



FLUORONAR® CLEAR SERIES 1076

PRODUCT PROFILE

GENERIC DESCRIPTION	Advanced Thermoset Solution Fluoropolymer Clear
COMMON USAGE	An exterior clear fluoropolymer finish coat especially designed to enhance the exterior weatherability of Fluoronar and HydroFlon. Fluoronar Clear has outstanding resistance to ultra-violet light providing extended color and gloss retention. An indicator dye is provided to aid in application.
COLORS	Clear. Note: 44-500 will change the appearance to a violet tint during application. After a period of up to 72 hours of sunlight exposure, appearance will be clear.
FINISH	High gloss
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

BASE COATS Series 700, 1070, 1078. **Note:** Series 1076 should be applied within 14 days of a Series 700, 1070 or 1078 application.

SURFACE PREPARATION

ALL SURFACES Prepare surfaces by method suitable for exposure and service. (See Base Coat Product Data Sheet for surface preparation recommendations.)
Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 56.7 ± 2.0% (mixed)
RECOMMENDED DFT 1.5 to 2.0 mils (40 to 50 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME	Temperature	To Touch	To Handle	Minimum Recoat †
	75°F (24°C)	1 1/2 hours	6-8 hours	24 hours

† Maximum recoat: 7 days. Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS	Unthinned: 3.18 lbs/gallon (381 grams/litre) Thinned 5%: 3.37 lbs/gallon (404 grams/litre)
THEORETICAL COVERAGE	910 mil sq ft/gal (22.3 m ² /L at 25 microns). See APPLICATION for coverage rates.
NUMBER OF COMPONENTS	Two: Part A and Part B
MIXING RATIO	By volume: Four (Part A) to one (Part B)
PACKAGING	Small Kit: Consists of a partially filled one-gallon can of Part A, a quart can of Part B and a foil package containing a vial of 44-500. When mixed yields one gallon (3.79L).
NET WEIGHT PER GALLON	9.26 ± 0.25 lbs (4.20 ± .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: 80°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.

APPLICATION

COVERAGE RATES		Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m²/Gal)
	Suggested	2.0 (50)	3.5 (90)	449 (41.7)
	Minimum	1.5 (40)	2.5 (65)	599 (55.6)
	Maximum	2.0 (50)	3.5 (90)	449 (41.7)

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	Small Kit: Add contents of the vial of 44-500 to Part A while under agitation. Mix thoroughly. Add contents of the quart can marked Part B to the mixture of Parts A and 44-500 while under agitation. Continue agitation until all components are thoroughly mixed. <i>Important: Mixing ratio is four (Part A) to one (Part B) by volume.</i> Do not use mixed material beyond pot life limits. Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Unused material must be kept tightly closed at all times.
THINNING	For air spray, thin up to 5% or 1/4 pint (190 mL) per gallon with No. 2 Thinner. For roller, thin 3% to 5% or 1/4 pint (190 mL) per gallon with No. 2 Thinner. Thinning is required for proper application. Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.
POT LIFE	5 hours at 50°F (10°C) 2 hours at 70°F (21°C) 1 hour at 90°F (32°C)

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APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	78	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 nap cover. Do not use medium or long nap roller covers.

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.

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

60°F (16°C): 6 hours	70°F (21°C): 3 hours	80°F (27°C): 2 hours
90°F (32°C): 1 hour	100°F (38°C): 30 minutes	

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.

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