



LOW VOC TNAME-GLOSS SERIES 2HS

PRODUCT PROFILE

GENERIC DESCRIPTION Alkyd

COMMON USAGE A low VOC, high solids, high gloss industrial enamel offering good flow, hiding and protection for recommended surfaces in mild to moderately severe exposures. Not for use on surfaces that are continually wet or sweat frequently.

COLORS Refer to Tnemec Color Guide.

FINISH Gloss

PERFORMANCE CRITERIA Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS **Steel:** Series 1, 10, V10, 27WB, 37H, 66, N69, 88HS, 530
Galvanized Steel and Non-Ferrous Metal: Series 27WB, 66 or N69. **Note:** Series 66 or N69 exterior exposed for 3 weeks or longer requires an epoxy-polyamide intermediate coat or scarification prior to topcoating with 2HS. Brush blasting with fine abrasive is the preferred method of scarification.
Wood: Series 10-99W, V10-99W

SURFACE PREPARATION

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants. Remove rust and paint not tightly bonded. Spot prime.

TECHNICAL DATA

VOLUME SOLIDS 81.0 ± 2.0% †

RECOMMENDED DFT 1.5 to 3.5 mils (40 to 90 microns) per coat. **Note:** Number of coats required will vary depending on color, substrate (surface) and other variables. Contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75° (24°C)	5 hours	18 hours	24 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.
Water Tank Exteriors: Five days or more curing time required before filling with water.

VOLATILE ORGANIC COMPOUNDS

Unthinned: 2.09 lbs/gallon (250 grams/litre)
Thinned 5% (No. 49 Thinner): 2.09 lbs/gallon (250 grams/litre)
Thinned 5% (No. 1 Thinner): 2.29 lbs/gallon (275 grams/litre)

HAPS 0.32 lbs/gallon solids

THEORETICAL COVERAGE 1,299 mil sq ft/gal (31.9 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS One

PACKAGING 55 gallon (208.2 L) drums, 5 gallon (18.9 L) pails and 1 gallon (3.79 L) cans

NET WEIGHT PER GALLON 10.95 ± 0.25 lbs (4.97 ± .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 12 months at recommended storage temperature.

FLASH POINT - SETA 113°F (45°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 use of this product.
Keep out of the reach of children.

LOW VOC TNEME-GLOSS | SERIES 2HS

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	1.5 (40)	2.0 (50)	866 (80.5)
Minimum	1.5 (40)	2.0 (50)	866 (80.5)
Maximum	3.5 (90)	4.5 (115)	371 (34.5)

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. for air spray, airless spray, brush or roller, thin up to 5% or 1/4 pint (190 mL) per gallon. **Note:** Where lower VOC is required, 5% of No. 49 Thinner may be used to comply with VOC regulations.

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	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	50-70 (3.4-4.8 bar)	20-30 psi (1.4-2.1 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.013"-0.017" (330-430 microns)	3400-4800 psi (241-312 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 nap covers. Use 1/4" to 1/2" (6.4 mm to 12.7 mm) nap, depending on surface roughness.

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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