



## W-THANE LXP 545

**PRODUCT DESCRIPTION:** Two-component aromatic polyurethane primer. Primer with excellent protection, drying and adhesion to carbon steel and fiber (RTM).

**RECOMMENDED USES:** Excellent primer to paint pay phones, freight carriers and bus bodies, in the fiber and carbon steel parts, providing good filling. It can be applied to nitrocellulose and polyester putty.

**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	0.76 4.23	0.95 5.28	GAL
	Component B	0.19 1.06	0.24 1.32	

<b>CHARACTERISTICS:</b>	<b>Color:</b>	Gray
	<b>Gloss:</b>	Ultra matte 0 – 15 UB
	<b>Volume solid:</b>	39 ± 1% (ISO 3233).
	<b>Flash Point:</b>	
	<b>Shelf-Life (77°F):</b>	12 months
	<b>Thickness per coat (dry):</b>	3,93 mils – 5,90 mils
	<b>Theoretical coverage:</b>	464.55 ft <sup>2</sup> /gal without dilution in the thickness of 1.38 mils dry. Without considering loss factors in application.
	<b>Resistance to dry heat:</b>	Maximum temperature . The product retains its physical and chemical properties up to the temperature of however, variations in the coating color and gloss may occur from 60 °C (140°F).

**Drying:**

	<b>77 °F</b>
<b>Touch:</b>	60 minutes
<b>Handling:</b>	2 hours
<b>Final:</b>	168 hours

**Overcoating Drying:**

	<b>77 °F</b>
Min	1 hour
Max	24 hours

**Drying sanding**

**77 °F**

Min 2 hours  
Max

## SURFACE PREPARATION

The performance of this product depends on the degree of surface preparation.

The surface must be clean and free of any contaminants. Completely remove oils, greases and fats, as described in the SSPC-SP 1 standard.

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.

### Surface treatment through Abrasive Blasting process

Inspect the newly blasted surface observing the presence of surface flaws that could become apparent after this stage, adopting appropriate actions to mitigate such defects through grinding, weld filling and/or epoxy putty.

Execute the abrasive blasting to near white metal, Sa 2 ½ grade of the ISO 8501-1 visual standard (A Sa 2 ½, B Sa 2 ½, C Sa 2 ½ and D Sa 2 ½) or according to SSPC-SP 10/NACE No. 2, SSPC-VIS 1 visual standard (A SP 10, B SP 10, C SP 10, D SP 10, G1 SP 10, G2 SP 10, G3 SP 10).

### 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 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.

### Diluent

### Pot life of the mixture (77°C)

4 h

## SAFETY PRECAUTIONS