



W-THANE VARNISH ONA 50

PRODUCT DESCRIPTION

High-performance two-component aliphatic/acrylic polyurethane finish. Good chemical and continuous weathering resistance. Excellent adhesion on Metallic, Pearl, or Smooth Base Coat (with recommendation/testing, can be applied over other products). Excellent UV gloss retention, high resistance to atmospheric agents and some solvents. High hardness, impact, and abrasion performance.

RECOMMENDED USE

Excellent finish for painting surfaces that require a glossy appearance. Can be applied to panels, machinery, and equipment that prioritize resistance to natural weathering and lightfastness.

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

<b>Component A</b>	0.95 US gal Package containing 0.63 US gal 5.28 US gal Package containing 3.51 US gal
<b>Component B</b>	0.40 US gal Package containing 0.32 US gal 1.06 US gal Package containing 0.88 US gal

CHARACTERISTICS

<b>Color</b>	Colorless.
<b>Gloss</b>	Gloss
<b>VOC content</b>	6.5 (lb/gal). Note: The average of VOC on the line can vary depending on the color.
<b>Volume Solids</b>	36 ± 2% (ISO 3233)
<b>Shelf Life</b>	12 months
<b>Dry Film Thickness</b>	1.2 mils - 1.6 mils
<b>Dry Heat Resistance</b>	Maximum temperature 212 °F. The product maintains its chemical properties up to a temperature of 212 °F, but from 140°F, color and gloss variations in the paint may occur.
<b>Theoretical Coverage</b>	419.3 ft <sup>2</sup> /gal without dilution at a dry film thickness of 1.4 mils. Loss factors during application are not considered.

DRYING

<b>Drying</b>	<hr/>			
	<b>50 °F</b>	<b>77 °F</b>	<b>95 °F</b>	
	<b>Touch</b>	2 hours	30 min	20 min
	<b>Manipulation</b>	12 hours	5 hours	3 hours
<b>Final</b>	180 hours	168 hours	168 hours	
<b>Recoat Drying</b>	<hr/>			
	<b>50 °F</b>	<b>77 °F</b>	<b>95 °F</b>	
	<b>Minimum</b>	18 hours	8 hours	6 hours
	<b>Maximum</b>	96 hours	72 hours	64 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.

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: 2 A x 1 B.
<b>Thinner</b>	PU DILUENT 5003
<b>Dilution</b>	Depending on the application method, dilute to a maximum of 20%.
<b>Notes</b>	<p>Dilute according to recommendation.</p> <p>Only add the thinner after the A + B components are completely mixed.</p> <p>Excessive thinning of the paint may affect film formation, appearance, and make it difficult to achieve the specified thickness.</p> <p>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.</p> <p>In locations with higher temperature and relative humidity, the pot life of the mixture will be reduced.</p>
<b>Pot Life</b>	<p>4 h</p> <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>No induction time required.</p> <p>In very hot locations, we recommend consulting WEG's Technical Department.</p>

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**APPLICATION METHODS**

<b>Conventional Spray Gun</b>	<p>Spray gun: JGA 502/3 Devilbiss or equivalent</p> <p>Fluid nozzle: EX</p> <p>Air cap: 704</p> <p>Atomization pressure: 60 - 65 psi</p> <p>Tank pressure: 10 - 20 psi.</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>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 re-thinned for later application.</p> <p>Reinforce all sharp corners, gaps, and weld beads with a brush to avoid premature failures in these areas.</p> <p>Clean all equipment immediately after use.</p>

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**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.

We recommend painting only if the measured surface temperature is at least 5.4°F above the dew point.

Do not apply at steel temperatures below 50°F.

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.

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.

Product not recommended for internal tank painting.

**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.