

PRODUCT PROFILE

GENERIC DESCRIPTION Moisture-Cured Aromatic Urethane

COMMON USAGE 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 scarification 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 scarification 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 51.0 ± 2.0%

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 or at relative humidities above 70% R.H. may cause bubbles to form in the cured film.**

CURING TIME

Temperature †	To Touch	To Handle	To Recoat
75°F (24°C)	2 hours	3 hours	5 hours

† 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

Unthinned: 1.25 lbs/gallon (149 grams/litre)

HAPS

Unthinned: 0.03 lbs/gal solids

THEORETICAL COVERAGE

818 mil 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

	Dry Mil (Microns)	Wet Mil (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	5.0 (125)	327 (30.4)
Minimum	2.0 (50)	4.0 (100)	409 (38.0)
Maximum	3.0 (75)	6.0 (150)	273 (25.3)

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 material is kept dry. Keep unused material tightly closed at all times. Avoid vigorous agitation that will incorporate excessive amounts of humid air into the product.

OMNITHANE® | SERIES V530

THINNING
APPLICATION EQUIPMENT

DO NOT THIN.

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss MBC or JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	60-80 psi (4.2-5.5 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.013"-0.017" (330-430 microns)	3000-3300 psi (207-227 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

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

Roller: Use carpet-type roller covers.

Brush: Use high quality natural or synthetic bristle brushes.

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.

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