TNEMEC

PRODUCT DATA SHEET

TNEME-ZINC SERIES 90-88

PRODUCT PROFILE

GENERIC DESCRIPTION Waterborne Epoxy Zinc Rich Primer

COMMON USAGE An innovative, waterborne, zinc-rich epoxy primer that offers extended protection to steel surfaces. Its ultra-low VOC formulation cures quickly and provides outstanding long-term corrosion resistance when used with other Tnemec high-performance coatings.

COLORS Reddish-Gray

ZINC PIGMENT 81% by weight in dried film

COATING SYSTEM

INTERMEDIATE Series 1224
Note: An intermediate coat is required prior to topcoat application.

TOPCOATS Series 1040

SURFACE PREPARATION

STEEL **Severe Exposure:** SSPC-SP10/NACE 2 Near-White Metal Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils.
Moderate Exposure: SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

TECHNICAL DATA

VOLUME SOLIDS 75% ± 2%

RECOMMENDED DFT 2.5 to 3.5 mils (64 to 90 microns)

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75°F (24°C)	20 minutes	2 1/2 hours	16 hours

Curing time will vary with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 0.07 lbs/gallon (7.9 grams/litre)

HAPS **Unthinned:** 0.00 lbs/gal solids

THEORETICAL COVERAGE 1,199 mil sq ft/gal (29.4 m^2/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Three: Part A, Part B and Part C

PACKAGING

	Part A (partially filled)	Part B (partially filled)	Part C (partially filled)	When Mixed
Large Kit	1-5 gallon pail	1-1 gallon can	1-3 gallon pail	3.0 gallons (11.3 L)
Small Kit	1-half gallon can	1-quart can	1-1 gallon can	1.0 gallons (3.79 L)

NET WEIGHT PER GALLON 27.78 ± 0.25 lbs (12.60 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 40°F (4°C) Maximum 110°F (43°C)
PROTECT FROM FREEZING

TEMPERATURE RESISTANCE Continuous 250°F (121°C) Intermittent 300°F (149°C)

SHELF LIFE Part A: 12 months; Part B: 12 months; Part C: 12 months at recommended storage temperature

FLASH POINT - SETA Part A: >230°F (110°C) Part B: >230°F (110°C) Part C: N/A

HEALTH & SAFETY This product contains chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m^2/Gal)
Suggested	3.0 (75)	4.0 (100)	401 (37.3)
Minimum	2.5 (65)	3.5 (90)	481 (44.7)
Maximum	3.5 (90)	4.5 (115)	344 (31.9)

Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING Always use the entire contents of Part A, B and C components. Power mix contents of Part A, making sure no pigment remains on the bottom. Add the contents of the container marked Part B to Part A while under mechanical agitation until thoroughly mixed. Add water for thinning and mix until fully incorporated. Slowly sift in the Part C powder while under agitation. Adjust mixer speed as necessary to break up lumps. Continue mixing until thoroughly blended. Strain through a 35 to 50 mesh (300 to 600 microns) screen before using.

Do not use mixed material beyond pot life limits. **Note:** Both components must be above 50°F (10°C) prior to mixing. For application to surfaces between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C).

THINNING Thinning is required. Thin 25% by volume with clean water. **Important:** Thin with mechanical agitation only after Part B has been thoroughly mixed with Part A according to mixing instructions.

POT LIFE 3 hours at 75°F (24°C)

SPRAY LIFE 3 hours at 75°F (24°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Material Hose ID	Atomizing Pressure	Pot Pressure
Devilbiss JGA†	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	40-50 psi (2.8-3.4 bar)	10-20 psi (0.7-1.4 bar)

† (with heavy mastic spring) Low temperatures or longer hoses will require additional pressure. Use pressure pot equipped with an agitator and keep pressure pot at same level or higher than the spray gun. Compressed air must be dry.

Airless Spray

Tip Orifice	Atomizing Pressure	Material Hose ID	Manifold Filter
0.017"-0.021" (430-535 microns) Reversible Tip	4,000-4,400 PSI (276-303 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Roller: Use 1/4" or 3/8" (6.4 mm or 9.5 mm) high quality synthetic woven nap roller covers.
Brush: Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE Minimum 50°F (10°C) Maximum 110°F (43°C)

CLEANUP Flush and clean all equipment immediately after use with water.