

WEG Coating Catalog

# DILUTION AND CATALYSIS GUIDE

## AUTOMOTIVE REFINISHING

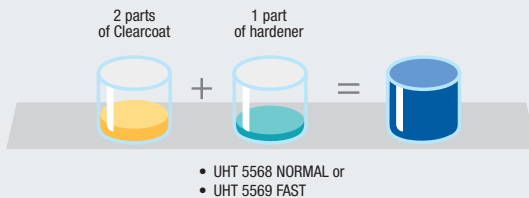


Motors | Automation | Energy | Transmission & Distribution | Coatings



**PRODUCT**
**PREPARATION / CATALYSIS / DILUTION**
**APPLICATION / DRYING**


**CLEARCOAT UHT  
W-79**



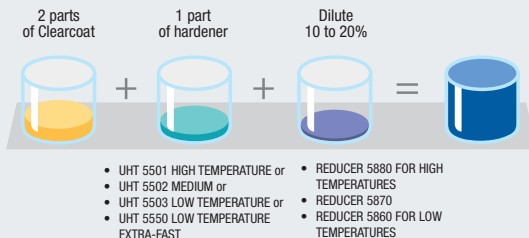
Apply 1/2 + 1 times  
with interval of 5 to  
10 minutes - 30 to 40  
microns per coat.

Touch: 10 to 20 minutes  
at 25°C.

Handling: 4 to 5 hours.  
Final: 24 hours.



**CLEARCOAT UHT  
W-50**

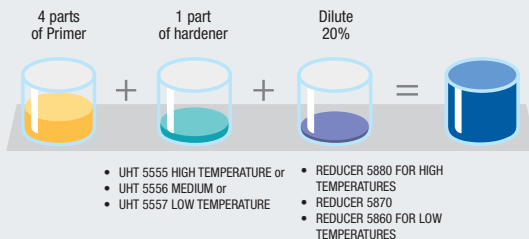


Apply 2 - 3 times.  
30 to 40 microns per  
coat per coat.

Touch: 30 minutes.  
Handling: 3-4 hours.  
Final: 24 hours.



**PRIMER UHT  
W-50**

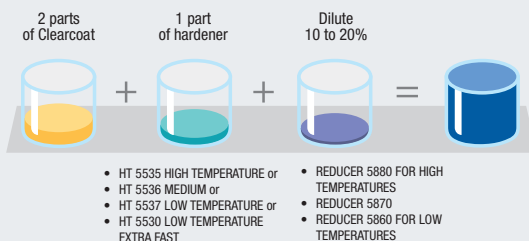


Apply 2 - 3 times.  
30 to 40 microns per coat  
per coat.

Touch: 5-10 minutes.  
Handling: 20-30 minutes.  
Final: 4 hours.



**CLEARCOAT HT  
W-30**

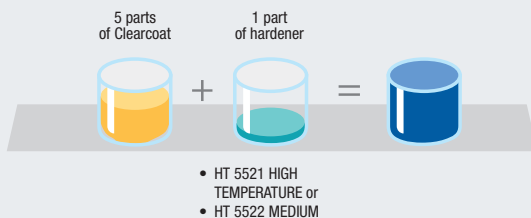


Apply 2 to 3 times.  
20 to 35 microns per coat  
per coat.

Touch: 5-10 minutes.  
Handling: 3-4 hours.  
Final: 24 hours.

**PRODUCT**
**PREPARATION / CATALYSIS / DILUTION**
**APPLICATION / DRYING**


**CLEARCOAT HT  
W-20**

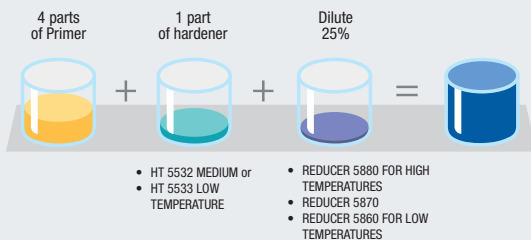


Apply 2 to 3 times.  
20 to 35 microns per coat.

