**VOLATILE ORGANIC COMPOUNDS**

**TECHNICAL DATA**

- **Volume Solids**: 58.0 ± 2.0% (mixed) †
- **Recommended DFT**: 2.0 to 3.0 mls (50 to 75 microns) per coat. **Note**: Number of coats and thickness requirements will vary with substrate, application method and exposure. **Caution**: Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating aesthetics and performance. Excessive film thicknesses will cause microbubbling. Contact your Tnemec representative.
- **Curing Time**
  - **Temperature**: 75°F (24°C)
  - **To Touch**: 45 minutes
  - **To Handle**: 6 hours
  - **To Recoat**: 6 hours
  - Curing time varies with surface temperature, air movement, humidity and film thickness.
- **Volatile Organic Compounds**
  - **Unthinned**: 0.8 lb/gal (97 grams/litre)
  - **Thinned 5% (Water)**: 0.8 lb/gal (97 grams/litre) †
  - **Thinned 5% (No. 66 Thinner)**: 1.31 lb/gal (158 grams/litre) †
- **HAPS**
  - **Unthinned**: 0 lb/gal solids
  - **Thinned 5% (Water)**: 0 lb/gal solids
  - **Thinned 5% (No. 66 Thinner)**: 0 lb/gal solids
- **Theoretical Coverage**: 930 mil sq ft/gal (24.4 m²/L at 25 microns). See APPLICATION for coverage rates. †
- **Number of Components**: Two: Part A and Part B
- **Mixing Ratio**: By volume: Four (Part A) to one (Part B)
- **Net Weight per Gallon**: 10.98 ± 0.25 lbs (4.98 ± 1.1 kg) †
- **Storage Temperature**
  - Minimum 40°F (4°C)
  - Maximum 110°F (43°C)
  - Protect from freezing.
- **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: 108°F (42°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

#### 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>4.5 (115)</td>
<td>572 (34.6)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>465 (43.2)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>5.0 (125)</td>
<td>310 (28.8)</td>
</tr>
</tbody>
</table>

**Note:** Coverage rates based on unthinned material. 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 aesthetics and performance. †

### MIXING

Stir contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the container marked Part B to Part A while under mechanical agitation. Continue agitation until the two components are thoroughly mixed. Continue mechanical agitation and thin according to the thinning instructions. 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. Do not reseal mixed material. An explosion hazard may be created. Unused mixed material should be thinned with equal amounts of water by volume and disposed of properly. **Important:** Thin with mechanical agitation only after Part B has been thoroughly mixed with Part A according to mixing instructions.

### THINKING

Thinning is required for proper application. Thin up to 15% by volume with clean water. For warm temperature applications, product can be thinned with a combination of 5% No. 66 Thinner and 10% water. **Important:** Thin with mechanical agitation only after Part B has been thoroughly mixed with Part A according to mixing instructions.

### POT LIFE

2 hours at 77°F (25°C)

### APPLICATION EQUIPMENT

<table>
<thead>
<tr>
<th></th>
<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>50-80 psi (3.4-5.5 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
<td></td>
</tr>
</tbody>
</table>

Low temperatures or longer hoses require higher pot pressure.

#### Airless Spray

<table>
<thead>
<tr>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.013&quot;-0.017&quot;&lt;sup&gt;**&lt;/sup&gt; (380-430 microns)</td>
<td>3000-4000 psi</td>
<td>1/4&quot; or 3/8&quot; (6.4 or 9.5 mm)</td>
<td>80 mesh (250 microns)</td>
</tr>
</tbody>
</table>

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions. **Roller:** Use 1/4" (preferred) or 3/8" (6.4 mm to 9.5 mm) synthetic woven nap roller cover. Do not use medium or long nap roller covers. Two coats are required to obtain dry film thickness above 3.0 mils (75 microns). **Brush:** Recommended for small areas only. Use high quality natural or synthetic bristle brushes. Two coats are required to obtain recommended film thickness.

### APPLICATION CONDITIONS

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. **Caution:** Protect from high humidity, dew and direct moisture contact during application and curing. Application and/or curing in humidities above maximum, or exposure to moisture from rain or dew may result in a loss of gloss and/or microbubbling of the product.

Flush and clean all equipment immediately after use with water and flush with xylene.

† Values may vary with color.

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