



APPLICATION

SURFACE PREPARATION

Surface must be free of oil, grease, dirt, wax, silicone, powdery or scaling rust, loose or peeling paint and all other foreign matter. Smooth slick surfaces should be sanded to promote adhesion. Prime bare and uncoated surfaces with one of the following Tufcote primers: Tufcote Hydro 2.1 PR (1200 waterborne series), Tufcote LV PR (4400 series) or Tufcote Hydro LV PR (7900 waterborne series).

METAL SURFACES:

Aluminum surfaces should be properly treated. Surface preparations may include sanding, brush off blasting (SSPC-SP7), Alodine treatment, treatment with an acid, or other preparation necessary to ensure adhesion. All aluminums are not alike, it is strongly suggested that adhesion testing be done to assure system robustness.

Galvanized steel surface preparation may include detergent washing, pre-treatment and abrasion for new surfaces; for weathered surfaces, detergent washing and sanding. For new galvanized surfaces, acid treatments, degreasing and abrasion might be required before application of appropriate primer.

PAINTED SURFACES: Be sure all loose and peeling paint is completely removed, and the surface is clean. Remove excess chalkiness with a wire brush or by sanding. Feather edge and spot prime with Tufcote Primer.

WOOD SURFACES: Clean wood thoroughly. Prime and seal with one coat of Tufcote Primer or Tufcote Hydro (tinted close to finish color, if desired).

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Apply 2 coats, 1 to 2 hours apart, if possible, using conventional application methods and equipment.

CLEAN UP THINNERS

Clean pad applicators, brushes and rollers immediately after use with soap and cold water. Clean spray equipment immediately after use with water followed with Tufcote 8020 Zero VOC Exempt Solvent.



DRY TIMES

Cure Time at Recommended Thickness @ 50% RH

	77°F (25°C)
To Touch	30 minutes
To Handle	1-2 hours
Recoat Time	1-2 hours
Full Cure	7 days



PHYSICAL PROPERTIES

Viscosity	86 - 88 Kreb units @ 77°F
Volume Solids	27% - 33%
Weight Solids	32% - 47%
Theoretical Coverage Per Gallon	433 - 535 ft ² per gallon @ 1 mil DFT



Solvents Used	Glycol Ethers
Flash Point	>200°F/TCC
Gloss	Gloss 80+
Shelf Life	12 months
Recommended DFT	2-3 mils DFT (5-7 mils WFT)

Application by brush and roller may require additional coats to achieve recommended film thickness.

STORAGE CONDITIONS

Store in a dry, well-ventilated area. Storage conditions should be between 35°F (2°C) and 90° F (32° C). Do not allow product to freeze.

ASTM INFORMATION

PHYSICAL FILM PROPERTIES AFTER 7 DAYS OF AIR DRY

Adhesion:	Cross-hatch – 100% adhesion
Flexibility and Elongation:	1/2" Mandrel, no cracking
Hardness:	B
Accelerated Weathering:	500 hours, 90% gloss retention
Print and Block Resistance:	Good
Direct Impact:	80 in-lbs, no cracking
Reverse Impact:	80 in-lbs, no cracking

VOC REGULATIONS

VOC (Theoretical, varies with color).

Less than 2.1 lbs/gal (250 grams per liter).

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

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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