Fluoronar® SERIES 1070

Product Data Sheet

Product Profile

Generic Description: Advanced Thermoset Solution Fluoropolymer

Common Usage: A high-solids fluoropolymer coating that provides an ultra-durable finish with user-friendly brush, roll, and conventional spray application. It has outstanding color and gloss retention even in the most severe exposures. Under certain conditions, it may be used to restore aged fluoropolymer coil applied coatings or for OEM applications. Contact Tnemec Technical Services or your local Tnemec representative for details.

Colors: Refer to Tnemec Color Guide. Note: Certain colors may require multiple coats depending on method of application and finish coat color. The preceding coat should be in the same color family, but noticeably different. Upon selection of the finish coat color (Series 1070), the intermediate coat color will be selected by Tnemec's color lab.

Finish: Gloss

Special Qualifications: Series 1070 meets the exterior weathering requirements of AAMA 2604-98.

Performance Criteria: Contact your Tnemec representative for specific test results.

Coating System


Intermediate: Series 75, 750, 1075, 1075U. (Intermediate coat may be required for some applications, please contact Tnemec.) Note: When topcoating with Series 1070, the following maximum recoat times apply: Over 27, 66, L69, L69F, N69, N69F, V69, V69F, 135 or 161, 14 days; over itself, 30 days; over 750, 45 days; over 75, 90-97, H90-97, 91-H2O, 94-H2O, 1075 and 1075U, 90 days.

Surface Preparation


All Surfaces: Must be clean, dry and free of oil, grease and other contaminants.

Technical Data

Volume Solids: 60.0 ± 2.0% (mixed) †

Recommended DFT: 2.0 to 3.0 mils (50 to 75 microns) per coat. Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

Curing Time

Temperature | To Touch | To Handle | Minimum Recoat ‡
---|---|---|---
90°F (32°C) | 10 minutes | 4 hours | 5-8 hours
70°F (21°C) | 30 minutes | 6-8 hours | 10-12 hours
50°F (10°C) | 1 hour | 12-15 hours | 16-24 hours

† Maximum recoat: 50 days. Curing time varies with surface temperature, air movement, humidity and film thickness. Note: For faster curing and low-temperature applications, add No. 44-710 Urethane Accelerator; see separate product data sheet.

Volatile Organic Compounds: Unthinned: 2.93 lbs/gallon (351 grams/litre) Thinned 5% (No. 63 Thinner): 3.10 lbs/gallon (371 grams/litre) † Unthinned: 4.1 lbs/gal solids

Theoretical Coverage: 962 mil sq ft/gal (23.6 m²/L at 25 microns). †

Number of Components: Two: Part A and Part B

Mixing Ratio: By volume: Five (Part A) to one (Part B)

Packaging

Medium Kit: 5 gallon pail partially filled

Small Kit: 1 gallon can partially filled

Yield (mixed): 3 gallons (11.35L)

Net Weight Per Gallon: 11.49 ± 0.25 lbs (5.21 ± .11 kg) (mixed) †

Storage Temperature: Minimum 20°F (-7°C) Maximum 110°F (43°C)

Temperature Resistance: (Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

Shelf Life: 12 months at recommended storage temperature.

Flash Point - Seta: Part A: 81°F (27°C) Part B: 130°F (54°C)

Health & Safety: Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product. Keep out of the reach of children.

Published technical data and instructions are subject to change without notice. The online catalog at www.tnemec.com should be referenced for the most current technical data and instructions or you may contact your Tnemec representative for current technical data and instructions.
APPLICATION

COVERAGE RATES

<table>
<thead>
<tr>
<th></th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested</td>
<td>2.5 (65)</td>
<td>4.0 (100)</td>
<td>585 (35.8)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>481 (44.7)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>5.0 (125)</td>
<td>321 (29.8)</td>
</tr>
</tbody>
</table>

Allow for overspray and surface irregularities. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.†

MIXING

Stir contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Keep unused material tightly closed at all times.

THINNING

For air spray, thin up to 5% or 1/4 pint (190 mL) per gallon with No. 63 Thinner. For roller, thin 5% to 8% per gallon with No. 63 Thinner. Thinning is required for proper application. Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.

POT LIFE

5 hours at 50°F (10°C) 2 hours at 70°F (21°C) 1 hour at 90°F (32°C)

APPLICATION EQUIPMENT

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Marl Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>704 or 765</td>
<td>5/16&quot; or 3/8&quot;, (7.9 or 9.5 mm)</td>
<td>3/8&quot; or 1/2&quot;, (9.5 or 12.7 mm)</td>
<td>75-90 psi (5.2-6.2 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
</tr>
</tbody>
</table>

Low temperatures or longer hoses require higher pot pressure. Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Use 1/4" or 3/8" (6.4 mm or 9.5 mm) synthetic woven nap cover. Do not use medium or long nap roller covers.

Brush: Use high quality natural or synthetic bristle brushes.

Contact Tnemec Company for information on electrostatic application.

Contact Tnemec Company for information on electrostatic application.

SURFACE TEMPERATURE

<table>
<thead>
<tr>
<th>Surface Temperature</th>
<th>Cure Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>40°F (4°C)</td>
<td>44 hours</td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>21 1/2 hours</td>
</tr>
<tr>
<td>60°F (16°C)</td>
<td>11 hours</td>
</tr>
<tr>
<td>70°F (21°C)</td>
<td>7 hours</td>
</tr>
<tr>
<td>80°F (27°C)</td>
<td>5 hours</td>
</tr>
<tr>
<td>90°F (32°C)</td>
<td>3 1/2 hours</td>
</tr>
<tr>
<td>100°F (38°C)</td>
<td>2 hours</td>
</tr>
</tbody>
</table>

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty-appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.