



WEGTHANE HPA 50 ALUMINUM

PRODUCT DESCRIPTION			Three-component aliphatic acrylic polyurethane topcoat, pigmented with aluminum. Offers excellent durability and long-term repainting.		
RECOMMENDED USE			Used as a topcoat above the waterline on metal structures, industrial equipment, and various machinery. Also recommended as an anti-graffiti coating.		
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	3.6L Package containing 2.78L 20L Package containing 15.48L	
			Component B	0.5L Package containing 0.5L 4L Package containing 2.85L	
			Component C	0.9L Package containing 0.441kg 3.6L Package containing 2.45kg	
CHARACTERISTICS			Color	Aluminum.	
			Gloss	Semi-Gloss Metallic	
			VOC content	586.98 g/l	
			Shelf Life	24 months	
			Dry Film Thickness	50 µm - 60 µm	
			Theoretical Coverage	10,18 m2/l without dilution at a dry film thickness of 55 µm. Loss factors during application are not considered.	
DRYING			Drying		
				10 °C	25 °C
			Touch	4 hours	2 hours
			Manipulation	24 hours	6 hours
			Final	240 hours	168 hours
			Recoat Drying		
				10 °C	25 °C
			Minimum	24 hours	6 hours
			Maximum	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.	
				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.	



Over Aged Coating

It is recommended to test the paint on a small area to check compatibility and ensure aged paint is well adhered. Loose or poorly adhered paints must be removed. Repainting should be done only on well-preserved surfaces.

Remove all contaminants from the existing paint. Areas where the film is not adhered must be removed with light blasting grade Sa 1 (brush off) or according to SSPC-SP7, ISO 8501-1 visual standard. Corrosion points, worn, or damaged areas must be prepared by commercial abrasive blasting grade Sa 2, ISO 8501-1 standard or SSPC-SP6/NACE No.3, SSPC-VIS 1 standard. If not possible, use rotary-mechanical tools according to SSPC-SP 11.

APPLICATION PREPARATION

Mixing	Homogenize the content of component A using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container. Gradually add component A to component C. Homogenize slowly using manual or pneumatic stirring until a smooth, lump-free mixture is obtained. Then add component B. Repeat the homogenization process. The indicated mixing proportion for paint preparation must be respected. If necessary, filter through a 60-mesh screen.
Mixing Ratio	By volume: 3.3 A x 1 B.
Thinner	PU DILUENT 5003
Alternative Thinners	Add the diluent after the complete mixing of the other components.
Dilution	Depending on the application method, dilute to a maximum of 20%.
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	2 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	Wait 15 to 20 minutes before application. In very hot locations, we recommend consulting WEG's Technical Department.

APPLICATION METHODS

Airless Spray Gun	Airless: Use minimum pump 60:1 Fluid pressure: 1500 - 2500 psi Hose: 1/4" inner diameter Nozzle: 0.015" - 0.021".
Roller	Use a short-haired, seamless wool or synthetic roller for epoxy paints. 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.
Brush	Recommended only for small area touch-ups or "stripe coat" (screws, nuts, weld beads, sharp corners, and touch-ups).



Cleaning of the equipments:

PU DILUENT 5003

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.

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.

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.

Variations in appearance, roughness, and absorption of concrete floors, associated with roller application, may result in higher sealer varnish consumption.

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

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.

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.

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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