



Tufcote™ 1.9 HG-D™ High Gloss Waterborne Acrylic DTM



GENERAL

DESCRIPTION

A high gloss, single-package, 1.9 lbs./gal. VOC conforming product based on waterborne acrylic technology. The resulting coating is designed to deliver good gloss and color retention in mild to moderate environments.

SUGGESTED USES:

As a high-quality waterborne topcoat on non-rusted carbon steel, galvanized steel, aluminum, concrete, plaster, fiberglass, PVC, glass, drywall, and wood where:

- Low odor, easy-to-use product is required
- Minimizing environmental impact and reducing cost for permitting, abatement, and waste disposal are important
- Single-package DTM (direct-to-metal) product is required
- Application by brush and roller, in addition to spraying, may be necessary
- Good gloss and color retention in mild to moderate environments is desired

NOT RECOMMENDED FOR:

- Immersion service
- Harsh chemical environments
- Application direct to rusted surfaces

COMPATIBILITY WITH OTHER COATINGS

Tufcote 1.9 HG-D can be applied over itself and over properly primed surfaces; including acrylics, alkyds, and epoxies. It may be used over most aged and hard cured coatings in good condition. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact Axalta Coating Systems for specific recommendations.

PERFORMANCE PROPERTIES

Color/Gloss Retention	Excellent
Flash Rusting	Excellent
Weather	Excellent

COLOR

White plus custom mix formulas available

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS

Factory packaged colors Bases are short filled to allow for colorant addition:

- 1LB72P™ 128 oz/gal
- 2MB72P™ 124 oz/gal
- 3DB72P™ 120 oz/gal
- 4NB72P™ 116 oz/gal

ACTIVATION

No activation required.

MIXING AND REDUCTION

No further reduction necessary. If more than 15% is required, contact your Axalta representative for specific recommendations.

APPLICATION THINNERS

Water

INDUCTION TIME

None

POT LIFE

Not applicable.



APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

SURFACE PREPARATION

For best results, all surfaces must be clean, dry and free of loose rust, oil, grease, and all other contamination. Can be applied over SSPC-SP-6 Commercial Blast Cleaned steel and other properly prepared substrates (see Compatibility Section). Can be applied over a SSPC-SP 2 Hand Tool Cleaned or SSPC-SP 3 Power Tool Cleaned surface with some sacrifice in performance. Can be applied over previously painted surfaces in good condition after checking for adhesion.

When using Tufcote 1.9 HG-D over rusted surfaces that cannot be blast cleaned

- Prepare surface in accordance with SSPC SP-2 Hand Tool Clean or SSPC SP-3 Power Tool Clean.
- Prime with Corlar® 2.1 ST™ or Corlar LV-SG™.
- Apply Tufcote 1.9 HG-D.

APPLICATION EQUIPMENT

Apply by spray, brush or roll. Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

Hiding – Most colors exhibit excellent hiding at the recommended DFT. However, some colors may require multiple coats and higher film builds to achieve complete hiding.

Roll

Wooster® Pro/Doo-Z ¼" - ½" nap roller cover.
Keep roll wet. Roll in one direction, rewet, then cross roll.

Brush

Wooster China Bristle Brush 2"-4"

Spray

Conventional Pressure Fed Liquid

	<u>Binks</u>	<u>DeVilbiss</u>	<u>Sata</u>
Spray Gun:	2001	JGA	K3RP
Fluid Nozzle:	63CSS	FF (1.4)	1.1
Pot Pressure:			40
Atomizing Pressure			36
Air Cap:	63PR	765	

Fluid lines 3/8" ID or larger are required for proper fluid delivery.

HVLP Pressure Fed

Devilbiss	GTi	1.4	2000
Binks	Mach 1	94 (1.4)	95AP



Airless Spray

Pump: Graco Extreme 33:1
Airless Gun: Graco 208663
Fluid Hose: 3/8" x 100' max.
Tips: 413-419
Minimum pressure to avoid fingering: 2400 psi min

CLEAN UP THINNERS

Cleaned immediately with water. Dry films require MEK or Xylene



DRY TIMES

Cure Times in hours at suggested DFT

	<u>77°F (25°C)</u>
To Touch	1
To Handle	3
To Recoat	3
Hard Dry	24

Note: Deep base colors may exhibit longer dry times due to higher colorant levels.



PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (93°C)
Gloss (ASTM D 523)	High to medium White and light colors 70 ± 5 @ 60° (Dark colors slightly lower)
Weight Solids (Avg. varies by color):	46% average
Weight per gallon-(Avg. varies by color):	9.5 Lb. (4.4 Kg) Average
Flash Point-Tag Closed Cup:	>200°F. Will not support combustion
Volume Solids (Avg. varies by color):	35.5% average
Shipping Weight (varies by color):	1 gallon container: 12 lbs 5 gallon quart container: 53 lbs
Shelf Life:	1 year minimum
Theoretical Coverage Per Gallon:	569 ft ² /gal at 1 mil DFT 284 ft ² /gal at 2 mil DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Suggested Film Builds:	5.5 mils (138 µm) wet 2.0 mils (50 µm) dry
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Application by brush and roller may require additional coats to achieve recommended films thickness.

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between 35°F (2°C) and 120°F (48°C). Tufcote 1.9 HG-D may settle. Agitate before each use.

THEORETICAL VOC

VOC less water and exempt compounds

Tufcote 1.9 HG-D 1.9 lbs/gal (228 g/l) max

NOTE: In order to achieve certain color positions the VOC might be above 1.9 lbs/gal. Please consult Axalta for exact color VOC level.



ASTM INFORMATION

Physical properties for Tufcote 1.9 HG-D are averages. For other system recommendations, please contact Axalta Coating Systems.

TEST	RESULTS
Adhesion (ASTM D4541):	400 psi Chemical Passed 24 hour spot test (Water, dilute inorganic acid (5%), dilute acetic acid, sodium hydroxide, aliphatic hydrocarbons, aromatic hydrocarbons, alcohols, esters (butyl acetate), gasoline, motor oil)
Color/Gloss Retention	Excellent
Dry Heat Resistance (ASTM D2485)	300°F
Flexibility (ASTM D1737)	180° bend 1/8" mandrel
Impact Resistance (ASTM G14)	1 week cure 1 month cure
Moisture Condensation (ASTM D2247)	100°F, 300 hours
Pencil Hardness (ASTM D3363)	2B
Salt Fog (ASTM B117)	3 mil DFT 300 hours
Weather	Very Good
Flash rust	Excellent

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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