



T N E M E C

UNI-BOND DF SERIES 115

PRODUCT PROFILE

GENERIC DESCRIPTION Self-crosslinking Hydrophobic Acrylic

COMMON USAGE A high-performance, versatile coating appropriate for a variety of uses including:
Exterior Steel: Waterborne, rust-inhibitive coating with excellent adhesion to organic zinc-rich coatings. Used as a primer or intermediate coat on tanks, vessels and other industrial and architectural metal substrates.
Humid Environments: Primer/finish for two coat applications over prepared galvanized steel and organic zinc-rich coatings in wet, temperature-controlled exposure areas.
Dry Interior Environments: One or two coat, flash-rust and corrosion resistant primer/finish for overheads. Use on prepared carbon and galvanized steel, aluminum, wood and concrete decks, beams, joists and HVAC.
Note: Uni-Bond DF's "dry-fall" characteristics help reduce the potential for overspray problems on buildings and surrounding property.

COLORS Refer to Tnemec Color Guide.

FINISH Eggshell

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

COATING SYSTEM

PRIMERS **Steel:** Self-priming or Series 1, 27, 66, 90-97, 90G-1K97, 91-H₂O, 94-H₂O, 135, 161, 394.
Concrete: Self-priming only.

INTERMEDIATE Series 115 may be used as an intermediate coat over 1, 90-97, 91-H₂O, 94-H₂O or 394. Series 44-900 Adhesion Promoter must be used when topcoating Series 1 or 394 with Series 115.

TOPCOATS Series 30, 35, 113, 114, 156, 157, 180, 181, 1028 or 1029. **Note:** When Series 115 is applied over 90-97, 90G-1K97, 91-H₂O or 94-H₂O, only Series 35, 1028 or 1029 can be used as topcoats.

SURFACE PREPARATION

STEEL **Weather Exposed:** SSPC-SP6/NACE 3 Commercial Blast Cleaning.
Enclosed, Protected & Mild Environments: SSPC-SP3 Power Tool Cleaning.

GALVANIZED STEEL & ALUMINUM Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

PAINTED SURFACES Remove chalk and old paint not tightly bonded to the surface. Clean all visible rust using SSPC-SP3 Power Tool Cleaning (interior dry) or to bare metal using SSPC-SP11 Power Tool Cleaning to Bare Metal (weather exposed). (Test patch is recommended in accordance with Technical Bulletin 98-10R latest revision.)

ALL SURFACES Must be clean, dry and free of dust, dirt, oil, grease and other contaminants. Existing water soluble stains in the substrate or upon the surface must be removed or sealed. Allow new concrete to cure 28 days.

TECHNICAL DATA

VOLUME SOLIDS 44.0 ± 2.0% †

RECOMMENDED DFT 2.0 to 4.0 mils (50 to 100 microns) per coat.

CURING TIME

Temperature	To Handle	To Recoat
75°F (24°C)	3 hours	4 hours

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

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 1.09 lbs/gallon (131 grams/litre)
Thinned 5%: 1.09 lbs/gallon (131 grams/litre) †

HAPS **Unthinned:** 0.02 lbs/gal solids
Thinned 5%: 0.02 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 One

PACKAGING 55 gallon (208.2L) drums and 5 gallon (18.9L) pails.

NET WEIGHT PER GALLON 11.60 ± 0.25 lbs (5.3 ± .11 kg) †

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

TEMPERATURE RESISTANCE (Dry) Continuous 170°F (77°C) Intermittent 200°F (93°C)

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA >230°F (110°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.

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APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	3.0 (75)	7.0 (175)	235 (21.8)
Minimum	2.0 (50)	4.5 (115)	355 (33.0)
Maximum	4.0 (100)	9.0 (230)	175 (16.3)

Allow for overspray and surface irregularities. Wet 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. **Note:** Two coats may be required on concrete for uniform appearance and coverage. †

MIXING

Mix by stirring to uniform consistency without creating air bubbles and foam. Do not box or use a paint shaker. Stir thoroughly, making sure no pigment remains on the bottom of the can.

THINNING

Thinning is not normally required but when needed, thin up to 5% or 1/4 pint (190 mL) per gallon with clean tap water.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	50-70 psi (3.4-4.8 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.013"-0.017" (330-430 microns) Reversible Tip	1800-2400 psi (124-165 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Note: On projects involving spray equipment being used over consecutive days, follow Cleanup instructions below and then leave xylo in the system overnight, flushing thoroughly with clean water before each start-up.

Roller: Contact your Tnemec representative.

Brush: Contact your Tnemec representative.

SURFACE TEMPERATURE

Minimum 45°F (7°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 clean tap water. Finish by flushing all spray equipment with isopropyl alcohol.

CAUTION

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that surface temperatures can be higher than air temperature.

† Values may vary with color.

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