Touch: 10-15 minutes.  
Handling: 3-4 hours.  
Final: 24 hours.



**PRIMER HT  
W-30 2K**

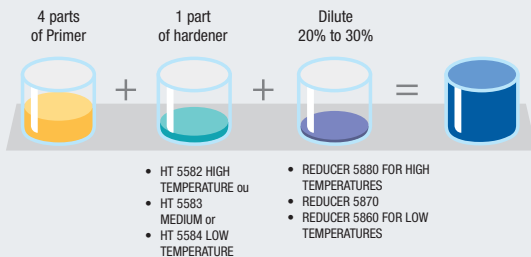


Apply 2 to 3 times.  
30 to 40 microns per coat.

Touch: 5-10 minutes.  
Handling: 20-30 minutes.  
Final: 90 minutes.



**PRIMER WET HT**

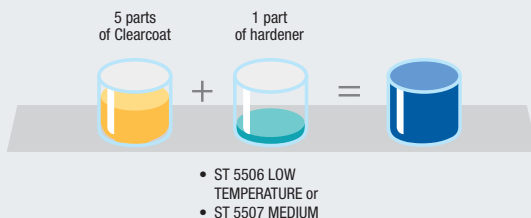


Apply 2 to 3 times.  
30 to 40 microns per coat.

Touch: 5-10 minutes.  
Handling: 1-2 hours.  
Final: 4 hours.

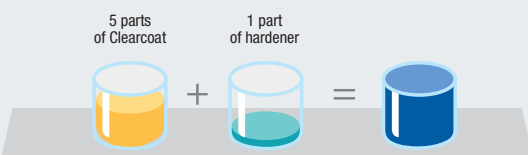
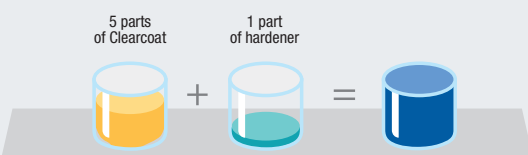
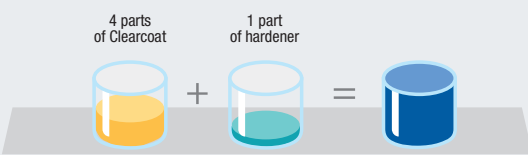
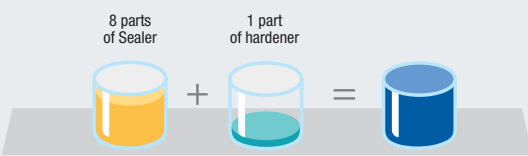


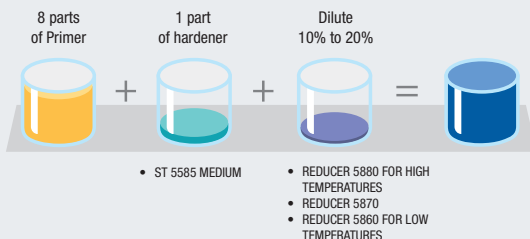
**CLEARCOAT PU ST  
3001**



Apply 2 to 3 times.  
20 to 30 microns per coat.

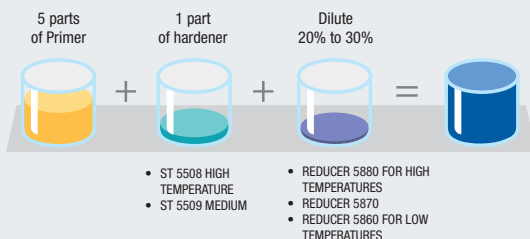
Touch: 10-15 minutes.  
Handling: 3-4 hours.  
Final: 24 hours.

