

Viking Paints, Inc.

100 W. 78th St.
Richfield, MN 55423
www.vikingpaints.com

Phone: 612-866-1212
Fax: 612-866-5821
E-mail: vikingpaints@earthlink.net

PRODUCT & TECHNICAL DATA SHEET

<u>PRODUCT LINE</u>	TENACO® EPOXY PRIMER																		
<u>PRODUCT NAME</u>	#50 GREY PRIMER #12-13 YELLOW PRIMER																		
<u>MANUFACTURER</u>	Viking Paints, Inc.																		
<u>DESCRIPTION</u>	TENACO® EPOXY Primer has been field tested since 1964. It contains Zinc Phosphate pigment as the anti-corrosive agent. ASTM B-117 test for rust creepage away from x-scribe on steel panel: rating of 10 on a scale of 0-10. 0-worst, 10-best.																		
<u>BASIC USES</u>	Rust inhibiting metal primer which can be used with most any painting system. Primers will not stain, shrink, or swell from sand scratches.																		
<u>PHYSICAL DATA</u>	<table><tr><td>PART-A EPOXY:</td><td>SOLIDS BY WEIGHT</td><td>66.65%</td></tr><tr><td></td><td>SOLIDS BY VOLUME</td><td>48.80%</td></tr><tr><td>PART-B CATALYST:</td><td>SOLIDS BY WEIGHT</td><td>61.55%</td></tr><tr><td></td><td>SOLIDS BY VOLUME</td><td>41.32%</td></tr><tr><td></td><td>DUST FREE:</td><td>1-HR</td></tr><tr><td>V.O.C.</td><td>471.55g/l</td><td></td></tr></table> <p>For additional information, please refer to the Safety Data Sheet.</p>	PART-A EPOXY:	SOLIDS BY WEIGHT	66.65%		SOLIDS BY VOLUME	48.80%	PART-B CATALYST:	SOLIDS BY WEIGHT	61.55%		SOLIDS BY VOLUME	41.32%		DUST FREE:	1-HR	V.O.C.	471.55g/l	
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<u>SURFACE PREPARATION</u>	<p>The surface must be clean and free from dirt, dust, grease, rust, and scale.</p> <p><u>For new steel surfaces:</u> Solvent wash with TENACO® Epoxy thinner or a high grade lacquer thinner.</p> <p><u>For rusted, heavily scaled, or previously painted surfaces:</u> Media blasting is recommended. If this is not practical, use other conventional methods.</p> <p><i>DO NOT USE OVER OLD PAINT OR UNCATALYZED PRIMERS.</i></p>																		
<u>MIXING INSTRUCTIONS</u>	TENACO® EPOXY Primer is a two-part system. Thoroughly mix individual components, Epoxy-A & Catalyst-B first, before combining components. Then measure and mix equal parts of epoxy and catalyst together. For best results, use a shaker. Allow 30 minutes induction time. Reduce with approximately 10-20% of TENACO® Epoxy thinner. If TENACO® Epoxy thinner is unavailable, use a high grade lacquer thinner formulated to thin epoxies. The amount of thinner needed depends upon ambient temperature and type of spray equipment used. For faster build, use less reduction.																		

APPLICATION

TENACO® 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® EPOXY covers like most conventional primers. For best results, 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.

TECHNIQUE

A film of the combined components A&B would yield a dry film by volume of $(40.33 + 41.28) / 2 = 40.80$. In other words, a wet film of 3 mils (.003) would yield a dry film of $3 \times .048 = 1.22$ mils.

Care must be taken in finish coating over epoxy primers. If film has not cured sufficiently, the catalyst component may migrate into the finish coat producing a cheese like result. For rush jobs, induct parts A&B for 2-3 hours before applying., or use FAST TENACO® EPOXY PRIMER CATALYST, with no induction necessary. This will cut the cure rate to approximately 1/2 the time.

Top coats must be applied no sooner than 12 hours after last prime coat, and no later than 36 hours, otherwise primer coat must be scuffed prior to top coating. When using FAST CATALYST, top coating can occur in the range of 6 - 18 hours.

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.

COVERAGE

Using conventional air atomizing spray equipment on a non-porous substrate, 1 gallon of thinned TENACO® EPOXY will cover approximately 300-350 square feet.

PACKAGING

Available in 1-gallon kits, 2-gallon kits, 5- gallon pails, and 55-gallon drums. All applications require equal parts of epoxy (Part-A) and catalyst (Part-B).

WARRANTY

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.