



Product Data

Wes-Thane® Acrylic Urethane

PRODUCT DESCRIPTION

WES-THANE® Acrylic Urethane is a durable, high gloss, and chemical/solvent resistant finish. WES-THANE® can be air dried or force dried for a tough acrylic urethane enamel that is ideal for OEM, fleet, truck, and special vehicle finishing. WES-THANE® is available in solid and metallic colors.

TECHNICAL DATA

• Mixing ratio by volume	3:1	• Dielectric strength	~2000 volts/mil
• Viscosity (sprayable)		• Maximum VOC as applied	VOC Total 4.7 #/s/gal, 563 g/l
#2 Zahn Cup	18 seconds	VOC Less Exempt	5.0 #/s/gal, 599 g/l
• Flash point - PMCC	60°F	• Performance after one week air dry	
• Coverage/sprayable gal @ 1 mil (dry)	425-483 sq ft	- Impact resistance (direct)	80 in/lbs
(White)		- Flexibility (1/8" con. mandrel)	Excellent
• Recommended dry film	2.0-2.5 mils	- Solvent resistance	Excellent
thickness(2 coats)		(MEK/Xylene/Gasoline/Diesel/Oil)	
• Gloss 60°	95	- Salt spray resistance - 500 hrs	Excellent
20°	85	- Humidity resistance - 96 hrs	Excellent
• DOI	80		

SURFACE PREPARATION

Bare Substrates*: Steel, properly treated Galvanized Steel, Aluminum, or Fiberglass

**Note: With the inconsistencies of substrates, consult your local Sales Representative for system recommendations and substrate testing.*

1. Solvent clean with Grease and Wax Remover WS1018 or Low VOC Surface Cleaner WS1019 and wipe dry with a clean, dry cloth.
2. Mechanically abrade all bare metal. For hot-rolled steel, a media blast is required to remove any surface impurities.
3. Solvent clean with Grease and Wax Remove WS1018 or Low VOC Surface Cleaner WS1019 and wipe dry with a clean, dry cloth.
4. Treat bare steel/hot rolled steel areas with Metal Prep W709.
5. For maximum protection, a premium pretreatment primer is recommended. Follow with Low VOC 2k Waterborne Primer-Sealer WP230/232 or HI-GLO® Primer Sealer W711/712/713.

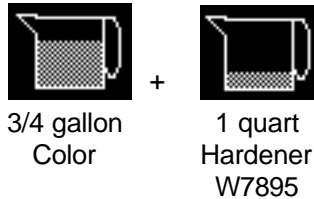
Repainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
2. Solvent clean enamel surfaces Grease and Wax Remover WS1018 or Low VOC Surface Cleaner WS1019. Wipe dry with clean cloth.
3. Grind off paint and remove all rust. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed. Body filler must be cured before coating.
4. Sand repair area and featheredge using 80, 180, 280, and finally 320 grit treated sandpaper on a random orbital sander.
5. Treat bare steel areas with Metal Prep W709.
6. Surface with E-PRIME® Acrylic Primer-Surfacer WP215 or Low VOC 2k Waterborne Primer-Surfacer WP230/234 as needed. Block sand with 180 to 280 grit treated sandpaper.
7. Finish sand repair area with 320 grit treated sandpaper on a random orbital sander.
8. Seal with HI-GLO® Primer Sealer W711/712/713.

(For the above products refer to the appropriate product label or data page for complete information.)

MIXING

1. Stir or shake WES-THANE® Color thoroughly before mixing.
2. Mix 3/4 gallon of WES-THANE® color with one quart of WES-THANE® Hardener W7895.
3. Color is pre-reduced.
4. Potlife is 6 hours.



APPLICATION

1. Adjust air pressure at the gun to **65-70** psi for siphon feed or pressure feed (adjust pot pressure to 5-10 psi).
2. Apply **2** full crosscoats at a gun distance of **8-10** inches allowing each coat to become hand slick (15-20 minutes flash) before applying the next coat. To uniform metallic colors apply a mist coat immediately by increasing the gun distance to **12-14** inches.

Note: Recommended dry film thickness is **2.0-2.5** mils.

3. If fisheyes are a problem, add 1-2 ounces of WES-THANE® Fisheye Eliminator W7897 per sprayable gallon of WES-THANE®.
4. For additional flow in hot/humid weather, add 2-4 ounces of WES-THANE® Retarder W7892 per sprayable gallon of WES-THANE®.

To maintain 5.0 VOC Compliance:

If the VOC of Wes-Thane® is:		OR	
Add up to the following amounts of W7892		Add up to the following amounts of W7897	
VOC (less exempt) of Intermix Color	VOC RTS (3 : 1 Mix)	# of ounces to RTS gallon	# of ounces to RTS gallon
4.89 or less	4.66	5	2
4.99	4.74	5	2
5.09	4.81	4.5	2
5.19	4.89	2.5	2
5.29	4.96	1	1.5
5.34	5.00	0	0

If the VOC of a color does not allow for a required additive level, OR if combinations of additives are needed, reducer must be removed from the intermix formula at the time of mixing according to the following:

For every 1 ounce of W7892 needed, remove 100 grams of Wes-Thane® Reducer from the intermix formula.

