



# W-THANE ENA 601

**PRODUCT DESCRIPTION:** Acrylic aliphatic polyurethane, glossy, bicomponent, with excellent durability. Items which comply with Directive Rohs have R in the product name.

**INTENDED USES:** Used as a finishing in areas above the water line, in metallic structures, industrial equipment and machinery.

<b>PACKAGING:</b>	<b>Component A</b>	W-THANE ENA 601 – Bucket (17,15 L)
	<b>Component B</b>	W-THANE 5058 – 10004312 (2,85 L)
	<b>Component A</b>	W-THANE ENA 601 – Gallon (3,08 L)
	<b>Component B</b>	W-THANE 5058 – 10004313 (0,52 L)

<b>CARACTERISTICAS</b>				
<b>Colors</b>		Ral, Munsell or as per customer standard.		
<b>Gloss/Aspect</b>	ENA 601 – Gloss	> 80 UB		
	ENA 602 – Semi Gloss	60 – 80 UB		
	ENA 603 – Semi Matte	30 – 60 UB		
	ENA 604 – Matte	15 – 30 UB		
<b>Volume Solids</b>	53 ± 2% (ISO 3233)			
<b>Shelf Life</b>	12 months at 25°C			
<b>Dry Film Thickness</b>	50 - 60 micrometers dry.			
<b>Theoretical Coverage</b>	10,37 m <sup>2</sup> /liters in the thickness of 55 micrometers dry. Without considering the loss factors in application.			
<b>Resistance to Dry Heat</b>	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.			
<b>Drying Information</b>		10°C	25°C	35°C
<b>Touch</b>		4 hour	2 hours	1 hour
<b>Handle</b>		24 hours	6 hours	4 hours
<b>Final</b>		240 hours	168 hours	168 hours
<b>Overcoating Data</b>		10°C	25°C	35°C
	Min.	24 hours	6 hours	5 hours
	Max.	48 hours	48 hours	48 hours

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**SURFACE PREPARATION**

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

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 ENA 601 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 technical bulletin of the primer used.

**Overcoating of surfaces in good condition**

It is advisable to test the W-THANE ENA 601 on the previous paint in a small area to check compatibility. It shall be ensured that the original material is well adhered. Loose or poorly adhering coating must be removed. Points with corrosion or application on aged paints should be treated according to technical guidance.

**Note:** If the maximum interval indicated for application of the subsequent coat is exceeded, it is necessary to proceed with manual / mechanical sanding using sandpaper to reduce the gloss. This procedure is necessary to obtain adherence 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 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**

6 A X 1B in volume

**Thinner**

Recommended - **Diluent PU 5003 – For temperatures below 25°C**  
**Diluent PU 5004 – For temperatures between 25°C and 35°C**  
**Diluent PU 5007 – For temperatures above 35°C and drying in oven**

**Thinning**

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

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

The mixture pot life is reduced with the increasing ambient temperature.

**Induction Period (25°C)**

No induction required.

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

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**FORMAS DE APLI  
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 - 2000psi  
 Hose..... 1/4" internal diameter  
 Nozzle..... 0,015" to 0,019"  
 Dilution..... Max. 5%

**Conventional spray gun:**

Spray gun..... JGA 502/3 Devilbiss  
 Fluid nozzle..... EX  
 Air cover..... 704  
 Atomization pressure..... 60 a 65 psi  
 Pressure in tank.... 10 a 20 psi  
 Dilution. .... Max. 20%

**Wide paintbrush:**

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

**Roller:**

Use sheep wool or synthetic wool rollers for PU and epoxy coatings.

**Note:** For application by wide paintbrush, 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.

Wash all the equipment used completely.



**APPLICATION PERFORMANCE**

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

For application by wide paintbrush, 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.

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.

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.

