



TNEMEC PRIMERS SERIES 10

PRODUCT PROFILE

- GENERIC DESCRIPTION** Modified Alkyd
- COMMON USAGE** Chemically active, rust-inhibitive primer for ferrous metals. Provides extended weathering for shop and field priming of structural and miscellaneous steel. Series 10-99W can also be used as a primer for wood substrates.
- COLORS** 99 Red, 1009 Gray, 99G Green, 99B Black, 99W White. **Note:** Minimum order quantities apply for 99G Green and 99B Black.
- PERFORMANCE CRITERIA** Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

- TOPCOATS** Series 2H, 2HS, 6, 30, 82HS, 113, 114, 115, 1028, 1029. **Note:** Some systems are not for use on surfaces that are continually wet or sweat frequently. Reference the applicable topcoat data sheet for additional information.
Note: Series 10 and V10 must cure three days before topcoating with Series 1028 or 1029.
Note: For field touch-up and VOC restricted areas, use Series V10.

SURFACE PREPARATION

- STEEL** SSPC-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning
 SSPC-SP6/NACE 3 Commercial Blast Cleaning when extended field exposure is expected.
- WOOD** Clean and dry.
- ALL SURFACES** Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

- VOLUME SOLIDS** 56.0 ± 2.0% †
- RECOMMENDED DFT** 2.0 to 3.5 mils (50 to 90 microns) per coat.
- CURING TIME**

	Temperature	To Handle	To Recoat
99, 99B 99G, 1009	75°F (24°C)	2-4 hours	12 hours
99W	75°F (24°C)	3-5 hours	12 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.

- VOLATILE ORGANIC COMPOUNDS** **Unthinned:** 2.98 lbs/gallon (357 grams/litre)
Thinned 10%: 3.30 lbs/gallon (395 grams/litre) †
- HAPS** **Unthinned:** 0 lbs/gal solids
Thinned 10%: 0 lbs/gal solids
- THEORETICAL COVERAGE** 898 mil sq ft/gal (22.0 m²/L at 25 microns). See APPLICATION for coverage rates. †
- NUMBER OF COMPONENTS** One
- PACKAGING** 55 gallon (208.2L) drums, 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.
- NET WEIGHT PER GALLON** 12.45 ± 0.25 lbs (5.65 ± .11 kg) †
- STORAGE TEMPERATURE** Minimum 20°F (-7°C) Maximum 110°F (43°C)
- TEMPERATURE RESISTANCE** (Dry) Continuous 200°F (93°C) Intermittent 250°F (121°C)
- SHELF LIFE** 24 months at recommended storage temperature.
- FLASH POINT - SETA** 100°F (38°C)
- HEALTH & SAFETY** Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

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APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.5 (115)	359 (33.4)
Minimum	2.0 (50)	3.5 (90)	449 (41.7)
Maximum	3.5 (90)	6.5 (165)	257 (23.9)

Allow for overspray and surface irregularities. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. †

MIXING

Stir thoroughly, making sure no pigment remains on the bottom of the can.

THINNING

Use No. 1 Thinner or mineral spirits. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, roller or brush thin up to 5% or 1/4 pint (190 mL) per gallon.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss MBC or JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	60-80 psi (4.2-5.5 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	1800-3000 psi (124-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Use high quality synthetic woven nap covers, 1/4" nap for smooth surfaces, 3/8" nap for rough surfaces.

Brush: Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or mineral spirits.

† Values may vary with color.

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