



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. 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 1072), the intermediate coat color may be selected by Tnemec Company.

**FINISH** Satin

**PERFORMANCE CRITERIA** Contact your Tnemec representative for specific test results.

COATING SYSTEM

**PRIMERS** Series 1, 27, 27WB, 66, L69, L69F, N69, N69F, V69, V69F, 90-97, H90-97, 91-H<sub>2</sub>O, 94-H<sub>2</sub>O, 118, 135, 161, 394, 1224. **Note:** Series 1 and 394 require an intermediate coat prior to topcoating with Series 1072. **Note:** Series 118 is typically used to overcoat, sound, existing coating systems. See product data sheet for more information.

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

**Note:** When topcoating with Series 1072, 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, 1075, 1075U, 1095, 45 days; over 1 and 394, 60 days; over 73, 90-97, 91-H<sub>2</sub>O, 94-H<sub>2</sub>O and 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** 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)	30 minutes	4-6 hours	6-8 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: 30 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** EPA Method 24 †  
**Unthinned:** 2.64 lbs/gallon (316 grams/litre)  
**Thinned 5% (No. 63 Thinner):** 2.81 lbs/gallon (337 grams/litre)

**HAPS** **Unthinned:** 3.89 lbs/gal solids  
**Unthinned 5% (No. 63 Thinner):** 3.88 lbs/gal solids

**THEORETICAL COVERAGE** 962 mil sq ft/gal (23.6 m<sup>2</sup>/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

	PART A	PART B	Yield (mixed)
Medium Kit	5 gallon pail partially filled	1/2 gallon can	3 gallons (11.35L)
Small Kit	1 gallon can partially filled	1 quart can partially filled	1 gallon (3.79L)

**NET WEIGHT PER GALLON** 11.69 ± 0.25 lbs (5.30 ± .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.**

# FLUORONAR® | SERIES 1072

**APPLICATION**

**COVERAGE RATES**

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Suggested	2.5 (65)	4.0 (100)	385 (35.8)
Minimum	2.0 (50)	3.5 (90)	481 (44.7)
Maximum	3.0 (75)	5.0 (125)	321 (29.8)

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 air spray, thin up to 5% or 1/4 pint (190 mL) per gallon with No. 63 Thinner. For roller, thin 3% to 5% or 1/4 pint (190 mL) per gallon with No. 63 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**

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-90 psi (5.2-6.2 bar)	10-20 psi (0.7-1.4 bar)

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.

**SURFACE TEMPERATURE**

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

Temperature	To Resist Moisture
100°F (38°C)	2 hours
90°F (32°C)	3 1/2 hours
80°F (27°C)	5 hours
70°F (21°C)	7 hours
60°F (16°C)	11 hours
50°F (10°C)	21 1/2 hours
40°F (4°C)	44 hours

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.

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