

W-THANE LXP 54

PRODUCT DESCRIPTION

Two-component aromatic polyurethane primer. Excellent protection, drying, and adhesion on carbon steel and fiber (RTM).

RECOMMENDED USE

Excellent primer for painting payphones, vehicle bodies, and bus bodies on fiberglass and carbon steel parts, providing good filling. Can be applied over polyester putty and nitrocellulose.

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 2.88L 20L Package containing 16L
Component B	0.9L Package containing 0.72L 4L Package containing 4L

CHARACTERISTICS

Color	Gray.
Gloss	Ultra-Matte
Volume Solids	40 ± 5% (ISO 3233)
Flash Point	28 °C
Shelf Life	12 months
Dry Film Thickness	30 µm - 40 µm
Dry Heat Resistance	Maximum temperature 90 °C. The product maintains its chemical properties up to a temperature of 90 °C, but from 60°C, color and gloss variations in the paint may occur.
Theoretical Coverage	11,43 m ² /l without dilution at a dry film thickness of 35 µm. Loss factors during application are not considered.

DRYING

Drying	25 °C
Touch	1 hour
Manipulation	2 hours
Final	168 hours
Recoat Drying	25 °C
Minimum	1 hour
Maximum	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.

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.



Abrasive Blasting

Perform abrasive blasting to near-white metal, Sa 2½ grade, according to ISO 8501-1 visual standard (A Sa 2½, B Sa 2½, C Sa 2½, D Sa 2½), or according to SSPC-SP10/NACE No. 2, visual standard SSPC-VIS 1 (A SP10, B SP10, C SP10, D SP10, G1 SP10, G2 SP10, G3 SP10).

A roughness profile equivalent to # to ¼ of the total system thickness (primer + topcoat) is recommended.

Inspect the freshly blasted surface, observing defects that may appear after treatment. Correct them by grinding, filling with welds and/or epoxy putty.

For areas near marine environments, wash with fresh water at low pressure (minimum 3,000 psi) before abrasive blasting. In some cases, repeat washing after blasting to remove soluble contaminants and perform a new abrasive blasting.

If oxidation occurs between the end of abrasive blasting and coating application, the surface must be blasted again until the specified visual standard is achieved.

Sanding

It is recommended to paint on fiber or carbon steel surfaces properly degreased and sanded with 320/400 grit sandpaper, according to the desired finish aspect.

Maintenance and Repair

NOTE: Respect the recoating interval for subsequent coat application. If exceeded, perform light manual/mechanical sanding to break the previous coat gloss, followed by dust and residue cleaning to ensure better adhesion between paint layers.

Carbon Steel Surfaces

Hard surface layers (e.g., layers resulting from flame cutting) must be removed by grinding before starting abrasive blasting.

All welds must be inspected and, if necessary, repaired before completing abrasive blasting. Porosities, cavities, weld splatter, etc., must be repaired with proper mechanical treatment or welding repair. In other areas, round edges and sharp corners (r # 2 mm, ISO 8501-3).

Fiber Surfaces

Remove all dirt and grease from the surface using clean cloths soaked in Cleaning Solvent according to SSPC SP1. Avoid using rags or colored cloths. Proceed with a "light sanding" using 180-grit sandpaper to promote roughness. Whenever possible, make cross-hatch scratches (horizontal and vertical). Clean the surface again with cloths soaked in solvent, changing them frequently.

APPLICATION PREPARATION

Mixing	Homogenize the content of the container using mechanical or pneumatic stirring. Ensure no sediment remains at the bottom of the container.
Mixing Ratio	By volume: 4 A x 1 B.
Thinner	PU DILUENT 5003
Alternative Thinners	PU 5004 Thinner - Slow Drying PU 5001 Thinner - Fast Drying
Dilution	Depending on the application method, dilute to a maximum of 15%.
Notes	In very hot locations, we recommend consulting the WEG Technical Department. Only add the diluent after completely mixing components A and B.
Pot Life	4 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 minutes before application.

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
Air cap: 704
Atomization pressure: 50 - 70 psi
Tank pressure: 10 - 20 psi.

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.

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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providing quality solutions to meet the needs of our customers.
