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SURFACE PREPARATION: All parts must be absolutely free of all oils, grease, moisture, dust, scale or corrosion.

METALS: For steel, sandblast with 80-100 grit aluminum oxide or similar. Softer metals, such as aluminum, use 100-120 grit aluminum oxide or similar at 35-40 PSI using a suction type blaster.

*NOTE: Phosphating may be preformed in lieu of sandblasting or in conjunction with the above mechanical etch.

FINAL CLEAN: Before spraying the part must be thoroughly cleaned using air blast, hot water rinse, solvent base rinse, or any other method that provides a clean dry surface. DO NOT USE petroleum-based solvents,

MIXING: Stir and shake well, it is best to mix in a food blender type mixer or any unit capable of producing high speed shear/dispersion. It is very important for all solids to be fully dispersed into the solution, including some that may need to be scraped off the bottom of the container. Provided ready to spray, however if desirable thin up to 10% by volume with DISTILLED WATER.

*NOTE: Use of non-distilled water may adversely affect product performance and void products warranty, whether express or implied.

PRIMER: No primer needed.

APPLICATION TEMPERATURES:

	<u>Material</u>	<u>Surfaces</u>	<u>Ambient</u>	<u>Humidity</u>
Normal	18-30°C	18-30°C	16-32°C	65-85%
Minimum	13°C	13°C	10°C	50%
Maximum	35°C	38°C	38°C	95%

SPRAY: Apply coating in light fog passes (approximately 20% overlap) to achieve a thickness of .001” to .0015”. Use sufficient air volume for correct operation of equipment. (Minimum 50 PSI) Minimum part temperature should be 65f, if below warm up part. Spray at a right angle to part with a 1mm or smaller nozzle size. Spray all irregular surfaces and edges first, making an extra pass later. Check part for complete coverage. Part should be a light green color.

SPRAY GUN & Mfr.: Any conventional unit. Recommended gravity feed type touch-up gun. (Important that nozzle size be 1mm or less)

DRYING TIME: Immediately, dry coating in an environment with temperatures in the range of, 100f to 110f. Part should change to a chalk white color. (Color determines when dry)

FINAL CURE: Typical: 260°C/500F for one hour at temperature.

***Note: If final cure is attained and recoat is necessary, special surface preparation may be required.

VENTILATION AND SAFETY: When used in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. The ventilating system should be capable of preventing fine particulate matter from exceeding TLV limits. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel. Where flammable solvents exist, explosion proof lighting equipment must be used. Hypersensitive persons should wear protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

CLEAN UP: Water

STORAGE CONDITIONS: (Store indoors)
 Temperature: 10-43°C Humidity: 0-100%

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