PRODUCT PROFILE

GENERAL DESCRIPTION
Waterborne Acrylic Epoxy

COMMON USAGE
High performance coating suitable for concrete, steel and other commonly used building materials. Features include high-build, low odor, non-yellowing white and fade resistant colors; easy cleanup and stain-, abrasion-, chemical- and moisture-resistance. Good exterior performance.

COLORS
Refer to Tnemec Color Guide.

FINISH
Satin

PERFORMANCE CRITERIA
Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS
Steel: Series 1, 10, 27, 57H, 66, N69, N69F, 90E-92, 90-97, H90-97, 115, 394, 530. Note: Series 10 and 37H are not recommended for frequently wet conditions. Allow Series 10 to cure one week and 37H to cure 30 days before topcoating. Note: When topcoating Series 1 or 394 with 113, maximum recoat time is three days.

Galvanized Steel and Non-Ferrous Metal: Series 66, N69, N69F, 115

Dense Concrete: Self-priming, Series 130, 218

CMU: Series 54, 130, 218

Drywall: Series 151

Wood: Dry interior environments only, self-priming, Series 10-99W, 151-1051

SURFACE PREPARATION

NEW CONCRETE & CMU
Allow to cure for 28 days. Level protrusions and mortar spatter. For optimum results, abrasive blast referencing SSPC-SP13/NACE 6, ICRI CSP 2-3 Surface Preparation of Concrete and Tnemec’s Surface Preparation and Application Guide.

PAINTED SURFACES
Apply test patch to check adhesion. Remove loose paint and spot prime.

ALL SURFACES
Must be clean, dry and free of oil, grease, form release agents and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS
44.0 ± 2.0% (mixed) †

RECOMMENDED DFT
4.0 to 6.0 mils (100 to 150 microns) per coat. Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

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>30-45 minutes</td>
<td>2-3 hours</td>
<td>1-2 hours</td>
</tr>
</tbody>
</table>

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS

Unthinned
1.90 lbs/gallon (228 grams/litre)

Thinned 5% (No. 59 Thinner)
2.03 lbs/gallon (243 grams/litre) †

HAPS
Unthinned: 2.59 lbs/gal solids
Thinned 5% (No. 59 Thinner): 2.82 lbs/gal solids

THEORETICAL COVERAGE
706 mil sq ft/gal (17.3 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS
Two: One Part A (4.5 gal) and One Part B (1/2 gal)

PACKAGING
Five-Gallon Kit: Consists of approximately 4.5 gallons of Part A in a five gallon pail and a partially-filled, half-gallon jug of Part B. When mixed, yields five gallons (18.9L).

One-Gallon Kit: Consists of a partially-filled one gallon can labeled Part A and a partially-filled pint can labeled Part B. When mixed, yields one gallon (3.79L).

NET WEIGHT PER GALLON
11.11 ± 0.25 lbs (5.04 ± 0.11 kg) (mixed) †

STORAGE TEMPERATURE
Minimum 35°F (2°C)     Maximum 110°F (43°C)

TEMPERATURE RESISTANCE
(Dry) Continuous 170°F (77°C)     Intermittent 250°F (121°C)

SHELF LIFE
Part A: 24 months; Part B: 12 months at recommended storage temperature.

FLASH POINT - SETA
Part A: 190°F (88°C)     Part B: 135°F (57°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>5.0 (125)</td>
<td>11.5 (290)</td>
<td>141 (13.1)</td>
</tr>
<tr>
<td>Minimum</td>
<td>4.0 (100)</td>
<td>9.0 (230)</td>
<td>176 (16.4)</td>
</tr>
<tr>
<td>Maximum</td>
<td>6.0 (150)</td>
<td>13.5 (345)</td>
<td>118 (10.9)</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**

Always use the entire contents of A and B components. Stir contents of Part A, making sure no pigment remains on the bottom. Slowly add the contents of Part B to Part A while under agitation. Continue agitation until thoroughly mixed.

**THINNING**

Use clean water. For air, airless spray, brush or roller, thin up to 5% or 1/4 pint (190 mL) per gallon. To improve brush and roll properties, thin up to 5% or 1/4 pint (190 mL) per gallon by volume with No. 59 Thinner. Note: Thin only after Part B has been thoroughly mixed with Part A according to mixing instructions.

**POT LIFE**

48 hours at 50°F (10°C)  24 hours at 77°F (25°C)  16 hours at 100°F (38°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 510</td>
<td>070&quot;</td>
<td>765</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>50-70 psi (3.4-4.8 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;-0.019&quot; (380-485 microns)</td>
<td>2400-3300 psi (165-228 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. **Roller:** Use 1/4" (6.4 mm) synthetic woven nap rollers for smooth surfaces, use 1/2" to 3/4" (12.7 mm to 19 mm) synthetic woven nap rollers for rough surfaces. **Brush:** Use a high quality nylon or synthetic bristle brush. **Touch-Up:** To minimize variations in appearance, touch-up over existing Tneme-Tufcoat should be done by the same method as initial application.

**SURFACE TEMPERATURE**

Minimum 50°F (10°C)  Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Coating won’t cure below minimum surface temperature.

**CLEANUP**

Clean all equipment immediately after use with clean water followed by a final washing with the recommended thinner or Ethanol.

† Values may vary with color.