



W-THANE SRD 85



**PRODUCT DESCRIPTION**

High-performance two-component aliphatic acrylic/polyester polyurethane primer/finish. Good chemical and continuous weathering resistance, excellent color and gloss retention, high resistance to atmospheric agents, excellent hardness and impact performance.

**RECOMMENDED USE**

Excellent direct-to-metal for painting machinery, vehicle bodies, and equipment that need natural weathering resistance.

**PACKAGING**

<b>Component A</b>	0.95 US gal Package containing 0.86 US gal 5.28 US gal Package containing 4.76 US gal
<b>Component B</b>	0.24 US gal Package containing 0.10 US gal 0.95 US gal Package containing 0.53 US gal

**CHARACTERISTICS**

<b>Color</b>	Aluminum.
<b>Gloss</b>	Semi-Matte
<b>Volume Solids</b>	44 ± 2% (ISO 3233)
<b>Shelf Life</b>	12 months
<b>Dry Film Thickness</b>	1.2 mils - 2.0 mils
<b>Dry Heat Resistance</b>	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.
<b>Theoretical Coverage</b>	448.3 ft <sup>2</sup> /gal without dilution at a dry film thickness of 1.6 mils. Loss factors during application are not considered.

**DRYING**

<b>Drying</b>	77 °F
<b>Touch</b>	8 min
<b>Manipulation</b>	55 min
<b>Final</b>	168 hours
<b>Recoat Drying</b>	77 °F
<b>Minimum</b>	12 hours
<b>Maximum</b>	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.

Accumulated dirt must be removed using a dry brush, and soluble salts must be removed by washing with fresh water under high pressure.

**Carbon Steel Surfaces**

Completely remove oils, greases, soluble salts, and other contaminants according to SSPC SP1 solvent cleaning method. Rinse with high-pressure fresh water.

The surface must be clean, dry, and free of contaminants.

**APPLICATION PREPARATION**

<b>Mixing</b>	Homogenize the content of each component using
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	<p>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.</p> <p>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.</p>
<b>Mixing Ratio</b>	By volume: 9 A x 1 B.
<b>Thinner</b>	PU DILUENT 5003
<b>Dilution</b>	Ready to use.
<b>Notes</b>	No dilution is required. Product ready to use. If necessary, consult the WEG Technical Department.
<b>Pot Life</b>	6 h
	<p>The shelf life of the mixture is reduced as the ambient temperature increases.</p> <p>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.</p>
<b>Induction Time</b>	<p>Wait 10 to 15 minutes before application.</p> <p>In very hot locations, we recommend consulting WEG's Technical Department.</p>

**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	<p>Spray gun: JGA 502/3 Devilbiss or equivalent                  Fluid nozzle: EX                  Air cap: 704                  Atomization pressure: 60 - 65 psi                  Tank pressure: 10 - 20 psi.</p>
<b>Airless Spray Gun</b>	Airless: not recommended.
<b>Roller</b>	Not recommended.
<b>Brush</b>	<p>Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).</p> <p>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.</p>
<b>Cleaning of the equipments:</b>	PU DILUENT 5003
<b>Notes</b>	<p>The data presented serves as a guide and similar equipment may be used.</p> <p>Changes in pressures and nozzle sizes may be necessary to improve spraying characteristics. Purge the compressed air line to avoid paint contamination.</p> <p>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.</p> <p>Before application, ensure that the equipment and respective components are clean and in optimal condition.</p> <p>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</p>



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.

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.

Substrate temperature, climatic and environmental conditions during application and curing, as well as applied film thickness, may affect drying time.

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

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.

**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.

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.