PRODUCT PROFILE

Moisture-Cured Aromatic Urethane
Aluminum pigmented primer or finish for marginally cleaned steel. Provides excellent abrasion-, moisture-, chemical- and corrosion-resistance. Suitable for use as a topcoat where an aluminum finish is desired. Topcoating provides enhancement of systems and more latitude with color. Compatible with aged coatings, but verify with test patch.

COLORS
Aluminum
FINISH
Matte

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

COATING SYSTEM

TOPCOATS
Series 2H, 2HS, 27, 66, 66HS, L69, N69, 72, 73, 82HS, 113, 114, 161, 161HS, V530, 1028, 1029, 1074, 1074U, 1075, 1075U, 1077

Note: Series V530 exterior (sunlight) exposed for 24 hours or longer requires scuffing or an intermediate coat of Series 27, 66, 66HS or N69 prior to topcoating with itself (V530), 72, 73, 1028, 1029, 1074, 1074U, 1075, 1075U or 1077. Also if exterior exposed for 7 days or longer, V530 requires scuffing or an intermediate coat of 27, 66, 66HS or N69 prior to topcoating with 113 or 114. The intermediate coat color should be noticeably different but in the same family as the specified topcoat color.

SURFACE PREPARATION

STEEL

Moderate Exposure: SSPC-SP2 Hand Tool Cleaning or SSPC-SP3 Power Tool Cleaning (SSPC Rust Grade Condition C or Condition D).
Severe Exposure: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

PREVIOUSLY COATED SURFACES

A test patch is required prior to application on previously coated surfaces. Reference the latest version of Technical Bulletin 98-10.

ALL SURFACES

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

TECHNICAL DATA

VOLUME SOLIDS
5.10 ± 0.20%

RECOMMENDED DFT
2.0 to 3.0 mils (50 to 75 microns) per coat. Caution: Application at film thicknesses exceeding 3.0 dry mils (75 microns) per coat at or relative humidities above 70% R.H. may cause bubbles to form in the cured film.

CURING TIME

<table>
<thead>
<tr>
<th>Temperature †</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>2 hours</td>
<td>3 hours</td>
<td>5 hours</td>
</tr>
</tbody>
</table>

† 50% Relative Humidity
Curing time varies with surface temperature, air movement, humidity and film thickness.

Note: For faster curing, low humidity and low-temperature applications, add No. 44-710 Urethane Accelerator; see separate product data sheet.

VOLATILE ORGANIC COMPOUNDS (VOC)
Unthinned: 1.25 lbs/gallon (149 grams/litre)
Unthinned: 0.05 lbs/gal solids

THEORETICAL COVERAGE
818 sq ft/gal (20.1 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS
One

PACKAGING
5 gallon pail yielding 5 gallons (18.9 L) and one gallon can yielding 0.95 gallons (3.6 L)

NET WEIGHT PER GALLON
10.90 ± 0.25 lbs (4.94 ± .11 kg)

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

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

SHELF LIFE
12 months at recommended storage temperature.

FLASH POINT - SETA
95°F (35°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.

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>5.0 (125)</td>
<td>527 (30.4)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>4.0 (100)</td>
<td>409 (38.0)</td>
</tr>
<tr>
<td>Maximum</td>
<td>3.0 (75)</td>
<td>6.0 (150)</td>
<td>273 (25.3)</td>
</tr>
</tbody>
</table>

Allow for overspray and surface irregularities. 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. This product reacts with moisture. Viscosity will remain constant if maternal is kept dry. Keep unused maternal tightly closed at all times. Avoid vigorous agitation that will incorporate excessive amounts of humid air into the product.

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.

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DO NOT THIN.

**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 MBC or JGA</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16” or 3/8” (7.9 or 9.5 mm)</td>
<td>5/8” or 1/2” (9.5 or 12.7 mm)</td>
<td>60-80 psi (4.2-5.5 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>3000-3500 psi (207-227 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. **Note:** Series 44-710 Accelerator must be used if the surface temperature is 35°F to 60°F (2°C to 16°C) and 20% to 40% relative humidity.

**Ambient Humidity**

- Minimum 20%
- Maximum 70%

**Cleanup**

Flush and clean all equipment immediately after use with xylene.