

W-THANE SRA 511

PRODUCT DESCRIPTION:	Conventional smooth 2-pack aliphatic polyurethane direct to metal. Good resistance to natural weathering and very good adhesion.
RECOMMENDED USES:	Excellent top coat for painting machinery and equipment and metal structures exposed to weathering.
CERTIFICATIONS AND APPROVAL:	This product, when supplied to comply with the RoHs Directive (Restriction of Certain Hazardous Substances) has the letter R in its description.

PACKAGING:	Component	Content	Package	Unit of measurement
	Component A	13,3	20	L
		2,4	3,6	
	Component B	3,35	3,6	L
		1,2	1,5	

CHARACTERISTICS: Color:	Ral, Munsell or as per customer standard.			
Gloss:	Gloss >80 UB			
Volume solid:	42 ± 5% (ISO 3233).			
Expiry Date:	12 months at 25 ° C - Component A 06 months at 25 ° C - Component B			
Thickness per coat (dry):	30 µm –50 µm			
Theoretical coverage:	10,5 m ² /l without dilution in the thickness of 40 µm dry. Without considering the loss factors in the application.			
Resistance to dry heat:	Maximum temperature 100 °C . The product retains its physical and chemical properties up to the temperature of 100 °C however, variations in the coating color and gloss may occur from 60 °C.			
Drying:				
	10°C	25°C	35°C	
Touch:	6 hours	1 hour	50 minutes	
Handling:	12 hours	5 hours	3 hours	
Final:	180 hours	168 hours	168 hours	
Repainting Drying:	10°C	25°C	35°C	
	Min	12 hours	5 hours	3 hours
	Max	24 hours	24 hours	24 hours

SURFACE PREPARATION	<p>The performance of this product is related to the degree of surface preparation.</p> <p>The accumulated dirt must be removed using a dry brush, clean and dry cloth, compressed air blow, vacuum cleaner and/or with the combination of such items, and the soluble salts must be removed through wash with a great quantity of fresh water, preferably with low pressure (up to 5,000 psi) according to SSPC-SP 12/NACE No. 5.</p> <p>Application over primer The product can be directly applied to a specific primer in order to form a suitable coating system.</p> <p>Observe the primer overcoating interval before applying the product. If the primer overcoating time is exceeded, sand as described in the primer data sheet. In coatings made on a primer after the overcoating interval, the adhesion values according to ASTM D 4541 may present lower values than those specified by Petrobras standard N 2913.</p> <p>Maintenance and repair NOTE: Observe the product overcoating interval to apply the next coat. In case the maximum overcoating interval has been exceeded, it is necessary to manually/mechanically sand the surface to break the gloss</p>
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of the previous coat and clean the sanding residues so as to provide better adhesion between the coats.

For further information, consult WEG Technical Department.

PREPARATION FOR APPLICATION

Mixture

Homogenize the contents of each component by means of mechanical or pneumatic stirring (A and B). Ensure that no sediment is settled at the bottom of the package. Add component B to component A, at the recommended proportion (volume), under stirring, until complete homogenization, observing the mixing ratio.

Mixing ratio (Volume)

2 A X 1 B.

Diluent

Pu diluent 5001

Dilution

Depending on the application method, dilute at most 25%

The quantity of diluent may vary depending on the type of equipment used and the ambient conditions during the application.

Only add the diluent after the complete mixing of components A + B.

Do not dilute with solvents that are not allowed by local legislation and do not exceed the recommended dilution percentage.

Excessive dilution of the coating may affect the formation of the film and appearance and hinder the attainment of the specified thickness.

Pot life of the mixture (25°C)

4 h

In hot areas, we recommend consulting WEG Technical Department.

APPLICATION FORMS

The data below is a guide, and similar equipment may be used.

Changes in nozzle sizes and pressures may be necessary to improve the spraying characteristics.

Before the application, make sure the equipment and its components are clean and in the best condition.

