PRODUCT PROFILE

GENERIC DESCRIPTION
Advanced Thermoset Solution Fluoropolymer

COMMON USAGE
A low VOC, 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, the intermediate coat color may be selected by Tnemec Company.

FINISH
Semi-Gloss

PERFORMANCE CRITERIA
Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS

INTERMEDIATE
Series 73, 750, 1075, 1075U, 1095 (Intermediate coat may be required for some applications, please contact your Tnemec coating consultant.)

Note: When topcoating with Series 1071V, the following maximum recoat times apply: Over 27, 66, L69, L69F, N69, N69F, V69, V69F, 135, 161, 14 days, over itself and 90-75, 30 days; over 750, 1075, 1075U, 1095, 45 days; over 1, 394, 60 days; over 27WB, 73, 90-97, H90-97, 91-H2O, 94-H2O, 1224, 90 days.

SURFACE PREPARATION

EXTERIOR EXPOSURE
See primer product data sheet for surface preparation recommendation.

ALL SURFACES
Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS
61.0 ± 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

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>Minimum Recoat ‡</th>
</tr>
</thead>
<tbody>
<tr>
<td>90°F (32°C)</td>
<td>30 minutes</td>
<td>4-6 hours</td>
<td>6-8 hours</td>
</tr>
<tr>
<td>70°F (21°C)</td>
<td>30 minutes</td>
<td>6-8 hours</td>
<td>10-12 hours</td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>1 hour</td>
<td>12-15 hours</td>
<td>16-24 hours</td>
</tr>
</tbody>
</table>

† 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: 1.05 lbs/gallon (125 grams/litre)
Thinned 10% (No. 65 Thinner): 0.51 lbs/gallon (61 grams/litre) (TBAc Exempt)
Thinned 10% (No. 63 Thinner): 0.71 lbs/gallon (205 grams/litre) (TBAc Exempt)†

HAPS
Unthinned: 0.01 lbs/gal solids
Thinned 10% (No. 65 Thinner): 0.01 lbs/gal solids
Thinned 10% (No. 63 Thinner): 0.007 lbs/gal solids †

THEORETICAL COVERAGE
878 mil sq ft/gal (24.0 m²/L at 25 microns) †

NUMBER OF COMPONENTS
Two: Part A and Part B

By volume: Eight (Part A) to one (Part B)

MIXING RATIO

<table>
<thead>
<tr>
<th>Packaging</th>
<th>PART A (partially filled)</th>
<th>PART B (partially filled)</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Medium Kit</td>
<td>5 gallon pail</td>
<td>1/2 gallon can</td>
<td>3 gallons (11.35L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 pint can</td>
<td>1 gallon (3.79L)</td>
</tr>
</tbody>
</table>

NET WEIGHT PER GALLON
13.31 ± 0.25 lbs (6.03 ± 0.11 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: 86°F (28°C) Part B: >200°F (93°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.

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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 (101)</td>
<td>385 (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 (127)</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**

Thinning is required for proper application. For brush, roller, and air spray, thin up to 10% (82 mL) per gallon with No. 63 Thinner. Note: In areas that require lower VOC, use No. 65 Thinner. Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.

**POT LIFE**

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

**APPLICATION EQUIPMENT**

**Air Spray**

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Mat'l Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>765 or 704</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>70-90 psi (4.9-6.2 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/atomizer pressure for equipment, applicator technique and weather conditions.

**Brush:** Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

**Surface Temperature**

Minimum 40°F (4°C)  Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

Cure time necessary to resist direct contact with moisture at surface temperature:

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