**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. Direct-to-Metal capability allows for a labor-saving, high-build, single coat application.

**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, 141, 161, 1220, 1224, 1254
- **CMU:** Series 1254

**Note:** The following maximum recoat times apply: Series L69F, 132, 133, 138, L140F or 141; 14 days, Series L69 or L140, 21 days, Series 1, 27, 27WB, 66, N69, N69F, V69, V69F, 118, 132, 135, N140, N140F, V140, V140F, 141, 161, 594, 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**

<table>
<thead>
<tr>
<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>5 gallons (18.9L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 quart can</td>
</tr>
</tbody>
</table>

**RECOMMENDED DFT**

- **Topcoat Service:** 2.0 to 5.0 mils (51 to 127 microns) per coat.
- **Direct-to-Metal, over Zinc or MIO-Zinc:** 3.0 to 6.0 mils (76 to 154 microns) per coat.

**CURING TIME**

<table>
<thead>
<tr>
<th>Temperature (°F/°C)</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. **Note:** For faster cure in temperatures down to 35°F (2°C), add No. 44-456 Urethane Accelerator, see separate product data sheet for cure information. **Note:** The use of Series 44-456 accelerator is not recommended when temperatures exceed 75°F (24°C).

**VOLATILE ORGANIC COMPOUNDS**

- **Unthinned:** 2.15 lbs/gallon (257 grams/litre) (TBAc exempt)
- **Thinned 15% (No. 10 Thinner):** 2.98 lbs/gallon (357 grams/litre)
- **Thinned 15% (No. 10 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):** 1.80 lbs/gallon (216 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**

- **Large Kit:** 6 gallon pail
- **Small Kit:** 1 gallon can

**NET WEIGHT PER GALLON**

12.38 ± 0.25 lbs (5.62 ± .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: 49°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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APPENDIX

APPLICATION

<table>
<thead>
<tr>
<th>Coverage Rates</th>
<th>Topcoat Service</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Dry Mils (Microns)</td>
</tr>
<tr>
<td>Suggested</td>
<td>2.5 (65)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
</tr>
<tr>
<td>Maximum</td>
<td>5.0 (125)</td>
</tr>
</tbody>
</table>

Direct-To-Metal; over Zinc or MIO Zinc

<table>
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<th>Coverage Rates</th>
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<tbody>
<tr>
<td></td>
<td>Dry Mils (Microns)</td>
</tr>
<tr>
<td>Suggested</td>
<td>4.0 (100)</td>
</tr>
<tr>
<td>Minimum</td>
<td>3.0 (75)</td>
</tr>
<tr>
<td>Maximum</td>
<td>6.0 (150)</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.

Thinning

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.

Without 44-456: 4 hours at 75°F (24°C)
With 44-456: 5 hours at 35°F (2°C) 4 hours at 55°F (13°C) 3 hours at 75°F (24°C)

Pot Life

Air Spray

Air Cap 765 or 704 5/16" or 3/8" (7.9 or 9.5 mm)
Mat'l Hose ID 3/8" or 1/2" (9.5 or 12.7 mm)
Atomizing Pressure 50-80 psi (3.4-5.5 bar)
Pot Pressure 10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice 0.015”-0.017” (330-430 microns)
Atomizing Pressure 3000-3500 psi (206-241 bar)
Mat'l Hose ID 1/4” or 3/8” (6.4 or 9.5 mm)
Manifold Filter 60 mesh (250 microns)

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 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.

Cleanup

Flush and clean all equipment immediately after use with xylene or MEK. Use Tnemec No. 74 Thinner when needed to remove remaining material. Do not store thinners for more than one week and do not use more than the recommended amount of Series 44-456 accelerator.

Values may vary with color.