



W-THANE DOUBLE FUNCTION

PRODUCT DESCRIPTION		High-performance aliphatic/acrylic polyurethane primer and finish. Good chemical and continuous weathering resistance, excellent adhesion on carbon steel, excellent color retention, high resistance to atmospheric agents and some solvents, high hardness performance.
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	Component A	5.28 US gal Package containing 3.51 US gal
	Component B	1.06 US gal Package containing 0.88 US gal
CHARACTERISTICS	Color	Gray.
	Gloss	Matte
	VOC content	5.02 lb/gal
	Volume Solids	38 ± 2% (ISO 3233)
	Shelf Life	12 months
	Dry Film Thickness	2.0 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	281.6 ft²/gal without dilution at a dry film thickness of 2.2 mils. Loss factors during application are not considered.
DRYING		
	Drying	77 °F
	Touch	60 min
	Manipulation	4 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.
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.

Homogenize the content of component A using mechanical stirring. Ensure no sediment remains at the bottom of the container. Add component B to component A in the indicated (volume) proportions under stirring until completely homogenized, respecting the mixing ratio.

Mixing ratio: 3 A x 1 B, by volume.

Mixing Ratio

By volume: 2 A x 1 B.

Thinner

PU DILUENT 5003

Dilution

Depending on the application method, dilute to a maximum of 15%.

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

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

Spray gun: JGA 502/3 Devilbiss or equivalent
Fluid nozzle: EX or FF
Air cap: 704.

Brush

Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).

Cleaning of the equipments:

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Notes

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.

Do not leave material in hoses, guns, or equipment used for spraying. Thoroughly wash all used equipment.

It is considered good practice to periodically wash the spraying equipment during the day. The cleaning frequency depends on the amount sprayed, temperature, and elapsed time, including all delays.

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.

Do not apply under adverse conditions, such as RH above 85%, as gloss and color may slightly change. Do not apply on condensed surfaces.

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.

The information contained in this technical bulletin is subject to periodic modifications, without prior notice, due to our policy of continuous improvement and evolution of our products and services, providing quality solutions to meet the needs of our customers.