## Viking Paints, Inc. 100 W. 78<sup>th</sup> St.

100 W. 78<sup>th</sup> St. Richfield, MN 55423 www.vikingpaints.com

## PRODUCT & TECHNICAL DATA SHEET

PRODUCT LINE	TENACO <sup>®</sup> EPOXY PROTECTIVE COATINGS
PRODUCT NAME	TENACO <sup>®</sup> EPOXY TOP COAT
<b>MANUFACTURER</b>	Viking Paints, Inc.
DESCRIPTION	TENACO <sup>®</sup> EPOXY is a series of two-component coatings available in a variety of colors and primers, as well as clear. (We will also consider matching competitors color offerings, based on quantity.) It is quick air-drying, chemical hardening, and thermosetting. It can be forced dried to accelerate cure. The dried film is tough, durable, and flexible. It provides excellent adhesion on nearly every substrate.
BASIC USES	TENACO <sup>®</sup> EPOXY has been field tested since 1964 on many different substrates including steel, aluminum, masonry, and wood as well wood composition boards.
<u>TECHNICAL DATA</u>	Approved for use where there is incidental contact with food in establishments operating under the federal meat and poultry products inspection program (not for storing potable liquids). Heat and cold resistance: Passes 25 cycle heat (195 F) and cold (-35 F) Moisture Absorption: Less than .056% after 30 day immersion in water. Abrasion Resistance: ASTM falling sand coefficient of 19. Impact resistance: 173 in-lbs on 22 gauge steel. Chemical resistance: Resistive to many acids and alkalies. Fungus Resistance: Film showed negative to fungus growth.
PHYSICAL DATA	TENACO® EPOXY COLORSSOLIDS BY WEIGHT72.23% SOLIDS BY VOLUMEV.O.C. 400.887 g/L52.38%(based on TENACO® #100-WHITE with TENACO® Gloss Catalyst)For additional information, please refer to the Safety Data Sheet.
SURFACE PREPARATION	The surface must be clean and free from dirt, dust, grease, rust, and scale. For new steel surfaces: Solvent wash with TENACO <sup>®</sup> Epoxy thinner or a high grade lacquer thinner. For rusted, heavily scaled, or previously painted surfaces: Media blasting is the preferred method. For concrete surfaces: Call for preparation guidelines. For very hard surfaces such as Stainless Steel: Abrading the surface by blasting to create a roughened surface condition is usually very helpful in aiding adhesion. This must normally be determined by trial and error to see if the adhesion result is adequate for the proposed application. TENACO <sup>®</sup> EPOXY Primer is a two-part system. Thoroughly mix individual components, Epoxy-A & Catalyst-B first, before combining components. Always mix equal parts of epoxy and catalyst together first-before thinning the mixture. For best

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	results, use a shaker. The amount of thinner needed depends upon ambient temperature and type of spray equipment used. For finish coat start with 6 parts paint to 1 part TENACO <sup>®</sup> thinner. If TENACO <sup>®</sup> thinner is unavailable, use a high grade lacquer thinner formulated to thin epoxies.
<u>APPLICATION</u>	TENACO <sup>®</sup> EPOXY products work ideally with conventional air-atomizing spray equipment, as well as HVLP and airless equipment. (Can also be applied with brush or roller.) Once the components are mixed and thinned, TENACO <sup>®</sup> covers like most conventional finish coats. For best results using conventional spray equipment, components should be inducted or reacted for 30 to 40 minutes, with occasional stirring prior to application. Film thickness should be built up by applying successive thin coats of paint and allowing about 20 minutes "flash off" time between coats.
	For electrostatic application, if conductivity does not fall within the prescribed range for a given application the conductivity can be raised by adding a polar solvent, such as Klean-Strip L-27. The polar solvent may have to be added a number of different times in a number of different quantities before desired conductivity is reached, so be sure to record the amount added to each test batch before application.
CURE SCHEDULE	For best results paint and surface should be over 70° F. Can be force dried after solvent has been flashed off. Suggest 120°F for 15 minutes to speed cure time.
<u>COVERAGE</u>	Using conventional air atomizing spray equipment on a non-porous substrate, 1 gallon of thinned TENACO <sup>®</sup> EPOXY will cover approximately 350 square feet. On a porous substrate such as concrete, 1 gallon will cover approximately 250 square feet. If rolled will cover approximately 300 square feet per gallon.
PACKAGING	Available in 1 & 2-gallon kits, 5-gallon pails, and 55-gallon drums. All applications require equal parts of epoxy (Part-A) and catalyst (Part-B).
<u>DURABILITY</u>	Although continued outside exposures to ultra-violet light will oxidize (chalk) and color fade TENACO <sup>®</sup> EPOXY, it will retain its outstanding protective integrity. Resistant to Salt fog, and fungus growth. Chemically resistant to acids and alkalies. Moisture Resistance: - Less than .056% after 30 day immersion in water.
<u>WARRANTY</u>	The manufacturer warrants all materials to be free from defects and will replace any material proven to be defective when applied according to our specifications at no cost within a period of one year. No other warranties are implied or intended.