Aliphatic Acrylic Polyurethane

A user friendly, low VOC, aliphatic polyurethane coating that provides excellent color and gloss retention for exterior applications to steel, concrete and other miscellaneous substrates.

**Colors**
Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. When feasible, the preceding coat should be in the same color family, but noticeably different.

Semi-gloss

**Primer**
- **Steel:** Series 1, 20HS, FC20HS, 27WB, 66, 66HS, L69, L69F, N69, N69F, 90-97, 90G-1K97, 91-H, L140, L140F, N140, N140F, V140, V140F, 161, 161HS, 394, 1224
- **Galvanized Steel & Non-Ferrous Metal:** 66, 66HS, L69, L69F, N69, N69F, 161, 161HS
- **Concrete:** Series 27WB, 66, 66HS, L69, L69F, N69, N69F, L140, L140F, N140, N140F, V140, V140F, 161, 161HS, 394, 1254
- **CMU:** Series 1254

**Surface Preparation**
- All Surfaces: Must be clean, dry and free of oil, grease, chalk and other contaminants.

**Technical Data**
- **Volume Solids:** 66.0 ± 2.0% (mixed) 
- **Recommended DFT:** 2.0 to 5.0 mils (51 to 127 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure.

<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>1-2 hours</td>
<td>9 hours</td>
<td>10-12 hours</td>
</tr>
</tbody>
</table>

To resist moisture: 8 hours. Curing time varies with surface temperature, air movement, humidity and film thickness.

**Volatile Organic Compounds**
- **Unthinned:** 1.95 lbs/gallon (232 grams/litre)
- **Thinned 15% (No. 10 Thinner):** 2.79 lbs/gallon (355 grams/litre)
- **Thinned 15% (No. 46 Thinner):** 1.96 lbs/gallon (254 grams/litre) (TBAc exempt)
- **Thinned 5% (No. 46 Thinner):** 1.99 lbs/gallon (258 grams/litre)

**HAPS**
- **Unthinned:** 0.00 lbs/gallon solids
- **Thinned 15% (No. 10 Thinner):** 0.04 lbs/gallon solids
- **Thinned 15% (No. 46 Thinner):** 0.09 lbs/gallon solids

**Theoretical Coverage**
1,059 mil sq ft/gal (26.0 m²/L at 25 microns). See APPLICATION for coverage rates. **Note:**

**Number of Components**
Two: Part A and Part B

**Mixing Ratio**
By volume: Four (Part A) to one (Part B)

<table>
<thead>
<tr>
<th></th>
<th>PART A (Partially filled)</th>
<th>PART B (Partially filled)</th>
<th>Yield (Mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>6 gallon pail</td>
<td>1 gallon can</td>
<td>5 gallons (18.9L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 quart can</td>
<td>1 gallon (3.79L)</td>
</tr>
</tbody>
</table>

**Health & Safety**

Paint products contain chemical ingredients which are considered hazardous. Read container label warning and 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

**Conventional Build (Spray, Brush or Roller)**

<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 (100)</td>
<td>423 (39.3)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.0 (75)</td>
<td>529 (49.2)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>4.5 (115)</td>
<td>353 (32.8)</td>
</tr>
</tbody>
</table>

**Hi-Build (Spray Only)**

<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>4.0 (100)</td>
<td>6.0 (150)</td>
<td>265 (24.6)</td>
</tr>
<tr>
<td>Minimum</td>
<td>3.0 (75)</td>
<td>4.5 (115)</td>
<td>353 (32.7)</td>
</tr>
<tr>
<td>Maximum</td>
<td>5.0 (125)</td>
<td>7.5 (190)</td>
<td>212 (19.7)</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. †

### 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. 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.

### THINNING

Thinning is required for proper application. Use No. 10 Thinner. For air spray, airless spray, brush or roller, thin up to 15% or 19 ounces (562 mL) per gallon. **Note:** In areas that require lower VOC, use No. 46 Thinner.

### POT LIFE

4 hours at 75°F (24°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” or 3/8” (7.9 or 9.5 mm)</td>
<td>3/8” or 1/2” (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>
</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>0.015”-0.017” (550-430 microns)</td>
<td>3000-5500 psi</td>
<td>1/4” or 3/8” (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

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) high quality 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.

### 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 a surface temperature of 75°F (24°C) is 8 hours.

### CLEANUP

Flush and clean all equipment immediately after use with xylene or MEK. Use Tnemec No. 74 Thinner when needed to comply with VOC regulations.

† Values may vary with color.