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**PRODUCT & TECHNICAL DATA SHEET**

**PRODUCT LINE**

TENACO® EPOXY PRIMER

**PRODUCT NAME**

**#19-90 BLACK AND WHITE  
(USE FAST CATALYST)**

**MANUFACTURER**

Viking Paints, Inc.

**DESCRIPTION**

TENACO® EPOXY 19-90 Primer is a high solids catalyzed primer with excellent filling capabilities. It has been extensively field tested since 1990. 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 9 on a scale of 0-10. 0-worst, 10-best. This product is designed to be the first primer applied to bare substrates.

**BASIC USES**

Metal primer which can be used with most any painting system -- #19-90 Primer will not stain, shrink, or swell from sand scratches.

**PHYSICAL DATA**

PART-A EPOXY:	SOLIDS BY WEIGHT	63.13%
	SOLIDS BY VOLUME	43.59%
PART-B CATALYST:	SOLIDS BY WEIGHT	55.96%
	SOLIDS BY VOLUME	37.62%
	COLOR MEDIUM / LIGHT GRAY	
	DUST FREE: 1-HR	

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® Epoxy thinner or a high grade lacquer thinner.

For rusted, heavily scaled, or previously painted surfaces: Media blasting is recommended. If this is not practical, use other conventional methods.

***DO NOT USE 19-90 PRIMER OVER OLD PAINT OR UNCATALYZED PRIMERS.***

**MIXING  
INSTRUCTIONS**

TENACO® EPOXY 19-90 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. 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.

**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. (standard catalyst) With 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. On a porous substrate such as concrete, 1 gallon will cover approximately 250 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.