liters in thickness of 90 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		6 hours	3 hours	2 hours
Handle		11 hours	7 hours	4 hours	
Final		300 hours	240 hours	168 hours	
Overcoating Data		10°C	25°C	35°C	
	Min.	12 hours	8 hours	5 hours	
	Max.	48 hours	48 hours	48 hours	

COPY FOR INFORMATION



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.

The W-THANE HBA 851 shall be applied on a specific primer in order to compose a suitable painting system. It is recommended to apply on LACKPOXI N 2630 and for the correct application of the primer, consult its technical data sheet. Other primers may be used according to technical guidance.

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

Note: If the maximum interval indicated for applying the subsequent coat is exceeded, it is necessary to proceed with manual / mechanical sanding using sandpaper to reduce gloss. This procedure is necessary to obtain adhesion between the coats.

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 pigment settling 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 mixing ratio.

Mix Ratio

3A X 1B in volume

Thinner

Recommended – **Diluent PU 5003 – For temperatures below 25°C**
Diluent PU 5007 – For temperatures above 35°C and drying in oven

Thinning

Depending upon the application method, dilute **at most 15% in volume**.

Only add the Diluent after completing the mixture 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

2 hours at 25°C

Induction Period (25°C)

No induction required.

N 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 coating.

After mixing the bicomponent products, if stoppages occur in application, and they exceed the useful life of the mixture (where the coating 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 - 2000 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%

Wide paintbrush:

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

Roller:

Consult the Technical Department of WEG for further information.

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

Cleaning of equipment: Use Diluent PU 5007 / PU 5003.

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.

All used equipment shall be thoroughly flushed with the proper thinner.



APPLICATION PERFORMANCE

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

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

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

Product not recommended for the painting of internal parts of tanks.

If application occurs in maritime areas, it is recommended to wash the coated surfaces with freshwater between each coating, to remove all loose powdery deposits and soluble salts.

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

Surface temperature must always be a minimum of 3°C above dew point. Do not apply if temperature is below 0°C.

The temperature of the substrate, 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. Color, aspect and gloss changes can be noticed in the film when application occurs in high relative humidity periods, rainy or low temperature days or when the film is exterior exposed before curing.

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 weathering.

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 varying the application method of coatings in the same work, it may occur differences in gloss and final aspect of the coated surfaces.

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

SYSTEM COMPATIBILITY AND MAINTENANCE RECOATING

The direct application of W-THANE HBA 851 on rich zinc silicate, alkyd primers, coal tar epoxy or other single component primers is not recommended. When the application of W-THANE HBA 851 on one of the aforesaid primers is necessary, it is recommended the application of an appropriate intermediary product.

In situations where the nature of the primer is not known, it is advisable to test the compatibility of W-THANE HBA 851 in a small area. Ensure that the original material is well adhered. All non-adhering paint must be removed. Points with corrosion or application on aged coatings shall be treated according to technical advice. Do not apply the product after the mixture pot life, if this time is exceeded.

The overcoating interval of the primer shall be respected for applying the top coat. If the maximum interval indicated is exceeded, it is necessary to proceed with manual / mechanical sanding to promote surface profile. The surface of the primer shall be dry and free of contaminants.

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 (www.weg.net).

The preparation of the surface, handling and use of coatings 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 coating.

Coatings 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 coating 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 coated 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 datasheet 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 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 datasheet 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 datasheet.

The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.