**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Aliphatic Acrylic Polyurethane

**COMMON USAGE**
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. Can be applied by brush, roller or spray.

**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.

**FINISH**
Eggshell

**COATING SYSTEM**

**PRIMERS**
- **Galvanized Steel & Non-Ferrous Metal:** Series 27, 66, L69, L69F, N69, N69F, V69, V69F, 161
- **Concrete:** Series 27WB, 66, L69, L69F, N69, N69F, V69, V69F, L140, L140F, N140, N140F, V140, V140F, 161, 1220, 1224, 1254
- **CMU:** Series 1254
  **Note:** The following maximum recoat times apply; Series L69 or L140F, 14 days; Series L69 or L140, 21 days; Series 1, 27, 27WB, 66, N69, N69F, V69, V69F, 118, 135, N140, N140F, V140, V140F, 161, 394, 1220, 1224, 1254, 30 days; Series 90-97, 90G-1K97, 91-H2O, 94-H2O, 60 days. Contact your Tnemec representative for specific recommendations.

**SURFACE PREPARATION**

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

**TECHNICAL DATA**

**VOLUME SOLIDS**
61.0 ± 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.

**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>1-2 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: 2.15 lbs/gallon (257 grams/litre)
- Thinned 15% (No. 10 Thinner): 0.72 lbs/gallon (86 grams/litre) (TBAc exempt)
- Thinned 15% (No. 10 Thinner): 2.98 lbs/gallon (357 grams/litre) (TBAc exempt)
- Thinned 15% (No. 46 Thinner): 1.99 lbs/gallon (259 grams/litre) (TBAc exempt)
- Thinned 15% (No. 46 Thinner): 2.20 lbs/gallon (263 grams/litre)
- Thinned 15% (No. 46 Thinner): 0.80 lbs/gallon (96 grams/litre) (TBAc exempt)

**HAPS**

- Unthinned: 0.01 lbs/gal solids
- Thinned 15% (No. 10 Thinner): 0.04 lbs/gal solids
- Thinned 15% (No. 46 Thinner): 0.10 lbs/gal solids

**THEORETICAL COVERAGE**
978 mil sq ft/gal (24.0 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)

**PACKAGING**

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

**NET WEIGHT PER GALLON**
12.38 ± 0.25 lbs (5.62 ± 0.11 kg) †

**STORAGE TEMPERATURE**
- Minimum: 40°F (4°C)
- Maximum: 110°F (43°C)

**TEMPERATURE RESISTANCE**
- (Dry) Continuous 250°F (121°C)
- Intermittent 275°F (135°C)

**SHELF LIFE**
Part A: 12 months, Part B: 12 months at recommended storage temperature.

**FLASH POINT - SETA**
- Part A: 40°F (9°C)
- Part B: 44°F (7°C)

**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**

**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>391 (36.4)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>489 (45.5)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>5.0 (125)</td>
<td>526 (30.3)</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>6.5 (165)</td>
<td>245 (22.7)</td>
</tr>
<tr>
<td>Minimum</td>
<td>3.0 (75)</td>
<td>5.0 (125)</td>
<td>326 (30.3)</td>
</tr>
<tr>
<td>Maximum</td>
<td>5.0 (125)</td>
<td>8.0 (203)</td>
<td>196 (18.2)</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. If using Series 44-456 accelerator, slowly add four (4) ounces of Series 44-456 per mixed gallon of Series 1096 while under agitation. **Note:** The use of more than the recommended amount of Series 44-456 accelerator will adversely affect performance.

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.

**THICKENING**

Use No. 10 Thinner. For air or airless spray, thin up to 10% or 12.8 ounces (378 mL) per gallon. For 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.

<table>
<thead>
<tr>
<th></th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pot Life</td>
<td>4 hours at 75°F (24°C)</td>
<td>4 hours at 55°F (13°C)</td>
</tr>
<tr>
<td></td>
<td>3 hours at 75°F (24°C)</td>
<td>3 hours at 55°F (13°C)</td>
</tr>
</tbody>
</table>

**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&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>
</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&quot;-0.017&quot; (330-430 microns)</td>
<td>3000-3500 psi (206-241 bar)</td>
<td>1/4&quot; or 3/8&quot; (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.

<table>
<thead>
<tr>
<th>Roller</th>
<th>Air Cap</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hi-Build</td>
<td>5/16&quot; or 3/8&quot;</td>
<td>3/8&quot; or 1/2&quot; (7.9 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

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).

**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.

**Cleanup**

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

† Values may vary with color.