



PRODUCT PROFILE

GENERIC DESCRIPTION Advanced Thermoset Solution Fluoropolymer

COMMON USAGE A high-solids fluoropolymer coating that provides an ultra-durable finish with user friendly brush, roll and spray application. It has outstanding color and gloss retention even in the most severe exposures. Under certain conditions, it may be used to restore aged fluoropolymer coil applied coatings or for OEM applications. Contact Tnemec Technical Services or your local Tnemec representative for details.

COLORS Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. The preceding coat should be in the same color family, but noticeably different. Upon selection of the finish coat color (Series 1070), the intermediate coat color will be selected by Tnemec's color lab.

FINISH Gloss

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Series 27, 66, 90-97, 135, 161, 394. **Note:** Series 394 requires an intermediate coat prior to topcoating with Series 1070.

INTERMEDIATE Series 73, 1075, 1075U (Intermediate coat may be required for some applications, please contact Tnemec.) **Note:** When topcoating with Series 1070, the following maximum recoat times apply: Over 27, 66, 135 or 161, 14 days; over 1075, 1075U and itself, 30 days; over 90-97 or 73, 90 days.

TOPCOATS Series 1076

SURFACE PREPARATION

STEEL SSPC-SP6/NACE 3 Commercial Blast Cleaning

GALVANIZED STEEL & NON-FERROUS METAL Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.

AGED COATINGS Adhesion test patches are required. Contact Tnemec Technical Services or your Tnemec representative for recommendations.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 60.0 ± 2.0% (mixed) †

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns) per coat.

CURING TIME	Temperature	To Touch	To Handle	Minimum Recoat ‡
	90°F (32°C)	10 minutes	4 hours	5-8 hours
	70°F (21°C)	30 minutes	6-8 hours	10-12 hours
	50°F (10°C)	1 hour	12-15 hours	16-24 hours

‡ Maximum recoat: 30 days. Curing time varies with surface temperature, air movement, humidity and film thickness. **Note:** For faster curing and low-temperature applications, add No. 44-710 Urethane Accelerator; see separate product data sheet.

VOLATILE ORGANIC COMPOUNDS **Unthinned:** 2.93 lbs/gallon (351 grams/litre)
Thinned 5% (No. 63 Thinner): 3.10 lbs/gallon (371 grams/litre) †

HAPS **Unthinned:** 4.1 lbs/gal solids
Thinned 5% (No. 63 Thinner): 4.1 lbs/gal solids

THEORETICAL COVERAGE 962 mil sq ft/gal (23.6 m²/L at 25 microns). †

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Five (Part A) to one (Part B)

PACKAGING	PART A	PART B	Yield (mixed)
Medium Kit	5 gallon pail partially filled	1/2 gallon pail	3 gallons (11.35L)
Small Kit	1 gallon can partially filled	1 quart can partially filled	1 gallon (3.79L)

NET WEIGHT PER GALLON 11.49 ± 0.25 lbs (5.21 ± .11 kg) (mixed) †

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE (Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA Part A: 81°F (27°C) Part B: 130°F (54°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.

FLUORONAR® | SERIES 1070

APPLICATION

COVERAGE RATES

	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.0 (100)	385 (35.8)
Minimum	2.0 (50)	3.5 (90)	481 (44.7)
Maximum	3.0 (75)	5.0 (125)	321 (29.8)

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 contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. **Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Keep unused material tightly closed at all times.**

THINNING

For air spray, thin up to 5% or 1/4 pint (190 mL) per gallon with No. 63 Thinner. For roller, thin 5% to 8% per gallon with No. 63 Thinner. Thinning is required for proper application. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.** Use No. 51 Thinner for electrostatic spray application.

POT LIFE

5 hours at 50°F (10°C) 2 hours at 70°F (21°C) 1 hour at 90°F (32°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	704 or 765	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-90 psi (5.2-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure. Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Use 1/4" (6.4 mm) synthetic woven nap cover. Do not use medium or long nap roller covers.

Brush: Use high quality natural or synthetic bristle brushes.

Contact Tnemec Company for information on electrostatic application.

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.

Cure time necessary to resist direct contact with moisture at surface temperature:

40°F (4°C): 44 hours	50°F (10°C): 21 1/2 hours	60°F (16°C): 11 hours
70°F (21°C): 7 hours	80°F (27°C): 5 hours	90°F (32°C): 3 1/2 hours
100°F (38°C): 2 hours		

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty-appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

CLEANUP

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

† Values may vary with color.

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