



TNEMEC PRIMERS SERIES V10

PRODUCT PROFILE

- GENERIC DESCRIPTION** Modified Alkyd
- COMMON USAGE** Chemically active, rust-inhibitive primer for ferrous metals. This low VOC primer 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.

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** 57 ± 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:** 2.80 lbs/gallon (335 grams/litre)
Thinned 1%: 2.84 lbs/gallon (340 grams/litre)
- HAPS** **Unthinned:** 0 lbs/gal solids
Thinned 1%: 0 lbs/gal solids
- THEORETICAL COVERAGE** 917 mil sq ft/gal (22.5 m²/L at 25 microns). See APPLICATION for coverage rates.
- NUMBER OF COMPONENTS** One
- PACKAGING** 55 gallon (208.2 L) drums, 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.
- NET WEIGHT PER GALLON** 12.69 ± 0.25 lbs (5.76 ± .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) | 366 (34.0) |
| Minimum | 2.0 (50) | 3.5 (90) | 457 (42.5) |
| Maximum | 3.5 (90) | 6.0 (150) | 261 (24.3) |

Allow for overspray and surface irregularities. Wet 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

THINNING

APPLICATION EQUIPMENT

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

Use No. 1 Thinner or mineral spirits. May thin up to 1% or 1.25 ounces per gallon.

Air Spray

| Gun | Fluid Tip | Air Cap | Air Hose ID | Mat'l Hose ID | Atomizing Pressure | Pot Pressure |
|---------------|-----------|------------|----------------------------------|----------------------------------|----------------------------|----------------------------|
| DeVilbiss 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) | 60-90 psi (4.2-6.2 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 |
|------------------------------------|--------------------------------|---------------------------------|--------------------------|
| 0.011"-0.017" (280-430 microns) | 3000-4000 psi (207-276 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.

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