

**W-THANE ERA 53**

**PRODUCT DESCRIPTION**

Conventional two-component aliphatic polyurethane finish paint. Good natural weathering resistance.

**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>	3.6L Package containing 2.7L 20L Package containing 15L
<b>Component B</b>	0.9L Package containing 0.9L 5L Package containing 5L

**CHARACTERISTICS**

<b>Color</b>	According to customer standard. RAL and Munsell chart.
<b>Gloss</b>	Gloss (>80 UB) W-THANE ERA 531 Semi-gloss (60 - 80 UB) W-THANE ERA 532 Semi-matte (30 - 60 UB) W-THANE ERA 533 Matte (15 - 30 UB) W-THANE ERA 534 Ultra-matte (0 - 15 UB) W-THANE ERA 535
<b>VOC content</b>	334.18 g/l
<b>Volume Solids</b>	38 ± 5% (ISO 3233)
<b>Shelf Life</b>	12 months
<b>Dry Film Thickness</b>	30 µm - 50 µm
<b>Dry Heat Resistance</b>	Maximum temperature 100 °C. The product maintains its chemical properties up to a temperature of 100 °C, but from 60°C, color and gloss variations in the paint may occur.
<b>Theoretical Coverage</b>	9,50 m <sup>2</sup> /l without dilution at a dry film thickness of 40 µm. Loss factors during application are not considered.

**DRYING**

<b>Drying</b>	<b>25 °C</b>
<b>Touch</b>	1 hour
<b>Manipulation</b>	3 - 5 hours
<b>Final</b>	168 hours
<b>Recoat Drying</b>	<b>25 °C</b>
<b>Minimum</b>	5 hours
<b>Maximum</b>	24 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.

**Over Primer**

The product must be applied over a specific primer. The primer must be clean, dry, and free of contaminants. The topcoat must be applied within the primer recoat interval. Consult the primer technical bulletin for correct application.

Respect the product recoat interval. If exceeded, perform light manual/mechanical sanding to break gloss and clean dust/residues for better adhesion between coats.

**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: 3 A x 1 B.
<b>Thinner</b>	PU DILUENT 5003
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 25%.
<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  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.
<b>Induction Time</b>	No induction time required.  In very hot locations, we recommend consulting WEG's Technical Department.

**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	Spray gun: JGA 502/3 Devilbiss or equivalent Fluid nozzle: EX Air cap: 704 Atomization pressure: 50 - 70 psi Tank pressure: 10 - 20 psi.
<b>Airless Spray Gun</b>	Airless: Use minimum pump 60:1 Fluid pressure: 1500 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.013" - 0.017".
<b>Brush</b>	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.
<b>Cleaning of the equipments:</b>	PU DILUENT 5003
<b>Notes</b>	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.

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.

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.

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.

Before application, observe weather conditions: there must be no threat of rain or drizzle. Surface temperature must be at least 3°C above the dew point, and relative humidity should not exceed 85%. Adverse conditions may cause color variations and other characteristics. Consult WEG Technical Department.

Painting is recommended only if surface temperature is at least 3°C above the dew point.

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.

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.

Under adverse weather conditions in indoor and/or outdoor environments with high relative humidity, rain or drizzle, low or very low temperatures, and excessively high temperatures, variations in color and other product characteristics may occur. Please consult WEG's Technical Department for more information.

**SYSTEM COMPATIBILITY AND MAINTENANCE REPAINTING**

The primer repainting interval must be respected for the application of the topcoat. If the maximum interval indicated is exceeded, manual/mechanical sanding with sandpaper to remove gloss is necessary. The primer surface must be dry and free of contaminants.

**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.



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**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.

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