| PRODUCT                                                                                                           | PREPARATION / CATALYSIS / DILUTION                                                                                                                                                                                                                                                    | APPLICATION / DRYING                                                                                                                    |
|-------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|
|  <p><b>CLEARCOAT ST W-10</b></p>  |  <p>5 parts of Clearcoat + 1 part of hardener =</p> <ul style="list-style-type: none"> <li>• ST 5510 HIGH TEMPERATURE or</li> <li>• ST 5511 MEDIUM</li> </ul>                                        | <p>Apply 2 to 3 times.<br/>20 to 30 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 3-4 hours.<br/>Final: 24 hours.</p>    |
|  <p><b>CLEARCOAT ST 2051</b></p>  |  <p>5 parts of Clearcoat + 1 part of hardener =</p> <ul style="list-style-type: none"> <li>• ST 5551 MEDIUM</li> </ul>                                                                               | <p>Apply 2 to 3 times.<br/>20 to 25 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 3-4 hours.<br/>Final: 24 hours.</p>    |
|  <p><b>CLEARCOAT ST W-41</b></p> |  <p>4 parts of Clearcoat + 1 part of hardener =</p> <ul style="list-style-type: none"> <li>• ST 5540 HIGH TEMPERATURE or</li> <li>• ST 5541 MEDIUM or</li> <li>• ST 5542 LOW TEMPERATURE</li> </ul> | <p>Apply 2 to 3 times.<br/>20 to 35 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 3-4 hours.<br/>Final: 24 hours.</p>    |
|  <p><b>SEALER ST</b></p>        |  <p>8 parts of Sealer + 1 part of hardener =</p> <ul style="list-style-type: none"> <li>• ST 5585 MEDIUM</li> </ul>                                                                                | <p>Apply 2 to 3 times.<br/>20 to 30 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 20-30 minutes.<br/>Final: 4 hours.</p> |

**PRIMER MULTI ST**

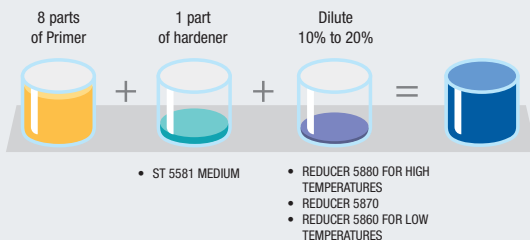
Apply 2 to 3 times.  
20 to 30 microns per coat.

Touch: 5-10 minutes.  
Handling: 1-2 hours.  
Final: 4 hours.

**PRIMER ST  
W-10**

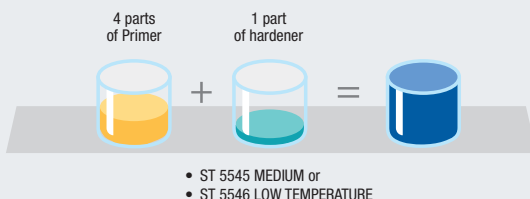
Apply 2 to 3 times.  
20 to 30 microns per coat.

Touch: 5-10 minutes.  
Handling: 1-2 hours.  
Final: 4 hours.

**PRIMER ST  
2081**

Apply 2 to 3 times.  
30 to 40 microns per coat.

Touch: 5-10 minutes.  
Handling: 20-30 minutes.  
Final: 4 hours.

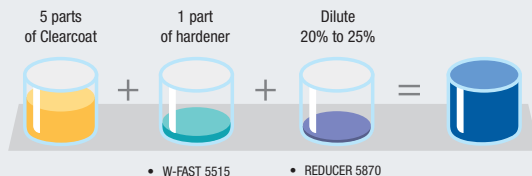
**PRIMER ST  
W-41**

Apply 2 to 3 times.  
30 to 40 microns per coat.

Touch: 10-15 minutes.  
Handling: 20-30 minutes.  
Final: 4 hours.



CLEARCOAT W-FAST

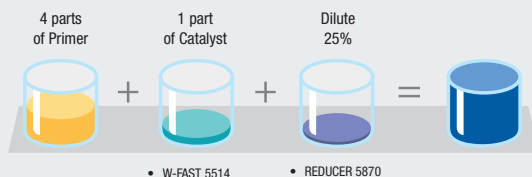


Apply 2 to 3 times.  
20 to 35 microns per coat.

Touch: 15-20 minutes.  
Handling: 30-50 minutes.  
Final: 90 minutes.



