

PRODUCT PROFILE

GENERIC DESCRIPTION	Aromatic Urethane, Zinc-Rich
COMMON USAGE	An advanced technology, two-component, moisture-cured, zinc-rich primer providing extraordinary performance. It's user friendly and rapid curing so chemical- and corrosion-resistant topcoats can be applied the "same-day." Also used for field touch-up of inorganic zinc coating. Application methods include "dry-fall" under certain conditions (see Application).
ZINC DUST CONTENT	83% by weight in dried film
COLOR	90-97 Reddish-gray
SPECIAL QUALIFICATIONS	Meets AISC requirements of a Class B surface with a mean slip coefficient no less than 0.50 and a tension creep not in excess of .005 inches (.13 mm). Series 90-97 Tneme-Zinc uses a zinc dust 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 0.06% lead by weight) as defined in Part 1303 of the Consumer Product Safety Act Regulations. Conforms to SSPC Paint 20, Type II .
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.



COATING SYSTEM

TOPCOATS	Series 6, 25, 27, 46H-413, 66, N69, 73, 84, 104, 113, 114, 161, 175, 594, 1074, 1075 Note: Certain topcoat colors may not provide one-coat hiding depending on method of application. Contact your Tnemec representative.
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SURFACE PREPARATION

Severe Exposure: SSPC-SP10 Near-White Blast Cleaning.
Moderate Exposure: SSPC-SP6 Commercial Blast Cleaning.

TECHNICAL DATA

VOLUME SOLIDS	63.0 ± 2.0% (mixed)		
RECOMMENDED DFT	2.5 to 3.5 mils (65 to 90 microns) per coat.		
CURING TIME	Temperature*	To Handle	To Recoat
Without 44-710	75°F (24°C)	1 hour	4 hours
	65°F (18°C)	1½ hours	5 hours
	55°F (11°C)	2 hours	6 hours
	45°F (7°C)	2½ hours	7 hours
	35°F (2°C)	3 hours	8 hours
With 44-710	Reference the 44-710 Urethane Accelerator product data sheet.		
VOLATILE ORGANIC COMPOUNDS	Unthinned 2.67 lbs/gallon (320 grams/litre)	Thinned 2.5% 2.78 lbs/gallon (333 grams/litre)	Thinned 10% 3.09 lbs/gallon (370 grams/litre)
THEORETICAL COVERAGE	1,011 mil sq ft/gal (24.8 m ² /L at 25 microns). See APPLICATION for coverage rates.		
NUMBER OF COMPONENTS	Two: Part A and Part B		
PACKAGING	Four-Gallon and One-Gallon Kits: Consist of one premeasured container of liquid (Part A) and one premeasured container of powder (Part B). When mixed, yields four gallons (15.1L) or one gallon (3.79L).		
NET WEIGHT PER GALLON	23.94 ± 0.60 lbs (10.86 ± .27 kg)		
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	Part A: 12 months at recommended storage temperature. Part B: 24 months at recommended storage temperature.		
FLASH POINT - SETA	Part A: 78°F (26°C)		Part B: NA
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

CAUTION! Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature is of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that surface temperatures can be higher than air temperature.

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	3.0 (75)	5.0 (125)	337 (31.3)
Minimum	2.5 (65)	4.0 (100)	404 (37.5)
Maximum	3.5 (90)	5.5 (140)	289 (26.9)

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 Always use the entire contents of A and B components. Use an air-driven power mixer and keep material under constant agitation while mixing. Slowly sift powder (Part B) into liquid (Part A). **-Do Not Reverse This Procedure-** Adjust mixer speed to break up lumps and mix until the two components are thoroughly blended. 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.

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.

THINNING For spray, thin up to 10% or ¼ pint (380 mL) per gallon with No. 2 Thinner if temperatures are below 80°F (27°C). Thin up to 10% or ¼ pint (380 mL) per gallon with No. 3 Thinner if temperatures are above 80°F (27°C). For brush or roller, thin up to 10% or ¼ pint (380 mL) with No. 3 Thinner. Do not thin more than 2.5% when air pollution regulations limit the atmospheric discharge of volatile organic compounds (VOC) in coatings to a maximum of 340 grams/litre (2.80 lbs/gal).

SURFACE TEMPERATURE Minimum 35°F (2°C) Maximum 120°F (49°C) Maximum for Brush & Roller 100°F (38°C)
The surface should be dry and at least 5°F (3°C) above the dew point.

APPLICATION EQUIPMENT **Note:** When 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 ¼" nap covers.

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss• MBC or JGA	E	78	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	40-50 psi (2.8-3.4 bar)	10-20 psi (0.7-1.4 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	Manifold Filter
0.017"-0.021" (430-535 microns) Reversible Tip	2400-3000 psi (165-207 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. Keep material agitated to prevent settling.

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

Brush: Use high quality natural or synthetic bristle brushes.

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

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