

## W-THANE ENA 60

**PRODUCT DESCRIPTION:** Gloss 2-pack aliphatic acrylic polyurethane topcoat with excellent durability:

**RECOMMENDED USES:** Used as topcoat in areas above the waterline on metal structures, industrial equipment and different kinds of machinery.

**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	17,15	20	L
		3,08	3,6	
	Component B	2,85	4	L
		0,52	0,5	

**CHARACTERISTICS: Color:** Ral, Munsell or as per customer standard.

<b>Gloss:</b>	Gloss	>80 UB	ENA 601	
	Semigloss	60 – 80 UB	ENA 602	
	Semi matte	30 – 60 UB	ENA 603	
	Matte	15 – 30 UB	ENA 604	
<b>Volume solid:</b>	53 ± 2% (ISO 3233).			
<b>Shelf-Life:</b>	12 months at 25°C.			
<b>Thickness per coat (dry):</b>	50 µm –60 µm			
<b>Theoretical coverage:</b>	10,37 m2/l without dilution in the thickness of 55 µm dry. Without considering loss factors in application.			
<b>Resistance to dry heat:</b>	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.			
<b>Drying:</b>				
		<b>10°C</b>	<b>25°C</b>	<b>35°C</b>
<b>Touch:</b>	4 hours	2 hours	1 hour	
<b>Handling:</b>	24 hours	6 hours	4 hours	
<b>Final:</b>	240 hours	168 hours	168 hours	
<b>Overcoating Drying:</b>				
		<b>10°C</b>	<b>25°C</b>	<b>35°C</b>
Min	24 hours	6 hours	5 hours	
Max	48 hours	48 hours	48 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.

### Application over primer

Observe the primer overcoating interval before applying the product. If the primer overcoating time is exceeded, sand as described in the primer data sheet. In coatings made on a primer after the overcoating interval, the adhesion values according to ASTM D 4541 may present lower values than those specified

by Petrobras standard N 2913.

The product can be directly applied to a specific primer in order to form a suitable coating system.

### Refinishing of surfaces with aged coating in good conservation conditions

We recommend the user of this coating to seek ways to make sure the original aged painting is still well bond to the substrate before executing this refinish. Loose aged coatings or not well bonded must be completely removed. We emphasize that the refinishing must only be made on surfaces in good conservation conditions.

### Maintenance and repair

**NOTE:** Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

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)

6 A X 1 B.

### Diluent

**Pu diluent 5003**  
**PU Diluent 5004**

For temperatures lower than 25°C.  
For temperatures between 25°C and 35°C.

**PU Diluent 5007**

For temperatures above 35°C and oven drying.

### Dilution

Depending on the application method, dilute at most 10%

Only add the diluent after complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

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)

4 h

The pot life is reduced with a higher room temperature.

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 the equipment and its components are clean and in best condition. Purge the compressed air line to prevent contamination of the coating.

After mixing 2-pack 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

# TECHNICAL DATA SHEET



Atomization pressure: 60 - 65 psi  
Pressure in the tank: 10 - 20 psi  
Dilution: 10%

### Airless Gun:

Use Airless: Use at least pump 60: 1  
Fluid pressure: 1500 - 2500 psi  
Hose: ¼" internal diameter  
Nozzle: 0,015" - 0,021"  
Dilution: Max. 5%

### 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:

Use a thin nap, seamless sheepskin or microfiber roller for epoxy coatings.  
For application with brush and/or roller, two or more passes may be necessary to obtain a uniform layer according to the recommended film thickness per coat.

### Cleaning the equipment:

Pu diluent 5003

### 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.

Clean all equipment immediately after use.

### PERFORMANCE IN THE APPLICATION

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

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.

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.

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.

Polyurethane systems (component A and B) present when exposed to air relative humidity, which can cause flaws in the dry film and reduction of pot life. Therefore, we recommend that the packages of each component be properly closed after use and kept in dry places protected from bad weather.

In coatings with variation in application method in the same job, the final aspect and gloss of the painted surfaces may show differences.

Some colors may require an additional coat to achieve uniform coverage.

On newly painted surfaces in direct contact with water during the curing process, localized stains may occur with changes in their color (more visible in dark colors), delay in curing and compromised product performance.

For further information, consult WEG Technical Department.

### COMPATIBILITY OF SYSTEMS AND MAINTENANCE REFINISHING

The direct application of this product on zinc-rich ethyl silicate-based primers, alkyd primers, coal tar-based coatings and other single-component primers is not recommended. When necessary to apply the topcoat over one of the primers mentioned above, we recommend the application of an appropriate intermediate coating.

In situations where the nature of the primer is unknown, it is recommended to test the compatibility of the product in a small area. Check the original material is well adhered. All loose coating must be removed. Points with corrosion or application over aged coatings should be treated according to technical guidance.

The primer overcoating interval should be observed before applying the topcoat. If the maximum recommended overcoating interval is exceeded, manual/mechanical sanding is necessary to break the gloss. The primer surface must be dry and free of any contaminants.

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](http://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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