TNEMEC

PRODUCT DATA SHEET

# EPOXY ACCELERATOR SERIES 44-700

## PRODUCT PROFILE

**GENERIC DESCRIPTION** Modified Amine

**COMMON USAGE** Special additive for use with select epoxies to accelerate the cure rate and allow for coating application at temperatures down to 35°F (2°C).

**COLORS** Clear Amber

**SPECIAL QUALIFICATIONS** Series 44-700 Epoxy Accelerator is considered by **NSF International** as an **NSF /ANSI Std. 61** certified component of Series L140, N140, V140 and 1220 when used in potable water applications.

**CAUTION** Adding Series 44-700 Accelerator to Series L69, N69, L140, N140 and V140 will:
1. Increase gloss 10 or more units on 60 degree meter.
2. Slightly decrease acid resistance.
3. Produce slightly yellower white and pastel colors.
4. Substantially change some clean yellow, green, orange and red colors.

## TECHNICAL DATA

**VOLUME SOLIDS** 100%

**CURING TIME**

With: Series L69, N69, L140 or V140

| Temperature | To Touch | To Handle | To Recoat | Immersion |
|---|---|---|---|---|
| 75°F (24°C) | 2 hours | 4 hours | 5 hours | 7 days |
| 65°F (18°C) | 3 hours | 7-8 hours | 9-11 hours | 8 days |
| 55°F (11°C) | 5-6 hours | 12-14 hours | 16-20 hours | 9-10 days |
| 45°F (7°C) | 7-8 hours | 18-22 hours | 28-32 hours | 12-13 days |
| 35°F (2°C) | 9-11 hours | 28-32 hours | 46-50 hours | 16-18 days |

Curing time varies with surface temperature, air movement, humidity and film thickness.
**Note:** See the Series L69, N69, L140, N140 or V140 product data sheet for cure times for potable water applications.

With: Series 27WB or 1220

| Temperature | To Touch | To Handle | To Recoat |
|---|---|---|---|
| 75°F (24°C) | 1 hour | 4 hours | 5 hours |
| 55°F (11°C) | 1 1/4 hours | 5 hours | 6 hours |
| 45°F (7°C) | 1 1/2 hours | 5 hours | 7 hours |
| 35°F (2°C) | 3 hours | 3 days | 4 days |

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

**VOLATILE ORGANIC COMPOUNDS** 0 lbs/gallon (0 grams/litre)

**PACKAGING** Individual graduated plastic quarts (0.95 L). Also in multiple 4-quart convenience pack.

**NET WEIGHT PER GALLON** 8.10 ± 0.10 lbs (3.67 ± .11 kg)

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

**SHELF LIFE** 24 months at recommended storage temperature.

**FLASH POINT - SETA** None

**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

**MIXING**

With: Series L69, N69, L140, N140 or V140
Stir contents of Series L69, N69, L140, N140 or V140 Part A and Part B separately, making sure no pigment remains on the bottom. Accurately add four (4) fluid ounces of 44-700 per gallon of Part A while Part A is under agitation. Continue agitation until thoroughly mixed. Next, add this mixture to Part B while under agitation. Continue agitation until thoroughly mixed. **Note:** Components should be above 50°F (10°C) prior to mixing. For application to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, the material temperature should be above 60°F (16°C). **Note:** The use of more than the recommended ratio of 44-700 will adversely affect coating performance.

With: Series 27WB or 1220
Prior to adding Series 44-700, properly mix the Series 27WB or 1220 components according to the mixing instructions listed on the product data sheet. Accurately add one (1) fluid ounce of 44-700 per mixed gallon of material. Continue agitation until thoroughly mixed. For optimum mixing and application properties, the material temperature should be between 70°F and 85°F (21°C and 29°C). **Note:** The use of more than the recommended ratio of 44-700 will adversely affect coating performance.

**POT LIFE**

With: Series L69, N69, L140, N140 or V140
2 hours at 50°F (10°C) 1 hour at 75°F (24°C) 30 minutes at 100°F (38°C).

With: Series 27WB or 1220
2 hours at 40°F (4°C) 1 1/2 hours at 60°F (15°C) 45 minutes at 75°F (24°C).
**Note:** Series 44-700 Accelerator is not recommended for use with Series 27WB or 1220 when temperatures exceed 75°F (24°C).

# EPOXY ACCELERATOR | SERIES 44-700

**SPRAY LIFE**

With: Series L69, N69, L140, N140 or V140
30 minutes at 75°F (24°C)
**Note:** Spray application after listed times will adversely affect ability to achieve recommended dry film thickness.

With: Series 27WB or 1220
1 1/2 hours at 40°F (4°C) 45 minutes at 75°F (24°C)

**SURFACE TEMPERATURE**

Minimum 35°F (2°C) Maximum 135°F (57°C)
Cure time necessary to resist direct contact with moisture at surface temperature when used with Series 27WB or 1220

| Temperature | To Resist Moisture |
|---|---|
| 75°F (24°C) | 5 hours |
| 55°F (13°C) | 16 hours |
| 45°F (7°C) | 24 hours |
| 35°F (2°C) | 4 days |