

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamide Epoxy Zinc Rich
COMMON USAGE	An advanced technology, three-component, zinc-rich primer providing extraordinary performance, user-friendly and easy application. Also used for field touch-up of inorganic zinc coating.
COLORS	Reddish Gray
ZINC PIGMENT	81% ± 2% by weight in dried film
SPECIAL QUALIFICATIONS	Tneme-Zinc uses a zinc pigment which meets the requirements of ASTM D 520 Type III and contains less than .002% lead. This level qualifies it to be classed as "non-lead" (less than 0.009% lead by weight) as defined in 16 CFR Part 1303 of the Consumer Product Safety Commission regulations. Conforms to SSPC Paint 20, Type II .

COATING SYSTEM

TOPCOATS Series 1, 27, N69, N69F, 66HS, 161HS, 1095

SURFACE PREPARATION

STEEL **Severe Exposure:** SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum angular anchor profile of 1.5 mils.
Moderate Exposure: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

TECHNICAL DATA

VOLUME SOLIDS 68% ± 2.0% (mixed)
RECOMMENDED DFT 3.0 to 5.0 mils (76 to 127 microns)

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75°F (24°C)	15 minutes	4 hours	6 hours

VOLATILE ORGANIC COMPOUNDS

Unthinned: 2.23 lbs/gallon (267.8 grams/litre)
Thinned 15% (No. 4 Thinner): 2.83 lbs/gallon (339.9 grams/litre)

HAPS 5.48 lbs/gal solids

THEORETICAL COVERAGE

1,043 mil sq ft/gal (25.6 m²/L at 25 microns at 25 microns) See APPLICATION for coverage rates.

NUMBER OF COMPONENTS

Three: Part A, Part B, and C

PACKAGING

	Part A (Partially Filled)	Part B (Partially Filled)	Part C (Partially Filled)	Yield (Mixed)
Large Kit	1-5 gallon pail	1-1 gallon can	1-3 gallon pail	4.0 gallons (15.1 L)
Small Kit	1-half gallon can	1-quart can	1-1 gallon can	0.95 gallons (3.59 L)

NET WEIGHT PER GALLON

24.6 ± 0.54 lbs (11.15 ± 0.25kg)

STORAGE TEMPERATURE

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

TEMPERATURE RESISTANCE

Dry (Continuous) 250°F (121°C) Intermittent 300°F (149°C)

SHELF LIFE

Parts A, B and C: 12 months at recommended storage temperature.

FLASH POINT - SETA

Part A: 47°F (8°C) Part B: 100°F (38°C) Part C: N/A

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.

APPLICATION

COVERAGE RATES

	Dry Mil (Microns)	Wet Mil (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	4.0 (100)	5.5 (140)	285 (26.5)
Minimum	3.0 (75)	4.0 (100)	380 (35.3)
Maximum	5.0 (125)	7.0 (180)	228 (21.2)

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

Always use the entire contents of A, B and C components. Power mix contents of each container, making sure no pigment remains on the bottom. Slowly sift the Part C powder into the Part A while under agitation. Adjust mixer speed to break up lumps and mix until thoroughly blended and homogenous. Add the contents of the Part B to blended Parts A and C while under agitation. Add the thinner and continue agitation until the components are thoroughly mixed. Strain through a 35 to 50 mesh (300 to 600 microns) screen before using. For spray application, keep under low RPM agitation to prevent settling. For brush or roller application, stir frequently to prevent settling. Do not use mixed material beyond pot life limits. **Note:** Both components must be above 50°F (10°C) prior to mixing. For application to surfaces between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C).

THINNING

Thin 15% or 19 fluid ounces per gallon with No. 4 thinner for spray, brush, or roller.

POT LIFE

5 hours at 75°F (24°C)

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APPLICATION EQUIPMENT

Note: When finish coats are white or light colors, best hiding of this dark color primer can be achieved by spray application.

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" (9.5mm or 12.7mm)	50-60 psi (3.4-4.1 bar)	30-40 psi (2.0-2.8 bar)

† (with heavy mastic spring) Low temperatures or longer hoses will require additional pressure. Use pressure pot equipped with an agitator and keep pressure pot at same level or higher than the spray gun. Compressed air must be dry.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID
0.017"-0.021" (430-535 microns) Reversible Tip	3500-4500 psi (241-310 bar)	1/4" or 3/8" (6.4 or 9.5 mm)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions. Stir material frequently or keep under agitation to prevent settling.

Roller: Use 3/8" or 1/2" (9.5 mm or 12.7 mm) synthetic woven nap roller covers.. Stir material frequently or keep under agitation to prevent settling.

Brush: Use high quality natural or synthetic bristle brushes. Stir material frequently or keep under agitation to prevent settling.

**SURFACE TEMPERATURE
CLEANUP**

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

Flush and clean all equipment immediately after use with the recommended thinner or methyl ethyl ketone.

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