PRODUCT PROFILE

GENERIC DESCRIPTION
Phenolic Alkyd

COMMON USAGE
Lead- and chromate-free, fast-drying, corrosion-resistant primer that accepts a variety of high-performance topcoats. Ideally suited for steel fabricators, OEM's and field applications where ‘dry-fall’ characteristics are desired. **Note:** Not recommended for immersion.

COLORS
77 Red, 78 Gray. **Note:** Minimum order quantities apply for 78 Gray.

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

COATING SYSTEM

TOPCOATS
Series 2H, 2HS, 6, 27, 30, 66, L69, L69F, N69, N69F, V69, V69F, 73, 82HS, 113, 114, 161, 175, 180, 181, 1028, 1029, 1074, 1074U, 1075, 1075U. Allow Series 37H to cure for three days before topcoating with 1028 or 1029. **Note:** Some systems are not recommended for frequently sweating or continually wet conditions. Reference the applicable topcoat data sheet for additional information. Also, an additional coat of 37H is suggested before applying Series 6, 180, 181, 1028 or 1029. Contact Tnemec Technical Services for details.

SURFACE PREPARATION

STEEL
Enclosed or Protected: SSPC-SP3 Power Tool Cleaning
Weather-Exposed: SSPC-SP6/NACE 3 Commercial Blast Cleaning

CAST/DUCTILE IRON
Contact your Tnemec representative or Tnemec Technical Services.

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

TECHNICAL DATA

VOLUME SOLIDS
58.0 ± 2.0% †

RECOMMENDED DFT
2.0 to 3.5 mils (50 to 90 microns) per coat.

CURING TIME
**Temperature:** 75°F (24°C)
**To Handle:** 2 hours
**To Recoat With Series:**

<table>
<thead>
<tr>
<th></th>
<th>2H, 2HS, 82HS, 180, 181</th>
<th>27•, 66•, 161•</th>
<th>1028, 1029</th>
<th>30</th>
<th>L69, L69F, N69, N69F, V69, V69F, 73, 113, 114, 175, 1074, 1074U, 1075, 1075U</th>
</tr>
</thead>
<tbody>
<tr>
<td>16 hours</td>
<td>48 hours</td>
<td>3 days</td>
<td>7 days</td>
<td>30 days</td>
<td></td>
</tr>
</tbody>
</table>
| Curing time varies with surface temperature, air movement, humidity and film thickness. **Note:** Allow 37H to cure 14 days if 27, 66 or 161 is to be used as an intermediate coat and topcoated with 73, 175, 1074, 1074U, 1075 or 1075U. Then allow 27, 66 or 161 to cure an additional 24 hours before topcoating.

Water Tank Exteriors: Five days or more curing required before filling.

VOLATILE ORGANIC COMPOUNDS

Unthinned: 2.91 lbs/gallon (348 grams/litre)
Thinned 4%: 5.07 lbs/gallon (568 grams/litre)
Thinned 9%: 5.27 lbs/gallon (591 grams/litre) †

HAPS

Unthinned: 1.37 lbs/gal solids
Thinned 4%: 1.89 lbs/gal solids
Thinned 9%: 2.51 lbs/gal solids

THEORETICAL COVERAGE
930 mil sq ft/gal (22.8 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS
One

PACKAGING
55 gallon (208.2L) drums, 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

NET WEIGHT PER GALLON
77 12.85 ± 0.25 lbs (5.92 ± .11 kg)
78 12.11 ± 0.25 lbs (5.61 ± .11 kg) †

STORAGE TEMPERATURE
Minimum 20°F (-7°C)  Maximum 110°F (43°C)

TEMPERATURE RESISTANCE
(Dry) Continuous 200°F (93°C)  Intermittent 250°F (121°C)
24 months at recommended storage temperature.

SHELF LIFE
65°F (18°C)

THEORY OF THE SHELF LIFE
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**

<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>4.5 (115)</td>
<td>572 (34.6)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.5 (90)</td>
<td>465 (43.2)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.5 (90)</td>
<td>6.0 (150)</td>
<td>266 (24.7)</td>
</tr>
</tbody>
</table>

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. †

Mixing

Stir thoroughly, making sure no pigment remains on the bottom of the can.

Minimizing

Use No. 2 Thinner. For air spray, thin up to 9% per gallon. For airless spray, brush or roller, thin up to 4% per gallon.

Application Equipment

<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>75-90 psi (5.2-6.2 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>2700-3000 psi (186-207 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 high quality synthetic woven nap covers, 1/4" nap for smooth surfaces, 3/8" nap for rough surfaces.

Brush

Recommended for small areas only. Use high quality nylon or synthetic bristle brushes.

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 the recommended thinner or xylol.

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions, equipment adjustment and proper thinning. 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 exterior surface temperatures can be higher than air temperature.

† Values may vary with color.