Aliphatic Acrylic Polyurethane

A coating highly resistant to abrasion, wet conditions, corrosive fumes, chemical contact and exterior weathering. Direct-to-Metal capability allows for a labor-saving, high-build, single coat application. NOT FOR IMMERSION SERVICE.

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 (blue, gray, etc.), but noticeably different.

Semi-gloss

Series 73 meets the accelerated weathering requirements of SSPC Paint Standard 36.

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

**TEMPERATURE RESISTANCE**

- **Part B**: 12 months at recommended storage temperature.
- **Part A**: 24 months at recommended storage temperature.

**NUMBER OF COMPONENTS**

Two: Part A and Part B

**NET WEIGHT PER GALLON**

- **Part A**: 12.13 ± 0.25 lbs (5.50 ± .11 kg)
- **Part B**: 12.00 ± 0.25 lbs (5.45 ± .11 kg)

**THEORETICAL COVERAGE**

930 mil sq ft/gal (22.8 m²/L at 25 microns). †

**STORAGE TEMPERATURE**

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

**THEORETICAL COVERAGE**

- (Dry): Continuous 250°F (121°C)
- Intermittent 275°F (135°C)

**FLASH POINT - SETA**

- Part A: 55°F (13°C)
- Part B: 112°F (43°C)

Published technical data and instructions are subject to change without notice. The online catalog at www.tnemec.com should be referenced for the most current technical data and instructions or you may contact your Tnemec representative for specific test results.
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>Topcoat Service</td>
<td></td>
<td></td>
<td></td>
</tr>
<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>3.0 (75)</td>
<td>5.0 (155)</td>
<td>310 (28.8)</td>
</tr>
</tbody>
</table>

|                      |                    |                    |                    |
| Direct to Metal Service |                |                    |                    |
| Suggested            | 4.0 (100)          | 7.0 (180)          | 235 (21.6)         |
| Minimum              | 3.5 (90)           | 6.0 (150)          | 266 (24.7)         |
| Maximum              | 5.0 (125)          | 8.5 (215)          | 186 (17.3)         |

(1) Can be spray applied at 3.0 to 5.0 mils (75 to 125 microns) DFT per coat when extra protection or the elimination of a coat is desired. (2) Can be sprayed, brushed or rolled at 2.0 to 3.0 mils (50 to 75 microns) DFT per coat for use in systems requiring a conventional build topcoat. 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 contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. When used with 44-710 Urethane Accelerator, first blend 44-710 into Part A under agitation, continue as above. 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.

**THINNING**

For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon by volume with No. 42 Thinner if temperatures are below 80°F (27°C), use No. 48 Thinner for temperatures above 80°F (27°C). Thin up to 5% or 1/4 pint (190 mL) per gallon for airless spray. For brush or roller, thin 5% to 10% or 1/4 to 3/4 pint (190 to 580 mL) per gallon with No. 59 or No. 65 Thinner. Thinning is required for proper brush or roller application. Note: A maximum of 10% of No. 56 Thinner may be used to comply with VOC regulations. Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.

**POT LIFE**

8 hours at 40°F (4°C)  4 hours at 77°F (25°C)  2 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</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16” or 3/8” (7.9 or 9.5 mm)</td>
<td>3/8” or 1/2” (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>0.013”-0.017” (330-430 microns)</td>
<td>2700-5300 psi (186-228 bar)</td>
<td>1/4” or 3/8” (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.

**Surface Temperature**

Minimum 35°F (2°C)  Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Cure time necessary to resist direct contact with moisture at surface temperature: 40°F (4°C) 24 to 40 hours  50°F (10°C) 18 to 26 hours  60°F (16°C) 12 to 16 hours  70°F (21°C) 4 to 8 hours  90°F (32°C) 2 to 4 hours  100°F (38°C) 2 to 3 hours

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

**Cleanup**

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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