PRIMER W-FAST

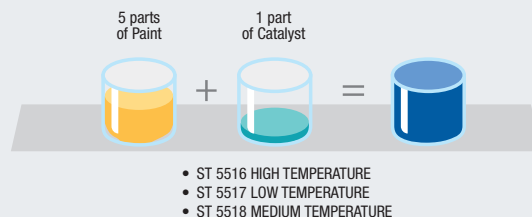


Apply 2 to 3 times.  
30 to 40 microns per coat.

Touch: 5-10 minutes.  
Handling: 20-30 minutes.  
Final: 90 minutes.

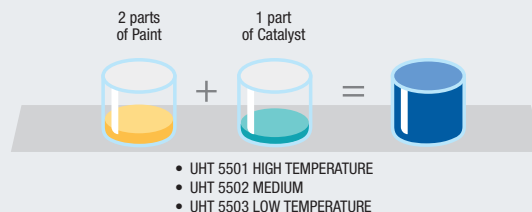
*To speed up the drying process, use the W-FAST APR in catalysis of 2:1:1.*

Final: 20-30 minutes.

W-MIX  
PU SD

Apply 2 to 3 times  
with interval of 5 to 10 minutes.

On the air:  
Touch: 15-30 minutes.  
Handling: 6 hours.  
Final: 24 hours.

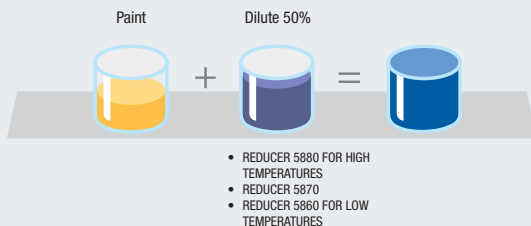
W-MIX  
PU SDP

Apply 2 to 3 times  
with interval of 5 to 10 minutes.

On the air:  
Touch: 15-30 minutes.  
Handling: 6 hours.  
Final: 24 hours.



**W-MIX  
POLYESTER**

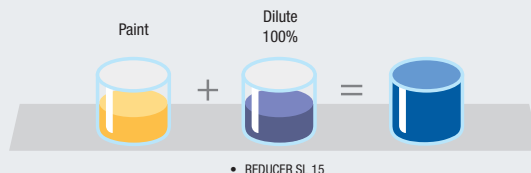


Apply 3 to 4 times  
with interval of 5 to 10  
minutes.

On the air:  
10 to 20 minutes



**W-MIX  
LACA SL**

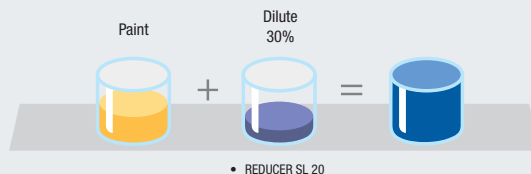


Apply 3 to 4 times  
with interval of 5 to 10  
minutes.

On the air:  
Touch: 5-10 minutes.  
Handling: 2 hours.  
Final: 12-16 hours.



**W-MIX  
SINTETIC SS**



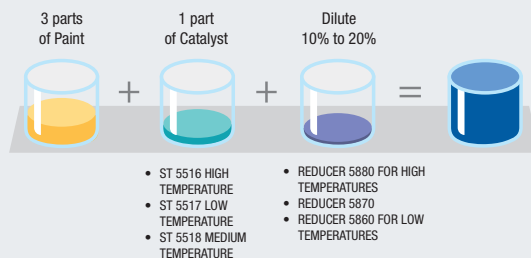
Apply 2 to 3 times  
with interval of 5 to 10  
minutes.

On the air:  
Touch: 5-10 minutes.  
Handling: 4 hours.

Painting Greenhouse:  
Flash Off: 10-15 minutes.  
Cicle: 30 minutes at 60°C.  
Final: 24 hours.



