**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Advanced Thermoset Solution Fluoropolymer

**COMMON USAGE**
A high-solids fluoropolymer coating that provides an ultra-durable metallic or pearlescent finish with user friendly 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**
Available in 42 standard colors. Refer to Tnemec Metallic Color Guide. Custom colors also available. 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 underlaying coats, gloss level, orientation of metallic pigment, equipment and applicator technique. Reference Technical bulletin No. 07-65 for more information.

**FINISH**
Semi-gloss. Other gloss levels may be available, contact Tnemec.

**SPECIAL QUALIFICATIONS**
Standard Series 1078 colors will meet the requirements of the Metallic Pigmented coatings category for use in air districts with more restrictive VOC regulations. Contact your Tnemec representative for specific test results.

**PERFORMANCE CRITERIA**

**THEORETICAL COVERAGE**
9.66 ± 0.25 lbs (4.38 ± .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 - SETHA**
Part A: 85°F (29°C)     Part B: 130°F (54°C)

**HEALTH & SAFETY**

**NET WEIGHT PER GALLON**
9.66 ± 0.25 lbs (4.38 ± .11 kg) (mixed) †

**PRODUCT DATA SHEET**

**SERIES 1078**

**PRIMERS**
Steel: Series 1, 20, 27, 66, L69, N69, 84, 90-97, 91-H, 0, 104, 135, L140, N140, 161, 394, 530
Galvanized Steel and Non-Porous Metal: Series 27, 66, L69, N69, 161

**INTERMEDIATE**
Series 75, 1075 (Intermediate coat may be required for some applications, please contact Tnemec.) Note: If an intermediate coat is required, it should be in the same color family but noticeably different than the topcoat color. Tnemec will specify the intermediate color.

**TOPCOATS**
Series 1079-0762 (semi-gloss), 1079-0763 (satin)

**AGED COATINGS**
Adhesion test patches are required. Contact Tnemec Technical Services or your Tnemec representative for recommendations.

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

**TECHNICAL DATA**

**VOLUME SOLIDS**
54.0 ± 2.0% (mixed) †

**RECOMMENDED DFT**
2.0 to 3.0 mils (50 to 75 microns) per coat.

<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>10 minutes</td>
<td>4 hours</td>
<td>5-8 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.

‡ Maximum recoat: 30 days. Curing time varies with surface temperature, air movement, humidity and film thickness.

**THEORETICAL COVERAGE**
866 ml sq ft/gal (21.3 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)

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

**SHIELD LIFE**
Part A: 85°F (29°C)     Part B: 130°F (54°C)

**FLASH POINT - SETHA**
Part A: 85°F (29°C)     Part B: 130°F (54°C)

**PACKAGING**

<table>
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<td>Medium Kit</td>
<td>5 gallon pail</td>
<td>3 gallons (11.35L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 gallon (3.79L)</td>
</tr>
</tbody>
</table>

**CONTACT INFORMATION**
Published technical data and instructions are subject to change without notice. For the most current technical data and instructions or you may contact your Tnemec representative for current technical data and instructions.
**APPLICATION**

<table>
<thead>
<tr>
<th>COVERAGE RATES</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>4.5 (115)</td>
<td>346 (32.2)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>433 (40.2)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>5.5 (140)</td>
<td>289 (26.8)</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 5% to 15% 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>Air Spray</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gun</td>
</tr>
<tr>
<td>DeVilbiss JGA</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.

Note: The finished appearance of 1078 can be affected by applicator technique, equipment and environmental conditions. A jobsite mock-up is recommended prior to full-scale application. Reference Technical Bulletin No. 07-65 for more information.

**SURFACE TEMPERATURE**

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

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

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

- 60°F (16°C): 11 hours
- 70°F (21°C): 7 hours
- 80°F (27°C): 5 hours
- 90°F (32°C): 3 3/4 hours
- 100°F (38°C): 2 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.