

TECH LINE Coatings

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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.

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 using a dispersion blade or any unit capable of producing high speed shear/dispersion. Provided ready to spray.

PRIMER: No primer needed.

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. Those instructions should be followed closely to obtain the maximum service from the materials.

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 .0002" to .0005". 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 150f. Part should change to a chalk white color. (Color determines when dry)

FINAL CURE: Minimum 350F. may be cured with the top coat at any temperature above 350F.

***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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Note: N/E = Not Established
N/A = Not Applicable