Aromatic Urethane, Zinc-Rich

A single-component, moisture-cured, zinc-rich primer for steel structures, including the interior and exterior of steel potable water tanks. Provides outstanding long-term corrosion resistance when used as a primer in conjunction with other Tnemec coatings. Series 94-H₂O has no maximum recoat time, cures quickly and offers rapid recoat at surface temperatures down to 35°F (2°C). **Note:** When used in conjunction with cathodic protection, anodes or impressed current systems should not provide current demand more negative than ~1.05 volts relative to a copper-copper sulfate reference electrode half-cell.

**Colors:**
Greenish-gray

**Zinc Pigment:**
83% by weight in dried film

Certified (with or without 44-710 Urethane Accelerator) in accordance with **ANSI/NSF/CAN Std. 61** and the extraction requirements of **NSF/ANSI/CAN 600** and is qualified for use on interior potable water tanks of 400 gallons (1514 L) or greater. Topcoating with Std. 61 certified Tnemec coatings is required. Contact your Tnemec representative for specific recommendations. Reference Tnemec’s certified product listing at www.nsf.org for details on maximum allowable DFT. Meets zinc-rich primer requirements of **AWWA D102-17 Standard for Inside System No. 3, 5 & 6 and Outside System No. 3, 4 & 6.** Series 94-H₂O uses a zinc pigment which meets the requirements of **ASTM D 520 Type III** and contains less than .002% lead.

Series 94-H₂O was tested in accordance with, and passed, the California Dept. of Public Health (CDPH) Standard Method v1.2, and meets the requirements of LEED v4.1 Low-Emitting Materials, Collaborative for High Performance Schools-Paints & Coatings, Living Building Challenge Materials Petal 10, and WELL Building Standard v2 X06 VOC Restrictions.

**Temperature †**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>2 hours</td>
<td>8 hours</td>
</tr>
<tr>
<td>55°F (11°C)</td>
<td>4 hours</td>
<td>12 hours</td>
</tr>
<tr>
<td>35°F (2°C)</td>
<td>6 hours</td>
<td>16 hours</td>
</tr>
</tbody>
</table>

† 50% relative humidity. **Note:** Refer to product listings on www.nsf.org for specific potable water return to service information. Curing time will vary with surface temperature, humidity and film thickness. **Ventilation:** When used in enclosed areas, provide adequate ventilation during application and cure.

**Note:** For faster curing, low humidity and low-temperature applications, add No. 44-710 Urethane Accelerator (see separate product data sheet). **Note:** For cure times to immersion service, reference the specified Tnemec interior topcoat method of application. Contact your Tnemec representative. **Note:** Series 94-H₂O must be exterior exposed for three days prior to topcoating with Series 1028 or 1029. **Note:** Series 94-H₂O must be exterior exposed for one day prior to topcoating with Series 27WB.

**Volume Solids**

62.0 ± 2.0% (mixed)

**Recommended DFT**

2.5 to 3.5 mls (65 to 90 microns) per coat.

**Curing Time**

Without 44-710

Unthinned: 0.74 lbs/gallon (89 grams/litre)
Thinned 15% (No. 49 Thinner): 0.74 lbs/gallon (89 grams/litre)
Thinned 10% (No. 3 Thinner): 1.57 lbs/gallon (188 grams/litre)
Thinned 10% (No. 2 Thinner): 1.56 lbs/gallon (187 grams/litre)

**Flash Point - SETA**

82°F (28°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 current technical data and instructions.
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>3.0 (75)</td>
<td>5.0 (125)</td>
<td>831 (30.8)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.5 (65)</td>
<td>4.0 (100)</td>
<td>598 (23.7)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.5 (90)</td>
<td>5.5 (140)</td>
<td>284 (26.4)</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. Reference the NSF website at www.nsf.org for details on the maximum allowable DFT.

MIXING

Stir thoroughly making sure no pigment remains on the bottom of the can. Use an air-driven power mixer and keep material under constant agitation while mixing. Do not use material beyond pot life limits.

THINNING

For air spray, thin up to 15% or 1 1/4 pints (570 mL) per gallon with No. 49 Thinner or thin up to 10% or 3/4 pint (380 mL) per gallon with No. 2 or No. 3 Thinner. (Use No. 2 if ambient temperatures are below 80°F (27°C) and No. 3 if above 90°F (32°C).) For brush or roller, thin up to 5% or 1/4 pint (390 mL) per gallon with No. 49 Thinner or thin up to 10% or 3/4 pint (380 mL) per gallon with No. 2 or No. 3 Thinner. Thinning is normally not required for airless spray. **Note:** The original formula of Series 94-H Thinner may be used with VOC restrictions. The use of any other thinner voids NSF/ANSI/CAN Std. 61 certification. **Caution:** Series 94-H, No. 2 or No. 3 Thinner. Use of any other thinner voids NSF/ANSI/CAN Std. 61 certification.

POT LIFE

8 hours at 77°F (25°C) and 50% R.H. **Caution:** This product cures with moisture acting as a catalyst. Incorporation of moisture or moisture laden air (humidity) during use will shorten pot life. Avoid continual agitation at high RPM. When feasible keep containers of mixed material covered during use.

APPLICATION EQUIPMENT

**Note:** When intermediate and finish coats are white or light colors, best hiding of this dark color primer can be achieved by spray application, or when roller applied, by using 1/4” nap covers.

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>704 or 765</td>
<td>5/16” or 3/8” (9.5 or 12.7 mm)</td>
<td>3/8” or 1/2” (0.9 or 12.7 mm)</td>
<td>40-50 psi (2.8-3.4 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
</tr>
</tbody>
</table>

† (with heavy mastic spring) Low temperatures or longer hoses will require additional pressure. Use spray 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

<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”-0.019” (380-481 microns)</td>
<td>3000-4000 psi (207-276 bar)</td>
<td>1/4” or 3/8” (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

<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>Reversible Tip</td>
<td>0.005”-0.006” (1250-1500 microns)</td>
<td>3000-4000 psi (207-276 bar)</td>
<td>1/4” or 3/8” (6.4 or 9.5 mm)</td>
</tr>
</tbody>
</table>

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

**Roller:** Use a 1/4” or 3/8” (6.4 or 9.5 mm) synthetic woven nap roller cover. Stir material frequently or keep under agitation to prevent settling.

**Brush:** Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 55°F (13°C) Maximum 140°F (60°C) Maximum for Brush & Roller 120°F (49°C) The surface should be dry and at least 5°F (3°C) above the dew point. **Note:** Series 44-710 Accelerator must be used if the surface temperature is 55°F to 60°F (2°C to 16°C) and 20% to 40% relative humidity. Please reference Technical Bulletin 98-14 for more information.

AMBIENT HUMIDITY

Minimum 20% Maximum 90%

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or xylene or, when required by SCAQMD regulations, No. 49 Thinner.

CAUTION

Series 94-H₂O, with one-component configuration, prevents the product’s ability to offer “dry-fall” characteristics.