**W-CAR  
URETHANE**

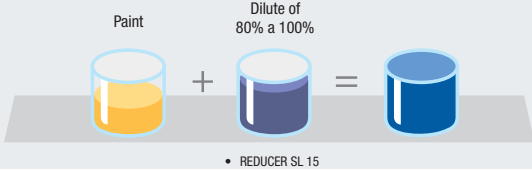
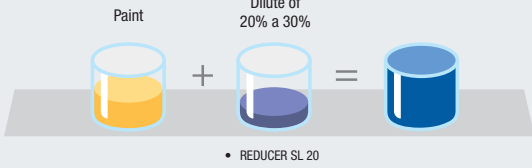
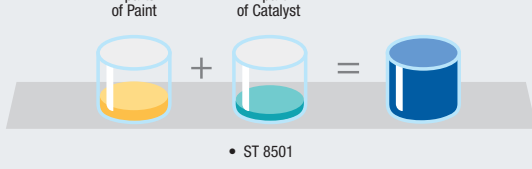


Apply 2 to 3 times  
with interval of 5 to 10  
minutes.

On the air:  
5-10 min.  
Handling: 2 hours.

Greenhouse:  
Flash Off: 10-15 minutes.  
Cicle: 30 minutes at 60°C.  
Final: 24 hours.

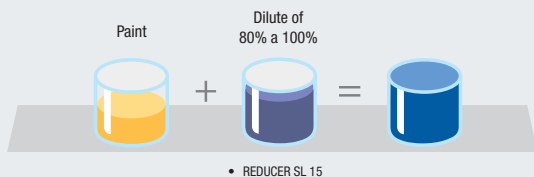


| PRODUCT                                                                                                                         | PREPARATION / CATALYSIS / DILUTION                                                                        | APPLICATION / DRYING                                                                                                                                                                                                                             |
|---------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  <p><b>W-CAR<br/>POLYESTER</b></p>              |                          | <p>Apply 3 to 5 times with interval of 5 a 10 minutes.</p> <p>On the air:<br/>10 a 20 minutes.</p>                                                                                                                                               |
|  <p><b>W-CAR NITROCELLULOSE<br/>LACQUER</b></p> |  <p>• REDUCER SL 15</p>  | <p>Apply 3 to 4 times with interval of 5 to 10 minutes.</p> <p>On the air:<br/>Touch: 5-10 minutes.<br/>Handling: 2 hours.<br/>Final: 12-16 hours.</p>                                                                                           |
|  <p><b>W-CAR<br/>SINTETIC</b></p>              |  <p>• REDUCER SL 20</p> | <p>Apply 2 to 3 times with interval of 5 to 10 minutes.</p> <p>Air drying:<br/>Touch: 10 to 15 minutes.<br/>Handling: 4 hours.<br/><i>To speed up the drying process, use the HARDENER ST 5512 in catalysis of 6:1.</i><br/>Final: 24 hours.</p> |
|  <p><b>WASH<br/>PRIMER ST</b></p>             |  <p>• ST 8501</p>      | <p>Apply 1 to 2 times of 10 a 20 microns per coat.</p> <p>Touch: 5-15 minutes.<br/>Handling: 15-20 minutes.<br/>Final: 20-30 minutes.</p>                                                                                                        |



**PRODUCT**
**PREPARATION / CATALYSIS / DILUTION**
**APPLICATION / DRYING**


**UNIVERSAL  
PRIMER ST**

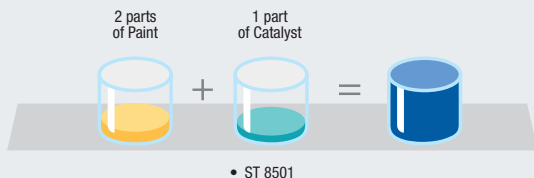


15 a 25 microns per coat

Touch: 15 minutes.  
Handling: 20-30 minutes.  
Final: 2 hours.



**BLACK MATTE  
VINYL ST**

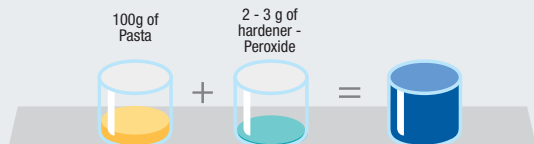


Apply 1 to 2 times  
with interval of 10 a 20  
minutes.

