



METALLIC CLEARCOAT SERIES 1079

PRODUCT PROFILE

GENERIC DESCRIPTION Aliphatic Acrylic Polyurethane

COMMON USAGE A unique clear coat used to both enhance the finish and extend the long-term weathering qualities of metallic pigmented coatings. Resists most graffiti markings. Series 44-500 (patent 5,548,010 and other patents pending), an optional indicator dye, is available to aid in uniform application. Where VOC regulations apply, this product can only be sold or used as part of a faux finishing coating system.

COLORS Clear. **Note:** 44-500 will temporarily change the appearance to a violet tint during application. After a period of up to 72 hours of sunlight exposure, appearance will be clear.

FINISH High gloss

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

COATING SYSTEM

BASE COATS Series 1077, 1078. **Note:** Series 1079 Metallic Clearcoat should be applied within 24 hours of a previous Series 1079 application and within 21 days of a 1077 or 1078 application.

SURFACE PREPARATION

ALL SURFACES Prepare by method suitable for exposure and service. (See Primer Product Data Sheet for surface preparation recommendations.)
Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 66.0 ± 2.0% (mixed)

RECOMMENDED DFT 1.0 to 2.0 mils (25 to 50 microns) per coat.

CURING TIME

Temperature	To Touch	To Handle	To Recoat	Maximum To Recoat †
75°F (24°C)	1-2 hours	2-3 hours	3 hours	24 hours

To resist moisture condensation: 3 hours.
Curing time varies with surface temperature, air movement, humidity and film thickness.
† If exceeded, scuff before applying an additional coat.

VOLATILE ORGANIC COMPOUNDS

Unthinned: 2.36 lbs/gallon (283 grams/litre)
Thinned 10%: 2.80 lbs/gallon (336 grams/litre)
Thinned 12%: 2.88 lbs/gallon (346 grams/litre)
Thinned 20%: 3.18 lbs/gallon (380 grams/litre)

THEORETICAL COVERAGE 1,059 mil sq ft/gal (26.0 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Three: Part A, Part B and Part C

MIXING RATIO By volume: Two (Part A) to one (Part B) Part C: See note under Mixing

PACKAGING Large Kit: Consists of two one-gallon cans of Part A, one one-gallon can of Part B, a one-quart plastic bottle of Part C and a foil package containing a vial of 44-500. When mixed yields 3.25 gallons.
Small Kit: Consists of a partially filled one-gallon can of Part A, a quart can of Part B, an eight-ounce plastic bottle of Part C and a foil package containing a vial of 44-500. When mixed yields .81 gallon.

NET WEIGHT PER GALLON 8.71 ± 0.20 lbs (3.95 ± .09 kg) (mixed)

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 Parts A, B & C: 12 months at recommended storage temperature.

FLASH POINT - SETA Part A: 110°F (43°C) Part B: 130°F (54°C) Part C: 102°F (39°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/Kit (m ² /Gal) Large Kit	Sq Ft/Kit (m ² /Gal) Small Kit
Suggested	1.5 (40)	2.0 (50)	2294 (213.3)	572 (53.1)
Minimum	1.0 (25)	1.5 (40)	3440 (320.0)	857 (79.6)
Maximum	2.0 (50)	3.0 (75)	1720 (160.0)	430 (40.0)

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

Note: Add Part C Accelerator according to the following chart.

Surface Temp. Range	Amount of Part C to Add (Small Kit - Parts A and B mixed)	Amount of Part C to Add (Large Kit - Parts A and B mixed)
40°F to 70°F (4°C to 21°C)	Full amount supplied (8 oz or 235 mL)	Full amount supplied (32 oz or 940 mL)
70°F to 80°F (21°C to 27°C)	50% of amount supplied (4 oz or 120 mL)	50% of amount supplied (16 oz or 470 mL)
Above 80°F (27°C)	25% of amount supplied (2 oz or 60 mL)	25% of amount supplied (8 oz or 235 mL)

Large Kit: Pour both gallon containers of Part A into a clean container large enough to hold all three components. Add Part C Accelerator and the vial of 44-500 to Part A while under agitation. Mix thoroughly. Add Part B to the mixture of Parts A, C and 44-500 while under agitation. Continue agitation until all components are thoroughly mixed. **Important:** Mixing ratio is two (Part A) to one (Part B) by volume.

THINNING

For air spray, use No. 2 Thinner and thin 10% or 3/4 pint (380 mL) to 20% or 1 1/2 pints (760 mL) per gallon. For roller or brush, use No. 39 Thinner and thin up to 10% or 3/4 pint (380 mL) per gallon. To comply with faux finishing VOC regulations, maximum thinning is 12%. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing. Thinning above 20% may adversely affect coating performance.**

POT LIFE

2 hours at 77°F (25°C) 30 minutes at 100°F (38°C)
Note: See chart at the beginning of Mixing instructions.

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 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	70-90 psi (4.8-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperature or longer hoses require higher pot pressure. Proper atomization is necessary to obtain a smooth finish. **Airless Spray:** Not recommended.

Roller: Use 1/4" (6.4 mm) synthetic woven nap cover. Do not use medium or long nap roller covers.

Brush: Recommended for small areas only. 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 xylol.

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