



W-THANE ENG 021

PRODUCT DESCRIPTION

High-performance two-component aliphatic acrylic polyurethane primer/finish with zinc phosphate-based anticorrosive pigmentation. Good chemical and continuous weathering resistance, excellent adhesion on carbon steel and galvanized steel, excellent color and gloss retention, high resistance to atmospheric agents, high hardness and impact performance.

RECOMMENDED USE

Excellent finish for painting machinery and equipment requiring resistance to natural weathering. Also recommended for painting electrical towers and communication towers, metal structures, parts, and galvanized equipment.

CERTIFICATIONS AND APPROVALS

When supplied to comply with the ROHS Directive (Restriction of Certain Hazardous Substances), this product includes the letter R in its nomenclature description.

PACKAGING

Component A	52.83 US gal Package containing 52.83 US gal
Component B	5.28 US gal Package containing 5.28 US gal

CHARACTERISTICS

Color	According to customer standard. RAL and Munsell chart.
Gloss	Gloss
VOC content	3.94 lb/gal
Volume Solids	38 ± 2% (ISO 3233)
Shelf Life	12 months
Dry Film Thickness	1.6 mils - 2.4 mils
Dry Heat Resistance	Maximum temperature 194 °F. The product maintains its chemical properties up to a temperature of 194 °F, but from 140°F, color and gloss variations in the paint may occur.
Theoretical Coverage	1 without dilution at a dry film thickness of 2.0 mils. Loss factors during application are not considered.

DRYING

Drying	77 °F
Touch	30 min
Manipulation	3 hours
Final	168 hours
Recoat Drying	77 °F
Minimum	12 hours
Maximum	48 hours

SURFACE PREPARATION

Standard Surface Preparation
The performance of this product is related to the degree of surface preparation. In case of doubts, for more information, consult WEG's Technical Department.

The surface must be clean, dry, and free of contaminants. Completely remove oils, greases, and fats according to SSPC-SP1.

Accumulated dirt must be removed using a dry brush, and soluble salts must be removed by washing with fresh water under high pressure.



Recommended Surface Profile

It is recommended a roughness profile between 1.57 and 2.36 mils.

Abrasive Blasting

For other applications, it is recommended to paint on surfaces blasted to Sa 2½ or Sa 3 grade, according to SSPC-SP10 or SSPC-SP5, respectively. Visual standard ISO 8501-1.

Evaluate the surface after blasting, observing revealed defects and adopt practices to minimize them, such as grinding or filling.

Maintenance and Repair

NOTE: Respect the recoating interval for subsequent coat application. If exceeded, perform light manual/mechanical sanding to break the previous coat gloss, followed by dust and residue cleaning to ensure better adhesion between paint layers.

Carbon Steel Surfaces

Completely remove oils, greases, soluble salts, and other contaminants according to SSPC SP1 solvent cleaning method. Rinse with high-pressure fresh water.

The surface must be clean, dry, and free of contaminants.

Hot-Dip Galvanized Surfaces

Remove surface grease with clean cloths soaked in PU 5001 Solvent. Proceed with a "light sanding" using 180-grit sandpaper, making cross-hatch scratches (horizontal and vertical) whenever possible. Clean the surface again with cloths soaked in solvent, changing them frequently. During all surface cleaning with cloths, avoid using rags or colored cloths.

Non-Ferrous and Electro-Galvanized Surfaces

Initially remove surface grease with clean cloths soaked in PU 5001 Solvent. Perform a "light sanding" using 180-grit sandpaper, making cross-hatch scratches (horizontal and vertical) whenever possible. Clean the surface again with cloths soaked in solvent, changing them frequently. Avoid using rags or colored cloths during all cleaning.

APPLICATION PREPARATION

Mixing	Homogenize the content of each component using mechanical or pneumatic stirring (A and B). Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated mixing ratio under stirring until completely homogenized, respecting the mixing ratio.
Mixing Ratio	By volume: 3 A x 1 B.
Thinner	PU DILUENT 5008
Dilution	Depending on the application method, dilute to a maximum of 20%.
Notes	The amount of Diluent may vary depending on the type of equipment used and environmental conditions during application. Only add Diluent after complete mixing of the other components. Do not dilute with solvents not allowed by local legislation, and do not exceed the indicated dilution percentage. Excessive dilution may affect film formation, appearance, and make it difficult to achieve the specified thickness.
Pot Life	1 h 30 min The shelf life of the mixture is reduced as the ambient temperature increases. The pot-life test of the mixture is carried out according to ABNT NBR 15742; however, different volumes of paint prepared at once, combined with varying ambient and paint temperatures, will affect the mixture's shelf life, potentially resulting in outcomes different from those stated in this technical bulletin.
Induction Time	No induction time required. In very hot locations, we recommend consulting WEG's



Technical Department.

APPLICATION METHODS

Conventional Spray Gun	<p>Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 60 - 65 psi Tank pressure: 10 - 20 psi.</p>
Roller	<p>Not recommended.</p>
Brush	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups). For application with brush and/or roller, it may be necessary to apply two or more coats to achieve a uniform layer and the recommended film thickness.</p>
Cleaning of the equipments:	<p>PU DILUENT 5008</p>
Notes	<p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination. Do not allow catalyzed product to remain in contact with application equipment, as at temperatures above the indicated "pot life", the paint will show variation in flow and will harden, making cleaning difficult. Before application, ensure that the equipment and respective components are clean and in optimal condition. After mixing two-component products, if there are application stops and the pot life has been exceeded (paint shows variation in flow), it can no longer be re-thinned for later application. Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas. Clean all equipment immediately after use. Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.</p>

APPLICATION PERFORMANCE

For coatings applied in coastal areas exposed to sea spray, it is recommended to wash with fresh water between coats to remove deposited impurities.

Do not apply the product after the pot life has been exceeded.

For optimal application properties, the paint temperature must be between 69.8°F - 80.6°F before mixing and application.

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point.

Must not be applied under adverse conditions, such as relative humidity (RH) above 85%, as color and appearance changes may occur.

Paintings performed with varying application methods on the same project may result in differences in gloss and final appearance.

Small variations in color, appearance, and gloss (more noticeable in dark colors), as well as delayed curing and performance compromise, may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals. Carefully read all information contained in the SDS of this product, available at: www.weg.net.
 Store in a covered and well-ventilated place. 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. Use protective gloves/protective clothing/eye protection/face protection.
 Empty containers and materials with paint residues must be disposed of according to current legislation. Take care of the environment.



NOTE

The information contained in this technical bulletin is based on the experience and knowledge acquired in the field by WEG's technical team.

In the event of using the product without prior consultation with WEG regarding its suitability for the purpose for which the customer intends to use it, the customer acknowledges that the use will be at their own exclusive responsibility, and WEG is not liable for the behavior, safety, suitability, or durability of the product.

Some information mentioned in this bulletin is only an estimate and may vary due to factors beyond the manufacturer's control. Therefore, WEG does not guarantee and assumes no responsibility for performance, efficiency, or any material or personal damages resulting from the incorrect use of the products in question or from the information contained in this Technical Bulletin.

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