



PRODUCT PROFILE

**GENERIC DESCRIPTION** Hydrophobic Acrylic Polymer

**COMMON USAGE** An advanced technology, direct-to-metal, corrosion-inhibiting coating with very good early flash-rust resistance, as well as long term corrosion protection and weathering properties. Formulated to resist mildew growth on the paint film. Provides good gloss and color retention on structural steel, tanks, towers, pipes and similar structures. May also be used on a wide range of other substrates and many aged coatings, interior or exterior (test patch is recommended per Technical Bulletin 98-10). Application methods include "dry-fall" under certain conditions (see Application).  
**Note:** Sprra-Saf EN's "dry-fall" characteristics help reduce the potential for overspray problems on buildings and surrounding property.

**COLORS** Refer to Tnemec Color Guide.

**FINISH** Satin

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

COATING SYSTEM

**PRIMERS** **Steel:** Self-priming or Series 10, 27, 37H, 66, L69, N69, N69F, 90E-92, 115, 135, L140, L140F, N140, 151, 161.  
**Note:** Allow Series 10 and 37H to cure one week before topcoating.

**TOPCOATS** Series 30, 1028, 1029

SURFACE PREPARATION

**STEEL** **Weather Exposed:** SSPC-SP6/NACE 3 Commercial Blast Cleaning  
**Enclosed or Protected:** SSPC-SP3 Power Tool Cleaning

**GALVANIZED STEEL & ALUMINUM** Surface preparation suggestions will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.

**PAINTED SURFACES** Remove chalk and old paint not tightly bonded to the surface. Clean all visible rust to bare metal using SSPC-SP11 Power Tool Cleaning to Bare Metal. Feather edges of thick coatings and dull glossy surfaces. (Test patch is recommended in accordance with Technical Bulletin 98-10R latest revision.)

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

TECHNICAL DATA

**VOLUME SOLIDS** 38.0 ± 2.0% †

**RECOMMENDED DFT** 2.0 to 4.0 mils (50 to 100 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°F (24°C)	1 hour	3 hours

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

**VOLATILE ORGANIC COMPOUNDS** **Unthinned:** 1.60 lbs/gallon (192 grams/litre)  
**Thinned 5%:** 1.60 lbs/gallon (192 grams/litre) †

**HAPS** **Unthinned:** 1.03 lbs/gal solids  
**Thinned 5%:** 1.03 lbs/gal solids

**THEORETICAL COVERAGE** 610 mil sq ft/gal (15.0 m<sup>2</sup>/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** 10.39 ± 0.25 lbs (4.7 ± .11 kg) †

**STORAGE TEMPERATURE** Minimum 40°F (4°C) Maximum 95°F (35°C)

**TEMPERATURE RESISTANCE** (Dry) Continuous 170°F (77°C) Intermittent 200°F (93°C)

**SHELF LIFE** 12 months at recommended storage temperature.

**FLASH POINT - SETA** Non-flammable

**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.**

# SPRA-SAF EN® | SERIES 30

## APPLICATION

### COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Suggested	3.0 (75)	8.0 (205)	205 (19.0)
Minimum	2.0 (50)	5.5 (140)	305 (28.3)
Maximum	4.0 (100)	10.5 (265)	155 (14.4)

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

Mix by stirring to uniform consistency without creating air bubbles and foam. Stir thoroughly, making sure no pigment remains on the bottom of the can. Do not box or use a paint shaker.

### THINNING

Use only clean tap water. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, brush or roller, 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 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)	50-70 psi (3.4-4.8 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
0.013"-0.017" (330-430 microns) Reversible Tip	1800-2400 psi (124-165 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.

**Note:** On projects involving spray equipment being used over consecutive days, follow Cleanup instructions below and then leave xylol in the system overnight, flushing thoroughly with clean water before each start-up.

**Roller:** Application not recommended.

**Brush:** Recommended for small areas only. Use only synthetic or nylon bristle brushes.

### SURFACE TEMPERATURE

Minimum 45°F (7°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: At 75°F (24°C): 1 hour. At 45°F (7°C): 3 hours.

### CLEANUP

Flush and clean all equipment immediately after use with clean tap water. Finish by flushing all spray equipment with isopropyl alcohol. Wash brushes in water to remove paint build-up during and after application.

### CAUTION

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

† Values may vary with color.

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