PRODUCT PROFILE

GENERIC DESCRIPTION
Aliphatic Acrylic Polyurethane

COMMON USAGE
An acrylic polyurethane finish coat that contains a sparkle aluminum pigment creating a metallic aesthetic finish. It is a highly durable coating that is resistant to abrasion, wet conditions and exterior weathering. This high performance finish contains UV absorbers for extended color and gloss retention. NOT FOR IMMERSION SERVICE.

COLORS
Available in 42 standard colors. Refer to Tnemec Metallic Color Guide. Certain colors may require a clear topcoat for optimum performance. Note: Variations in appearance between product samples, color cards, color sheets and actual field applications should be expected due to differences in environmental conditions, color of underlying coats, gloss level, orientation of metallic pigment, and applicator technique. Reference Technical Bulletin No. 07-65 for more information.

FINISH
Semi-gloss

SPECIAL QUALIFICATIONS
Standard Series 1077 colors will meet the requirements of the Metallic Pigmented coatings category for use in air districts with restrictive VOC regulations.

COATING SYSTEM

PRIMERS
Galvanized Steel and Non-Ferrous Metal: Series 27, 66, L69, N69, V69, 1224. Note: For special galvanized surface preparation instructions, consult the latest version of Tnemec Technical Bulletin 10-78.
Note: Series V530 exterior exposed more than 24 hours, Series 161, N69F, L69F, V69F exterior exposed more than 30 days, Series 104 or 135 exterior exposed more than 60 days, or Series L69, N69, V69, L140, N140 or V140 exterior exposed more than 90 days must first be scarified or reprimed with themselves. Brush blasting with fine abrasive is the preferred method of scarification.

TOPCOATS
Series 1079, optional when extended weatherability is desired or as directed by Tnemec Company.

SURFACE PREPARATION

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

TECHNICAL DATA

VOLUME SOLIDS
56.0 ± 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. For applications over zinc or MIO-zinc, reference Technical Bulletin 10-100.

CURING TIME

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>1 hour</td>
<td>5.8 hours</td>
<td>12 hours</td>
</tr>
</tbody>
</table>

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS
Unthinned: 3.34 lbs/gallon (400 grams/litre)
Thinned 14% (No. 42 Thinner): 3.75 lbs/gallon (449 grams/litre)†
Thinned 15% (No. 39 Thinner): 3.72 lbs/gallon (445 grams/litre)†

HAPS
1.42 lbs/gal solids

THEORETICAL COVERAGE
908 mil sq ft/gal (22.0 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

<table>
<thead>
<tr>
<th>PART A</th>
<th>PART B</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>6 gallon pail partially filled</td>
<td>1 gallon can</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can partially filled</td>
<td>1 quart can partially filled</td>
</tr>
</tbody>
</table>

NET WEIGHT PER GALLON
9.05 ± 0.25 lbs (4.04 ± 0.11 kg)†

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: 55°F (13°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.
**APPLICATION**

<table>
<thead>
<tr>
<th>COVERAGE RATES</th>
<th>Dry Mil (Microns)</th>
<th>Wet Mil (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Suggested</strong></td>
<td>2.5 (65)</td>
<td>4.5 (115)</td>
<td>359 (33.4)</td>
</tr>
<tr>
<td><strong>Minimum</strong></td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>449 (41.7)</td>
</tr>
<tr>
<td><strong>Maximum</strong></td>
<td>3.0 (75)</td>
<td>5.5 (140)</td>
<td>299 (27.8)</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 14% or 18 ounces (530 mL) per gallon by volume with No. 42 Thinner if temperatures are below 80°F (27°C), use No. 39 Thinner for temperatures above 80°F (27°C). Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.

**POT LIFE**

8 hours at 40°F (4°C)  4 hours at 77°F (25°C)  2 hours at 100°F (38°C)

**APPLICATION EQUIPMENT**

<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>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>85-90 psi (5.7-6.2 bar)</td>
<td>12-15 psi (0.8-1.0 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. Note: Brush and roller application is not recommended as it could adversely affect the appearance.

**SURFACE TEMPERATURE**

Minimum 35°F (2°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:

| 40°F (4°C): 24 to 40 hours | 50°F (10°C): 18 to 26 hours | 60°F (16°C): 12 to 16 hours |
| 70°F (21°C): 4 to 8 hours | 90°F (32°C): 2 to 4 hours | 100°F (38°C): 2 to 3 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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