



Tufcote™ 3.5 FT-D™ Flat Gloss DTM



GENERAL

DESCRIPTION

A flat gloss, single package, 3.5 lbs/gal VOC conforming polyester modified alkyd base coat. The resulting coating is designed to dry fast and to provide a very durable system when topcoated with Imron® clear polyurethane topcoats.

SUGGESTED USES:

As a quality flat gloss color base coat on carbon steel where:

- Fast dry times are required
- High build, single package color base coat is required
- Self-priming, Direct-To-Metal (DTM) coating is required
- Application by brush, roll or spray is required

NOT RECOMMENDED FOR:

- Immersion service
- Severe corrosive and/or harsh chemical service where mechanical damage is likely
- Galvanized Steel
- Exterior exposure without topcoat

COMPATIBILITY WITH OTHER COATINGS

Must be topcoated with Imron 3.4 HG-C™ (610P) or Imron 3.5 HG-C™ (611P) clearcoat. Can be applied over old, intact coatings. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact Axalta Coating Systems for specific recommendations.

PERFORMANCE PROPERTIES

Chemical	Excellent
Humidity	Excellent
Weather	Excellent

COLOR

Can be manufactured in a variety of colors. Contact your Axalta representative.

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



MIXING

COMPONENTS

Tufcote 3.5 FT-D 1, 5 and 55 gallon containers

ACTIVATION

No activation required.

MIXING AND REDUCTION

This product must not be reduced to comply with maximum VOC of 3.5 lbs/gallon. Material may be applied as packaged.

APPLICATION THINNERS

None required in order to maintain VOC compliance at 3.5 lbs/gal. If thinning is required, use TY-3810™.

INDUCTION TIME

None



POT LIFE
Infinite.

APPLICATION

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is below 40°F (4°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

Commercial Blast to an SSPC-SP6 specification is highly desired. If this is not possible, then hand clean to an SSPC-SP2 specification, or power tool clean to an SSPC-SP3 specification, with some reduction in performance.

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.

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:	63BSS	FF (1.4)	1.1
Pot Pressure:			12
Atomizing Pressure			36
Air Cap:	63PB	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)	94P

Airless Spray

Pump: Graco Extreme 33:1
Airless Gun: Graco 207945
Fluid Hose: 3/8" x 100' max.
Tips: 415-521
Minimum pressure to avoid fingering: 2400 psi min

CLEAN UP THINNERS

T-8805, MEK or Acetone



DRY TIMES

Cure Times at suggested DFT

	<u>77°F (25°C)</u>
To Touch	30 minutes
To Handle	2 hour
To Recoat	30-60 minutes
To Tape	45 minutes
Hard Dry	2 hours

Dry to recoat time of 30-60 minutes for spray. Recoat time by brush or roll is 72 hours.



PHYSICAL PROPERTIES

Maximum Service Temperature:	150°F (66°F) in continuous service 200°F (93°F) in intermittent heat
Gloss (ASTM D 523)	Flat
Weight Solids (Avg. varies by color):	70% ± 2% average
Weight per gallon-(Avg. varies by color):	11.8 lbs. ± 0.2 lbs/gal average
Flash Point-Tag Closed Cup:	Between 20°-73° F (-6-23° C)
Volume Solids (Avg. varies by color):	50% ± 2% average
Shipping Weight (varies by color):	1 gallon container: 12 lbs 5 gallon container: 61 lbs 55 gallon container: 645 lbs
Shelf Life:	1 year minimum
Theoretical Coverage Per Gallon:	802 ft ² (19.6 m ² /L) at 1 mil DFT
Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.	
Suggested Film Builds:	6-8 mils (150-200 µm) wet 3-4 mils (75-100 µm) dry

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 -30°F (-34°C) and 120°F (-48°C).

THEORETICAL VOC

VOC less water and exempt compounds

Tufcote 3.5 FT-D 3.5 lbs./gal. (420 gm/liter)

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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