



# Tufcote™ LV HG- D

## Direct to Metal Urethane DX-8500 Series

(Formerly Ellis Decade DX-8500 Self-Priming Urethane)



### GENERAL

#### DESCRIPTION

Tufcote LV HG-D, DX-8500 series, is a two-component 0.8 lbs/gal (100 g/l) VOC solvent borne coating providing gloss, good durability and corrosion-resistance properties. Tufcote LV DTM DX-8500 is lead and chromate free.

#### SUGGESTED USES

As an economy coating for use on machinery, oil refineries, storage tanks, offshore platforms, piers, structural steel, steel decks over properly prepared ferrous, non-ferrous or painted surfaces where the following attributes are desirable:

- Exceptionally strong adhesion
- Chemical resistance
- Exceptional resistance to chipping abrasion
- Easy mixing
- Good Long term gloss

#### COLOR

Black, white, and tint bases

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



### MIXING

#### COMPONENTS

Tufcote LV-D DX-85844C Clear Base	1 gallon container (86 oz.)
Tufcote LV-D DX-85844D Deep Base	1 gallon container (102 oz.)
Tufcote LV-D DX-85844W White Base	1 gallon container (102 oz.)
Fac Pacs	1 gallon container (102 oz.)

Tufcote LV-D DX-8599 Activator                      Quart container (25.6 oz.)

#### MIX RATIO

Components	Parts by Vol.
Tufcote LV-D DX-8500 Base	4
Tufcote LV-D DX-8599 Activator	1

#### MIXING

Tufcote LV HG- D DX-8500 series must be mixed with DX-8599 Activator before the product can be used. The proper mixing ratio is 4:1. Mix four parts of Tufcote LV HG- D DX-8500 series with one part DX-8599 Activator. Stir thoroughly to a uniform mixture. Strain mixture prior to application. Mix no more material than will be used in a 2-hour period.

#### Reduction

If thinning is necessary, use 82 Super Gloss & Flow Zero VOC Reducer. Thin to desired viscosity after the Tufcote LV HG-D DX-8599 Activator has been added.

#### POT LIFE

2 hours @ 77°F

Pot life can be extended by adding Tufcote 82 Super Gloss & Flow Zero VOC Reducer. Pot life will be reduced as the ambient temperature rises above 77°F



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## APPLICATION

### APPLICATION CONDITIONS

Application at air and surface temperatures lower than 110°F (43°C) and above 50°F (10°C) and more than 5°F (-15°C) above the dew point is suggested.

### SURFACE PREPARATION

All surfaces to be painted must be clean, dry and in fit condition to be painted. Be sure to remove all wax, silicone, oil, powdery or scaling rust, loose or peeling paint and all other foreign matter. Smooth, slick surfaces should be sanded to achieve adhesion.

**BARE FERROUS METAL:** Clean off all dirt, grease, oil, wax or other foreign matter. All loose, powdery or scaling rust must also be removed. A completely de-rusted surface is recommended.

For best results on steel, abrasive blast surface to an SSPC-SP-6 Commercial Blast. Profile should be 2.0 to 2.5 mils. Average peak to valley surface profile shall be 1.5 to 2.5 mils. If blasting is not possible or practical, hand tool clean to an SSPC-SP 2 or power tool clean to an SSPC-SP 3 may be used with sacrifice in performance vs. blasted 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:** Tufcote LV HG-D DX-8500 may lift old paint. We recommend a test patch. If lifting occurs, remove old paint and follow directions for bare ferrous metals. 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.

### APPLICATION

Apply by spray, (or in small areas by brush or roller) in an even, wet coat to a minimum of 5 mils wet film (DFT of 2 mils) thickness. Give particular attention to all irregularities to ensure that they are completely covered. On a porous type substrate, the use of a thin or "mist" coat may be needed. If a second coat is needed, allow 15 minutes flash time.

### CLEAN UP THINNERS

Do not allow catalyzed material to stand in equipment after use. Equipment should be thoroughly cleaned immediately after use in an enclosed spray equipment cleaner with Tufcote 8020 Zero VOC Exempt Solvent.



## DRY TIMES

Cure Time at Recommended Thickness @ 50% RH

	<b>77°F (25°C)</b>
To Touch	20 minutes
To Handle	1 hour
Recoat Time	1 – 2 hours

RECOAT TIME: Recoat when material is relatively dry and firm (1-2 hours at 77°F and 50% RH), but before coating reaches complete cure and hardness. Check for desired film thickness and continuity. Allow final dry time of at least 5 days at 77°F. All solvent vapors should be removed before placing in service. Curing time is significantly shorter at higher temperatures or lower film thicknesses, and longer at lower temperatures or higher film thicknesses.



## PHYSICAL PROPERTIES

Viscosity	60 - 65 Kreb Units @77°F
Volume Solids	38-44%
Weight Solids	38-50%
Theoretical Coverage Per Gallon	607-705 ft <sup>2</sup> per gallon @ 1 mil DFT
Solvents Used	PCBTF/Acetate/Naptha/Xylene
Flash Point	76°F (Base), 109°F (Activator)
Gloss	80+ Gloss
Shelf Life	12 months
Recommended DFT	5 mils WFT (2 mils DFT)

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 90°F (32°C).

## VOC REGULATIONS

VOC (Theoretical, varies with color).

0.8 lbs/gal (100 grams per liter) or less

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.

## ASTM INFORMATION

### Film Properties:

Adhesion: ASTM D-3359  
Flexibility and Elongation: ASTM D-522  
Impact Resistance: ASTM D6905  
Mar Resistance:  
Pencil Hardness: ASTM D-3363  
Salt Spray: ASTM B117

Cross-Hatch. 5B. - 100% adhesion  
1/8" Mandrel, no cracking  
50lbs/in.  
Excellent  
F - H  
1,000 hours, No rust on un-scribed area.



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## **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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