



## W-THANE AC/SB 486

### PRODUCT DESCRIPTION

Acrylic/polyester polyurethane primer/finish catalyzed with aliphatic isocyanate. Semi-gloss paint with excellent color and gloss retention. Resistant to extreme chemical and environmental conditions. Excellent applicability by filling (circulation) process.

### RECOMMENDED USE

Indicated for internal coating of conventional steel maintenance systems of radiators, transformers, and generators.

### CERTIFICATIONS AND APPROVALS

Complies with ABNT NBR 14274 standard- Determination of the compatibility of materials used in electrical equipment (mineral insulating oil for radiators).

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> | 0.95 US gal Package containing 0.71 US gal |
| <b>Component B</b> | 0.24 US gal Package containing 0.24 US gal |

### CHARACTERISTICS

|                             |                                                                                                                                                                                |
|-----------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Color</b>                | White.<br>Colors upon request.                                                                                                                                                 |
| <b>Gloss</b>                | Semi-Gloss                                                                                                                                                                     |
| <b>VOC content</b>          | 5.99 lb/gal<br>lb/gal                                                                                                                                                          |
| <b>Volume Solids</b>        | 58 ± 2% (ISO 3233)                                                                                                                                                             |
| <b>Flash Point</b>          | 31 °C<br>25 °C                                                                                                                                                                 |
| <b>Shelf Life</b>           | 24 months                                                                                                                                                                      |
| <b>Dry Film Thickness</b>   | 1.2 mils - 1.6 mils                                                                                                                                                            |
| <b>Dry Heat Resistance</b>  | Maximum temperature 248 °F.<br>The product maintains its chemical properties up to a temperature of 248 °F, but from 140°F, color and gloss variations in the paint may occur. |
| <b>Theoretical Coverage</b> | 675.2 ft <sup>2</sup> /gal without dilution at a dry film thickness of 1.4 mils. Loss factors during application are not considered.                                           |
| <b>Specific Gravity</b>     | Min: 1.45 Max: 1.55 g/cm <sup>3</sup><br>Min: 1.52 Max: 1.62 g/cm <sup>3</sup>                                                                                                 |

### DRYING

#### Drying

|                     | 50 °F     | 77 °F     | 95 °F     |
|---------------------|-----------|-----------|-----------|
| <b>Touch</b>        | 5 hours   | 3 hours   | 2 hours   |
| <b>Manipulation</b> | 11 hours  | 8 hours   | 5 hours   |
| <b>Final</b>        | 216 hours | 168 hours | 120 hours |

#### Recoat Drying

|                | 50 °F    | 77 °F    | 95 °F    |
|----------------|----------|----------|----------|
| <b>Minimum</b> | 24 hours | 20 hours | 12 hours |
| <b>Maximum</b> | 48 hours | 36 hours | 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.

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.

## 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 5008                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |
| <b>Alternative Thinners</b> | PU 5008 Diluent - Flooding.<br>Thinner SL 42 - Spray gun.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| <b>Dilution</b>             | Depending on the application method, dilute to a maximum of 30%.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
| <b>Notes</b>                | Dilute according to recommendation.<br><br>Only add the thinner after the A + B components are completely mixed.<br><br>Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness.<br>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>             | 4 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: 50 - 70 psi<br>Tank pressure: 10 - 30 psi.                                                                               |
| <b>Airless Spray Gun</b>      | Airless: Use minimum pump 60:1<br>Fluid pressure: 2000 - 2500 psi<br>Hose: 1/4" inner diameter<br>Nozzle: 0.015" - 0.021".<br>Filter: mesh 60.                                                                                     |
| <b>Roller</b>                 | Use a short-haired, seamless wool or synthetic roller for epoxy paints.<br>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).

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.

## Cleaning of the equipments:

PU DILUENT 5008

## 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.

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.

Light colors may require more than one coat to achieve uniform coverage.

Do not apply the product after the pot life has been exceeded.

During the initial curing (first 24 hours), humidity must not exceed 70%, otherwise the visual appearance may be compromised.

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 70% or on condensed surfaces. Small variations in color, appearance, and gloss may occur during high humidity, rainy days, cold locations, or when parts dry outdoors.

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.



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