Purge the compressed air line to prevent contamination of the coating.

After mixing the 2-pack products, if there are stops in the application, and the pot life is exceeded (the coating presents variation in its fluidity), it can no longer be diluted for further application.

Reinforce all sharp edges, cracks and weld beads with a brush to prevent premature failures in these areas.

Conventional gun:

Gun:	JGA 502/3 Devilbiss or equivalent
Fluid nozzle:	EX
Air cap:	704
Atomization pressure:	60 - 65 psi
Pressure in the tank:	10 - 20 psi
Dilution:	25%

Airless Gun:

Use Airless:	Use at least pump 60: 1
Fluid pressure:	1500 - 2500 psi
Hose:	¼" internal diameter
Nozzle:	0,013" - 0,017"
Dilution:	Max. 10%

Brush:

Only recommended for retouching small areas or stripe coat (screws, nuts, weld beads, sharp edges and retouching). Use a brush 75 to 100 mm wide for larger surfaces and 25 to 38 mm for retouching. For application with brush, application in two or more passes may be necessary to obtain a uniform layer

according to

Cleaning the equipment:

Pu diluent 5001

Do not leave the catalyzed product in contact with the equipment used in the application, because the coating will present variations in fluidity at temperatures above the specification in the pot life and will harden, making the cleaning difficult.

Clean all equipment immediately after use.

NOTE:

PERFORMANCE IN THE APPLICATION

For a good performance of the product, we recommend following the directions below:

In paintings executed on the seafront, if exposed to the action of sea air, we recommend to wash with fresh water between coats eliminating the settled impurities.

Light colors may require more than one coat for an even coverage.

Do not apply the product after the pot life has expired.

We recommend coating only if the measured surface temperature is at least 3 °C above the dew point temperature.

Minor variations in color, appearance and gloss (more noticeable in dark colors) may occur, as well as delay in curing and impairment of surface performance, when applied during periods of high air relative humidity, rainy days, low temperatures or in case the coated parts are put to dry outdoors.

The temperature of the substrate, the weather and environmental conditions during the application and during the curing of the product, and the thickness of the applied film may interfere with the product drying time.

For better application properties, the coating temperature should be between 21 - 27 °C prior to the mixing and application.

It should not be applied under adverse conditions, such as air relative humidity (RH) above 85%, as changes in color and appearance may occur.

Polyurethane systems (component A and B) present sensitivity when exposed to air relative humidity, which can cause flaws in the dry film and reduction of pot life. Therefore, we recommend that the packages of each component be properly closed after use and kept in dry places protected from bad weather.

In coatings with variation in the application method in the same job, the final appearance and gloss of the painted surfaces may present differences.

For further information, consult WEG Technical Department.

SAFETY PRECAUTIONS

Product developed for industrial use intended for handling by qualified professionals.

Please read carefully all the information contained in the MSDS of this product, available at: www.weg.net.

Store in a covered, well-ventilated area. 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.

Wear protective gloves / protective clothing / eye protection / face protection.

Avoid release of the product and its packaging, as well as materials used during handling and application in the environment.

NOTE:

The information contained in this technical datasheet is based upon the experience and knowledge acquired in the field by the technical team of WEG.

If using the product without prior inquiry to WEG Coating concerning its suitability for the customer's intended purpose, the customer is aware that the use shall be its exclusive responsibility, WEG not being responsible for the behavior, safety, suitability or durability of the product.

Certain information contained in this datasheet is merely an estimate, and can undergo variances arising from factors outside the manufacturer's control. Thus, WEG does not guarantee and does not assume any responsibility regarding the yield, performance or any other material or personal damage resulting

from the incorrect use of the products concerned or the information contained in this Technical datasheet.

The information contained in this technical datasheet is subject to periodic modification, without prior notice, due to the policy of evolution and continuous improvement of our products and services, providing solutions with quality to satisfy our customers' requirements.

