



W-CRIL SEA 854 PEM

PRODUCT DESCRIPTION			High-build, two-component phenolic novolac epoxy primer and topcoat. Provides excellent chemical resistance, including against various solvents, as well as outstanding anticorrosive and abrasion resistance.		
RECOMMENDED USE			Indicated for painting panels, machinery, equipment, automotive parts, and household utensils.		
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			Single Component	20L Package containing 20L	
CHARACTERISTICS			Color	RAL, Munsell, or according to the customer's standard.	
			Gloss	Gloss (>80 UB) W-CRIL SEA 854 PEM1 Semi-gloss (60 - 80 UB) W-CRIL SEA 854 PEM2 Semi-matte (30 - 60 UB) W-CRIL SEA 854 PEM3 Matte (15 - 30 UB) W-CRIL SEA 854 PEM4 Ultra-matte (0 - 15 UB) W-CRIL SEA 854 PEM5	
			Volume Solids	46 ± 5% (ISO 3233)	
			Shelf Life	12 months	
			Dry Film Thickness	1.4 mils (35 µm) - 1.8 mils (45 µm)	
			Dry Heat Resistance	Maximum temperature 392 °F (200 °C). Organic coatings can undergo changes in color, gloss, and adhesion when exposed to temperatures above 392 °F (200 °C).	
			Theoretical Coverage	468.6 ft²/ga (11,50 m2/l) without dilution at a dry film thickness of 1.6 mils (40 µm). Loss factors during application are not considered.	
			Oven Drying		
				140 °C	160 °C
			Time	20 min	10 min
			Flash off	10 min	
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.		
APPLICATION PREPARATION			Mixing	Homogenize the component content with a spatula. Ensure no pigment remains at the bottom of the container. Add component B to component A respecting the mixing ratio. Mix thoroughly with the spatula.	
			Thinner	ALKYDIC DILUENT 1027	
			Dilution	Depending on the application method, dilute to a maximum of 25%.	
			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

Not relevant.

APPLICATION METHODS

Cleaning of the equipments:

ALKYDIC DILUENT 1027

Notes

The data presented serves as a guide and similar equipment may be used.
Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.
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.

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.

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

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

For optimal application properties, the paint temperature should be between 21°C and 27°C before mixing and application.

Painting is recommended only if surface temperature is at least 3°C 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.

Polyurethane systems (components A and B) are sensitive to relative humidity, which may cause defects in the dry film and reduction in pot life. After use, keep containers closed and protected.

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

Product not recommended for internal tank painting.

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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