For every 1 ounce of W7897 needed, remove 55 grams of Wes-Thane® Reducer from the intermix formula.

5. Clean spray gun immediately after use with a quality lacquer thinner.

GUN RECOMMENDATIONS

Spray Gun Type	Manufacturer	Spray Gun Model	Nozzle	Orifice Size	Air cap
Siphon Feed	Binks	#7B/C Gold	66	.070"	66SK
Siphon Feed	DeVilbiss	JGA510	EX	.070"	80
Siphon Feed	Sharpe	975/971	1-975-04-70N1	.070"	1-71-02MO
Gravity Feed	SATA	SATA Jet 90	1.4 mm	.055"	Nozzle Set
HVLP	Binks	Mach I	92	.046"	97P
HVLP	DeVilbiss	OMX	1.5-1.6 mm	.059"	supplied
HVLP	SATA	Jet/B-NR95	1.5-1.7 mm	.059"/.067"	Nozzle Set
Conv. Pressure Pot	Binks	Gold #7	1.2 mm	.047	66SK
Conv. Pressure Pot	DeVilbiss	JGA Series	1.1 mm	.043	80/777
Conv. Pressure Pot	Sharpe	975/971	1.2 mm	.047	#10

DRYING SCHEDULE

Dry times are based on the recommended dry film thickness of **2.0-2.5** mils; thicker films will extend drying times.

- **Air dry times @ 70°F and 50% R.H.:**
 - Dust free 15 minutes
 - Tack free 1-1.5 hours
 - Tape free 16 hours
- **Force dry times** (With infrared/radiant heat add 3-5 ounces WES-THANE® Retarder W7892 per sprayable gallon of WES-THANE® Color.):

<u>Temperature</u>	<u>Tape free</u>
120°F	2 - 2 1/2 hours
140°F	1 - 1 1/2 hours
160°F	1 hour

RECOATING

WES-THANE® can be recoated at any time without the fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

NOTES

Decal Application: Decals may be applied after 72 hours and before one week air drying at 75°F. Lower temperatures, heavy film thickness, poor air movement, thick decals, foil-based decals, etc., will extend the 72 hour dry time before decal may be applied. Refer to your local Sales Representative for recommendations.

PRODUCT QUICK REFERENCE CHART

PRODUCT USE

WES-THANE® Acrylic Urethane Enamel

- Durable, high gloss, chemical/solvent resistant finish
- Available solid and metallic colors.
- Ideal for fleet, truck, and special vehicle refinishing

SUITABLE SUBSTRATES

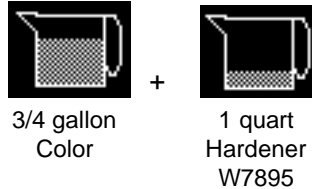
- OEM Enamels
- OEM Lacquers
- Refinish Enamels
- 2k Waterborne Primer-Surfacer
- 2k Waterborne Primer-Sealer
- E-PRIME® Acrylic Primer-Surfacer
- HI-GLO® Primer-Sealer

SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and feather edge all broken film areas.
- **Treat** bare metal with an appropriate metal conditioner or etching primer.
- **Surface** with appropriate primer-surfacer. Finish sand with 320 grit sandpaper.
- **Seal** with appropriate sealer.

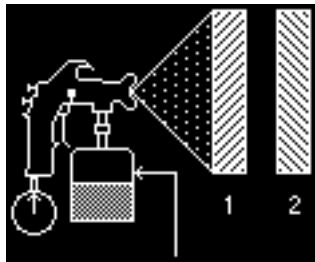
MIXING

- Stir or shake WES-THANE® color thoroughly before mixing.
- Mix 3/4 gallon of WES-THANE® color with one quart of WES-THANE® Hardener W7895.



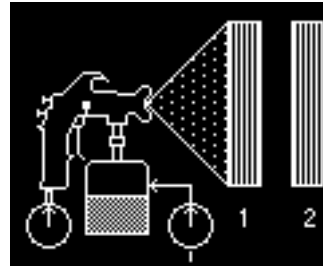
APPLICATION

Siphon feed
Apply 2 full cross-coats.
Allow each coat to become hand slick.



65-70 psi pot life: 6 hours

Pressure feed
Apply 2 full cross-coats
Allow each coat to become hand slick.



65-70 psi pot life: 6 hours
pot pressure: 5-10 psi

Time to Recoat
Anytime



RECOAT

- WES-THANE® can be recoated at any time without the fear of lifting. It can also be recoated up to 72 hours later without the need for scuffing or sanding. Older films should be scuff sanded with no-fill type sandpaper to insure good adhesion of new topcoat to old.

NOTES

- If fisheyes are a problem, add 1-2 ounces of WES-THANE® Fisheye Eliminator W7897 per sprayable gallon of WES-THANE®.
- For additional flow in hot/humid weather, add 2-4 ounces of WES-THANE® Retarder W7892 per sprayable gallon of WES-THANE®.
- Recommended dry film thickness is 2.0-2.5 mils.

PERSONAL PROTECTION

K

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a positive air respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.