

TNEK

Epoxy Primer

09142016

DESCRIPTION

TNEK has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum. When mixed properly, TNEK is compliant with all known Canadian and US rules including SCAQMD Rule 1151..

COMPONENTS

- TNEK Epoxy Base Primer
- EXTNEK Epoxy Catalyst
- S065 or S075 Fast/Medium/Slow – Zero VOC Reducers
- S9860/9870/9885 Fast/Medium/Slow – Stand Reducers

MIXING RATIO

Mix one (1) part TNEK Epoxy Base to one (1) part TNEK Epoxy Catalyst. Reduce 15-25% with Northstar S065 or S075 Reducers to maintain 2.1 VOC. S9860, S9870, or S9885 may be used for non-compliant product areas.

POT LIFE AT 77° F

8 hours

CLEAN UP

Use NORTHSTAR Lacquer thinner or zero VOC solvents. (Check local regulations)

PHYSICAL DATA

Solids wt. (as mixed)	44 - 54%
VOC as mixed	2.1
Color	Light Gray

DRY / FLASH TIMES

Air Dry at 77° F

Flash between coats	30 minutes
To sand	Overnight
To topcoat	60 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	30 minutes at 140° F

GUN SETUPS

Conventional

Gravity Feed	1.5 mm – 1.8 mm
Siphon Feed	1.5 mm – 1.8 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	35 – 45 psi
Siphon Feed	40 – 50 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.

APPLICATION

- Apply 1 - 2 medium wet coats over substrate
- Allow 15 minutes between coats, 60 minutes to topcoat
- Scuff after 48 hour period
- Clean gun after spraying is completed

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.