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](mailto:tintas@weg.net)).**



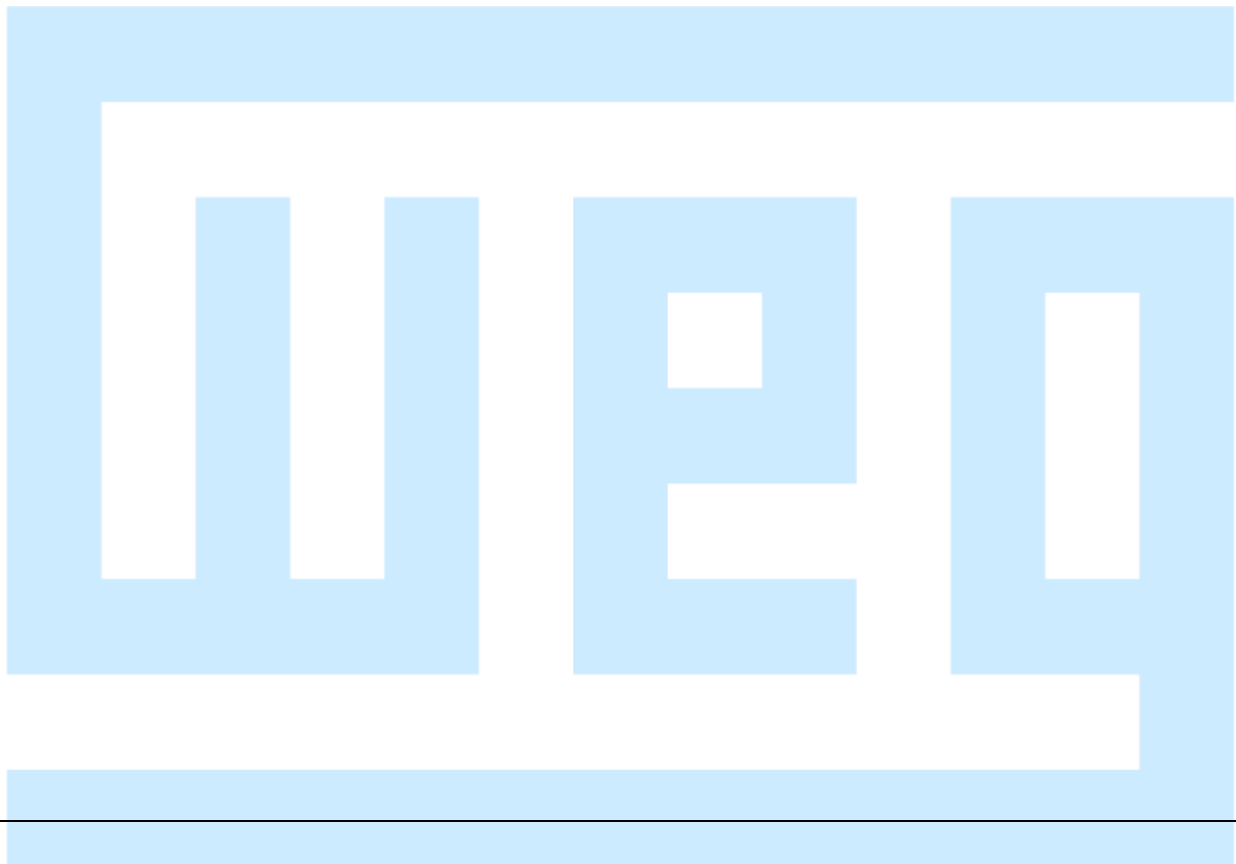
**SYSTEM  
COMPATIBILITY  
AND MAINTENANCE  
RECOATING**

The direct application of finishing W-THANE ENA 601 on primers rich in zinc with a silicate ethyl base, alkyd primers, paints with a coal tar base and other single component primers is not recommended. When the application of the finishing on one of the aforesaid primers is necessary, we recommend 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 finishing W-THANE ENA 601 Aluminum in a small area. It shall be ensured that the original material is well adhered. All the paint not adhering shall be removed. The points with corrosion or the application on old paint shall be treated as per technical guidelines. Do not apply the product after the useful life of the mixture 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.

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**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](http://www.weg.net)).**

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 CO<sub>2</sub> 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.

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**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 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.

The information contained in this technical bulletin 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.

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