PRODUCT PROFILE

Waterborne Epoxy Zinc Rich Primer

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

SOLID DESCRIPTION

Waterborne Epoxy Zinc Rich Primer

COMMON USAGE

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.

UNTHINNED

Unthinned: 0.07 lbs/gallon (7.9 grams/litre)

Unthinned: 0.00 lbs/gal solids

1,199 mil sq ft/gal (29.4 m²/L at 25 microns). See APPLICATION for coverage rates.

Three: Part A, Part B and Part C

PACKAGING

<table>
<thead>
<tr>
<th>Large Kit</th>
<th>Small Kit</th>
</tr>
</thead>
<tbody>
<tr>
<td>1-5 gallon pail</td>
<td>1-half gallon can</td>
</tr>
<tr>
<td>1-1 gallon can</td>
<td>1-quart can</td>
</tr>
<tr>
<td>1-3 gallon pail</td>
<td>1-1 gallon can</td>
</tr>
<tr>
<td>When Mixed:</td>
<td>3.0 gallons (11.3 L)</td>
</tr>
</tbody>
</table>

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

Part A: >230°F (110°C) Part B: >230°F (110°C) Part C: N/A

FLASH POINT - SETA

HAPS

Theoretical Coverage

1.199 mil sq ft/gal (29.4 m²/L at 25 microns). See APPLICATION for coverage rates.

PRODUCT DATA SHEET

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.

COLORS

- Reddish-Gray

MIXING

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 mechanical 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).

APPLICATION

COVERAGE RATES

Suggested | Dry Mils (Microns) | Wet Mils (Microns) | Sq Ft/Gal (m²/Gal)
--- | --- | --- | ---
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 mechanical 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.

Keep out of the reach of children.
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.

3 hours at 75°F (24°C)

3 hours at 75°F (24°C)

### Application Equipment

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Material Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>Devilbiss JGA†</td>
<td>E</td>
<td>765 or 70i</td>
<td>5/16&quot; or 3/8&quot; (7.9 or 9.5 mm)</td>
<td>3/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>40-50 psi (2.8-3.4 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
</tr>
</tbody>
</table>

*† (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

<table>
<thead>
<tr>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Material Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.017&quot;-0.021&quot; (430-535 microns) Reversible Tip</td>
<td>4,000-4,400 PSI (276-303 bar)</td>
<td>1/4&quot; or 3/8&quot; (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

### Rollers

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

### Brushes

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.

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