



W-THANE HBA 53

PRODUCT DESCRIPTION: Two-component high-thickness aliphatic acrylic polyurethane finish paint. It has anti-corrosion protection, chemical resistance and resistance to continuous weathering. It forms an economical anti-corrosion system when applied over a high thickness epoxy primer.

RECOMMENDED USES: Excellent finish for the electrical transformers industry, chemical industries, pulp and paper, petrochemical, sugar & alcohol, metal structures, external painting of tanks and equipment in general exposed to continuous weathering.

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 3,08	20 3,6	L
	Component B	2,85 0,52	3,6 0,9	L

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

Gloss:			
	Gloss	>80 UB	HBA 531
	Semigloss	60 – 80 UB	HBA 532
	Semi matte	30 – 60 UB	HBA 533
	Matte	15 – 30 UB	HBA 534
	Ultra matte	0 – 15 UB	HBA 535

Volume solid: 52 ± 2% (ISO 3233).

Shelf-Life: 24 months at 25°C.

Thickness per coat (dry): 70 µm –80 µm

Theoretical coverage: 6,9 m²/l without dilution in the thickness of 75 µm dry. Without considering loss factors in application.

Resistance to dry heat: 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.

Drying:

	10°C	25°C	35°C
	24 hours	16 hours	12 hours
	240 hours	168 hours	120 hours

**Overcoating
Drying:**

	10°C	25°C	35°C
Min	12 hours	5 hours	5 hours
Max	48 hours	24 hours	-

SURFACE PREPARATION The performance of this product depends on the degree of surface preparation.

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

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

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 component A by means of mechanical or pneumatic stirring. Ensure that no sediment is settled at the bottom of the package. Slowly add component A to component C. Slowly homogenize by manual or pneumatic stirring until a homogeneous, lump-free mixture is obtained. Only then add component B. Repeat the homogenization process. The mixing ratio recommended for the preparation of the paint should be observed. If necessary, filter using a 60 mesh screen.

Mixing ratio (Volume)

6 A X 1 B.

Diluent

Pu diluent 5003

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

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

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Changes in nozzle sizes and pressures may be necessary to improve spraying characteristics.

Before application, check if the equipment and its components are clean and in best condition.

After mixing two-component 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
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:	2000 - 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.

TECHNICAL DATA SHEET



Cleaning the equipment:

Pu diluent 5003

Clean all equipment immediately after use.

NOTE:

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.

Light colors may require more than one coat for an even coverage.

Do not apply the product after the pot life has expired.

Variations in color, aspect and gloss (more noticeable in dark colors) may occur, as well as delay in curing and low coating performance, when applied during periods of high air relative humidity, rainy days, low temperatures or drying the coating outdoor.

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

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.

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 respected 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.

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: