



# Tufcote™ Hydro 220

## Zero VOC Universal Acrylic Primer



### GENERAL

#### DESCRIPTION

The Tufcote™ Hydro 220 is a universal single component acrylic primer designed to provide corrosion protection to steel surfaces during new construction and maintenance operations.

Product Highlights:

- Easy to apply
- High-build, Single coat
- Fast Dry
- Zero VOC
- Zero HAPs

#### SUGGESTED USES

The Tufcote™ Hydro 220 is recommended as an exterior coating for use on the following:

- Railcar Manufacturing and Maintenance
- Steel Fabrication
- OEM/Industrial Maintenance

#### COLORS AVAILABLE

Black  
Red Oxide  
Light Gray



### MIXING

#### COMPONENTS

Black, 220-B300-184

#### MIXING

The Tufcote™ Hydro 220 is a single component product. Mix paint thoroughly to a uniform consistency with low speed power agitation prior to use.

#### REDUCTION

No reduction necessary for airless spray.



### APPLICATION

#### SURFACE PREPARATION

For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants. If applying over previously installed coatings, test an inconspicuous area for lifting or softening of existing coating prior to full application. Do not use hydrocarbon solvents for surface preparation.

#### APPLICATION CONDITIONS

This product is designed for single-coat application and can be applied up to 8 mil DFT in a single coat. Multiple coats may be applied if desired.

Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising with a maximum relative humidity of 85%. Water condensation on the new film may cause surface imperfections and poor cure. Avoid placing freshly painted components outdoors under wet, rainy conditions.



**APPLICATION DATA**

Coating Thickness: 2-8 Mil DFT  
Coverage: 120 Sq. Ft/Gal @ 4 Mil DFT  
Full Cure: 30 Days @ 77°F  
Re-coat: 1-2 Hr. @ 77°F

**SPRAY APPLICATION**

**Airless Spray**

Pressure: 1,800 – 2,500 psi  
Tips: 0.017” – 0.021”

**Conventional Spray**

Spray Gun: Binks 95  
Fluid Nozzle: 66  
Air Nozzle: 63PB  
Atomizing Pressure: 60 psi  
Fluid Pressure: 20 psi

**BRUSH & ROLL APPLICATION**

These products may be applied by brush or roller for touch-up and repair.



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**DRY SCHEDULE**

Cure time in hours at 4 mil DFT (50%RH)

Temperature	Dry Touch	Dry-Handle
104° (40°C)	15 Min.	30 Min.
77°F (25°C)	30 Min.	1 Hr.
60°F (15°C)	1 Hr.	2 Hr.
50°F (10°C)	1.5 Hr.	3Hr.



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**PHYSICAL PROPERTIES**

Finish	Gloss
Mixed VOC	0.0 lbs./gal
Volume Solids	30% +/- 1%
Weight Solids	42% +/- 1%
Theoretical Coverage Per Gallon	481 ft <sup>2</sup> @ 1 mil DFT 120 ft <sup>2</sup> @ 4 mils DFT

**RECOMMENDED STORAGE CONDITIONS**

Store components between 55°F and 100°F. Store in dry shaded/covered conditions away from sources of heat and ignition. Do not allow product to freeze.

Shelf-Life, Part A, 24 Months-Unopened, 77°F  
Part B, 24 Months-Unopened, 77°F

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**SAFETY AND HANDLING**

Use soap and water to remove any material from hands or skin. Cleanup solvents or thinners are recommended to be used in accordance with each facilities Environmental, Health and Safety standards, regulations and procedures. Please and understand the Safety Data Sheet before using this product.