



PRODUCT PROFILE

GENERIC DESCRIPTION	Moisture-Cured Aromatic Urethane
COMMON USAGE	Aluminum pigmented primer or finish for marginally cleaned steel. Provides excellent abrasion-, moisture-, chemical- and corrosion-resistance. Suitable for use as a topcoat where an aluminum finish is desired. Topcoating provides enhancement of systems and more latitude with color. Compatible with aged coatings, but verify with test patch.
COLORS	Aluminum
FINISH	Matte
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

TOPCOATS	Series 2H, 23, 27, 66, N69, 73, 113, 114, 161, 175, 530, 700, 1070, 1071, 1072, 1074, 1075, 1077 Note: Series 530 exterior (sunlight) exposed for 24 hours or longer requires scarification or an intermediate coat of Series 27, 66 or N69 prior to topcoating with itself (530), 73, 175, 700, 1070, 1071, 1072, 1074, 1075 or 1077. Also if exterior exposed for 7 days or longer, 530 requires scarification or an intermediate coat of 27, 66 or N69 prior to topcoating with 113 or 114. The intermediate coat color should be noticeably different but in the same family as the specified topcoat color.
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SURFACE PREPARATION

STEEL	Moderate Exposure: SSPC-SP3 Power Tool Cleaning or SSPC-SP2 Hand Tool Cleaning Severe Exposure: SSPC-SP6 Commercial Blast Cleaning
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	51.0 ± 2.0%
RECOMMENDED DFT	2.0 to 3.0 mils (50 to 75 microns) per coat. Note: Number of coats required will vary depending on exposure conditions and other variables. Contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75°F (24°C) (50% Relative Humidity)	2 to 2-1/2 hours	2-1/2 to 3 hours	5 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.
Note: For faster curing and low-temperature applications, add No. 44-710 Urethane Accelerator; see separate product data sheet.

VOLATILE ORGANIC COMPOUNDS	Unthinned: 3.49 lbs/gallon (418 grams/litre)
THEORETICAL COVERAGE	818 mil sq ft/gal (20.1 m ² /L at 25 microns). See APPLICATION for coverage rates.
NUMBER OF COMPONENTS	One
PACKAGING	5 gallon (18.9L) pails and 1 gallon (3.79L) cans.
NET WEIGHT PER GALLON	9.16 ± 0.25 lbs (4.15 ± .11 kg)
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	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.

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	5.0 (125)	327 (30.4)
Minimum	2.0 (50)	4.0 (100)	409 (38.0)
Maximum	3.0 (75)	6.0 (150)	273 (25.3)

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. This product reacts with moisture. Viscosity will remain constant if material is kept dry. Keep unused material tightly closed at all times. Avoid vigorous agitation that will incorporate excessive amounts of humid air into the product.

THINNING

DO NOT THIN. Viscosity will remain constant provided the container is covered. See mixing instructions for further information.

OMNITHANE® | SERIES 530

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	78	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	60-80 psi (4.2-5.5 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)	1800-3000 psi (124-207 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.

Warning: Avoid contamination with alcohol type thinners.

Roller: Use carpet-type roller covers.

Brush: Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 35°F (2°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. **Caution: Application at film thicknesses exceeding 3.0 dry mils (75 microns) per coat or at relative humidities above 70% R.H. may cause bubbles to form in the cured film.**

CLEANUP

Flush and clean all equipment immediately after use with xylol.

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