



W-THANE ENG 011 M0710214

**PRODUCT DESCRIPTION**

Aliphatic acrylic polyurethane primer/finish with excellent durability.

**RECOMMENDED USE**

Excellent finish for painting machinery, equipment, and metal structures exposed to natural weathering.

**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**

|                    |                            |
|--------------------|----------------------------|
| <b>Component A</b> | 20L Package containing 18L |
| <b>Component B</b> | 4L Package containing 2L   |

**CHARACTERISTICS**

|                             |   |
|-----------------------------|---|
| <b>Color</b>                | RAL, Munsell, or according to the customer's standard.  |
| <b>Gloss</b>                | Semi-Gloss  |
| <b>VOC content</b>          | 619.33 g/l  |
| <b>Volume Solids</b>        | 42 ± 2% (ISO 3233)  |
| <b>Shelf Life</b>           | 12 months   |
| <b>Dry Film Thickness</b>   | 90 µm - 110 µm  |
| <b>Dry Heat Resistance</b>  | Maximum temperature 90 °C.<br>The product maintains its chemical properties up to a temperature of 90 °C, but from 60°C, color and gloss variations in the paint may occur. |
| <b>Theoretical Coverage</b> | 4,20 m <sup>2</sup> /l without dilution at a dry film thickness of 100 µm. Loss factors during application are not considered.  |

**DRYING**

|                      |                |              |              |
|----------------------|----------------|--------------|--------------|
| <b>Drying</b>        | <hr/>          |              |              |
|                      | <b>10 °C</b>   | <b>25 °C</b> | <b>35 °C</b> |
|                      | <hr/>          |              |              |
|                      | <b>Touch</b>   | 2 hours      | 1 hour       |
| <b>Manipulation</b>  | 8 hours        | 3 hours      | 3 hours      |
| <b>Final</b>         | 240 hours      | 168 hours    | 168 hours    |
| <br>                 |                |              |              |
| <b>Recoat Drying</b> | <hr/>          |              |              |
|                      | <b>10 °C</b>   | <b>25 °C</b> | <b>35 °C</b> |
|                      | <hr/>          |              |              |
|                      | <b>Minimum</b> | 24 hours     | 8 hours      |
| <b>Maximum</b>       | 48 hours       | 48 hours     | 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.

Completely remove oils and greases by applying a degreasing product or according to the solvent cleaning method. Whenever cleaning surfaces with cloths, replace them to avoid saturation. Do not use cotton waste or colored cloths.

Remove accumulated dirt using a dry brush, clean dry cloth, compressed air blow, vacuum, or a combination of these. Remove soluble salts by washing with plenty of fresh water, preferably under low pressure (up to 5,000 psi), according to SSPC-SP12/NACE No. 5 standard.

**Recommended Surface Profile**

It is recommended a roughness profile between 40 and 60 micrometers.



**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.

**APPLICATION PREPARATION**

|                     |  |
|---------------------|--|
| <b>Mixing</b>       | 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.   |
| <b>Mixing Ratio</b> | By volume: 9 A x 1 B.  |
| <b>Thinner</b>      | PU DILUENT 5003  |
| <b>Dilution</b>     | Depending on the application method, dilute to a maximum of 20%.   |
| <b>Notes</b>        | 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. |
| <b>Pot Life</b>     | 6 h<br><br>The shelf life of the mixture is reduced as the ambient temperature increases.<br><br>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.      |

**APPLICATION METHODS**

|                                    |   |
|------------------------------------|---|
| <b>Conventional Spray Gun</b>      | Spray gun: JGA 502/3 Devilbiss or equivalent<br>Fluid nozzle: EX<br>Air cap: 704<br>Atomization pressure: 60 - 65 psi<br>Tank pressure: 10 - 20 psi.  |
| <b>Airless Spray Gun</b>           | Airless: Use minimum pump 60:1<br>Fluid pressure: 1500 - 2500 psi<br>Hose: 1/4" inner diameter<br>Nozzle: 0.015" - 0.021".  |
| <b>Brush</b>                       | Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).  |
| <b>Cleaning of the equipments:</b> | PU DILUENT 5003   |
| <b>Notes</b>                       | Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.<br>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.

In spray application, overlap each gun pass by 50%, finishing with a cross pass. This technique avoids uncovered or unprotected areas and ensures proper aesthetic finish.

Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.

Clean all equipment immediately after use.

**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 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.

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.

Polyurethane systems (components A and B) are sensitive when exposed to ambient relative humidity, which may cause defects in the dry film and reduce pot life. Therefore, we recommend that the packaging of each component, after use, be properly sealed and stored in dry places protected from weather conditions.

**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](http://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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