On the air:  
20-30 minutes to primer  
application.



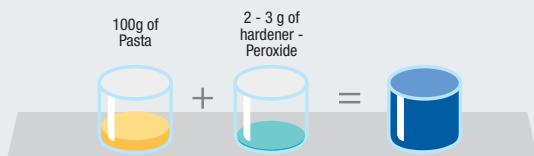
**BODY FILLER ST**



Handling: 10-15 minutes.  
Final: 20-30 minutes.

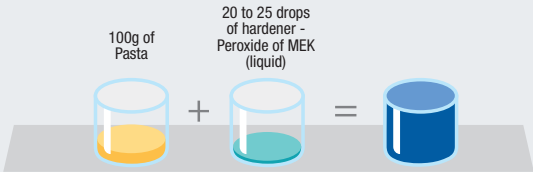
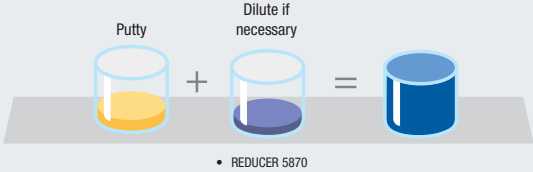


**BODY FILLER  
LIGHT ST**



Handling: 10-15 minutes.  
Final: 20-30 minutes.

| PRODUCT                                                                                                                   | PREPARATION / CATALYSIS / DILUTION                                                                                                                              | APPLICATION / DRYING                                                                                                         |
|---------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------|
|  <p><b>MASKING LIQUID ST</b></p>          | <p>Ready to use</p>                                                            | <p>On the air:<br/>20-30 minutes.</p>                                                                                        |
|  <p><b>AUTOBODY SEALER ST</b></p>         | <p>100g of Sealant + 15g of Car Sealant hardener =</p>                         | <p>Handling: 4 hours.<br/>Final: 24 hours.</p>                                                                               |
|  <p><b>PLASTIC ADHESIVE LIGHT ST</b></p> | <p>100g of Adhesive + 20 drops of hardener - Peroxide of MEK (liquid) =</p>   | <p>Apply 80 to 140 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 20-30 minutes.<br/>Final: 40-60 minutes.</p> |
|  <p><b>PLASTIC ADHESIVE ST</b></p>      | <p>100g of Adhesive + 20 drops of hardener - Peroxide of MEK (liquid) =</p>  | <p>Apply 80 to 120 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 20-30 minutes.<br/>Final: 60-80 minutes.</p> |

| PRODUCT                                                                                                                                                                                      | PREPARATION / CATALYSIS / DILUTION                                                                                                            | APPLICATION / DRYING                                                                                                                        |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------|
| <div data-bbox="79 177 230 360"></div> <div data-bbox="107 379 202 421"><b>LAMINATION<br/>ADHESIVE</b></div> | <div data-bbox="275 188 807 360"></div>                      | <p>Apply 40 to 80 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 30-45 minutes.<br/>Final: 120 minutes.</p>                   |
| <div data-bbox="79 531 230 715"></div> <div data-bbox="84 730 226 751"><b>ANTI-NOISE PUTTY</b></div>         | <div data-bbox="275 544 807 716"><p>• REDUCER 5870</p></div> | <p>Apply 1 to 3 times with 40 to 100 microns per coat.</p> <p>Touch: 40-60 minutes.<br/>Handling: 120-140 minutes.<br/>Final: 24 hours.</p> |
| <div data-bbox="79 882 230 1066"></div> <div data-bbox="96 1082 213 1102"><b>FAST PUTTY ST</b></div>        | <div data-bbox="275 927 807 1046"></div>                    | <p>Apply 30 to 60 microns per coat.</p> <p>Touch: 10-15 minutes.<br/>Handling: 20-30 minutes.<br/>Final: 40-60 minutes.</p>                 |

For WEG's worldwide  
operations visit our website



[www.weg.net](http://www.weg.net)

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Cod: 50051415 | Rev: 04 | Date (m/y): 10/2020

The values are subject to change without prior notice.  
The information contained is reference values.