

TRIPLE C INC

SABETHA, KS

Painter Training

7/23/13

NEXGEN

VLX18462-01 3.5 VOC GRAY LOW HAP'S ULTRA RUST INHIBITIVE PRIMER

PRODUCT DESCRIPTION:

- ❖ Latest in polymer and corrosion inhibitor technologies.
- ❖ It can be used as both a single component (1K) or two component (2K) mixed at a 10A:1B ratio with IG-0267.
- ❖ 3.5 VOC, Low HAP's primer
- ❖ Fast dry times along with excellent gloss holdout and corrosion resistance.

PHYSICAL PROPERTIES

- | | |
|------------------------|-----------------------------|
| ❖ Weight Solids | 71 % |
| ❖ Volume Solids | 52 % |
| ❖ Resin Type | Modified Epoxy Ester |
| ❖ Gloss | Satin |
| ❖ Theoretical Coverage | 832 ft ² @ 1 mil |
| ❖ Weight Per Gallon | 12.2 lbs. |
| ❖ VOC | 3.5 lbs/gallon |
| ❖ Viscosity @ 77°F | 23 - 25 seconds #2 Zahn |

SURFACE PREPARATION

- ❖ The service expectancy of a coating system is primarily dependent upon good surface preparation.
- ❖ The surface to be coated should be free of mill scale, rust, oil, and other contaminants.
- ❖ Minion acrylic enamels should always be applied over a primed substrate.
- ❖ Bare steel areas should be treated with iron phosphate conversion coatings with adequate rinsing.
- ❖ Aluminum or galvanizing should be treated with appropriate metal cleaners and conditioners, including a vinyl wash primer.
- ❖ For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils.
- ❖ Prime coat and then be coated before flash rusting occurs.
- ❖ Recommended primer systems
 - Single component EPEC
 - Two component Stratum urethane primer system.

REDUCTION

- ❖ For conventional air spray some reduction may be necessary.
- ❖ Thin sparingly with Butyl Acetate or other aromatic solvents (D-100 & D150)

APPLICATION

- ❖ Dry film thicknesses should be about 1 - 2 mils above surface profile.
- ❖ This will require wet film thicknesses of around 2 - 4 mils.
- ❖ Air Spray
 - Fluid Pressures
 - ✓ Conventional @ 50-55 psi range
 - Atomizing Air Pressures
 - ✓ Conventional @ 40-45 psi range

DRY TIMES

- ❖ Recoat at tack free 15 - 30 minutes.
- ❖ Force dried for 30 minutes at 140°F.
- ❖ Surface should be sanded for recoating after 24 hrs.

CLEAN UP

- ❖ Xylol to flush paint lines.
- ❖ N-9000 Gun Cleaner for removing dried coatings.

MINION

IC-9626 GLOSS BLACK ACRYLIC ENAMEL

PRODUCT DESCRIPTION

- ❖ Specifically developed for original equipment manufacturers
- ❖ High performance single component acrylic coating system.
- ❖ Offer excellent long term color and gloss retention.
- ❖ Very quick dry times
- ❖ Non-self lifting properties for easy touch-up and repair.

PHYSICAL PROPERTIES

- | | |
|------------------------|-----------------------------|
| ❖ Weight Solids | 41 % |
| ❖ Volume Solids | 35% |
| ❖ Resin Type | Acrylic |
| ❖ Gloss | Full |
| ❖ Theoretical Coverage | 569 ft ² @ 1 mil |
| ❖ Weight Per Gallon | 7.9 lbs. |
| ❖ VOC | 4.7 lbs/gallon |
| ❖ Viscosity @ 77°F | 45 - 48 seconds #2 Zahn |

REDUCTION

Three Minion acrylic reducers are available

1. N-9059 Fast - *for use when temperatures are below 70°F.*
2. N-9070 Medium - *for use when temperatures are 70° - 90° F.*
3. N-9090 Slow - *for use when temperatures are 90°+ F.*

- ❖ Conventional air spray reduce up to 50%
 - Do not exceed 1 part reducer to 2 parts paint
- ❖ Airless spray reduce approximately 20 - 30%.

N-7019 Minion Urethane Hardener

- ❖ For enhanced cure
- ❖ Gloss and abrasion resistance
- ❖ 8:1 ratio (pint per gallon).
- ❖ Fifteen minute induction time is required before thinning.
- ❖ Pot life will be approximately 24 hours.
- ❖ Always use over a primed surface.

IC-0635 Minion Clear Base

- ❖ May be used as a gloss additive.
- ❖ Mix up to 50% on the final coat.

APPLICATION

- ❖ Dry film thicknesses should be about 1-2 mils above surface profile.
- ❖ This will require wet film thicknesses of around 3-6 mils.
- ❖ Air Spray
 - Fluid Pressures
 - ✓ Conventional @ 50-55 psi range
 - Atomizing Air Pressures
 - ✓ Conventional @ 40-50 lb. range

DRY TIMES

- ❖ Recoat at tack free 15 - 30 minutes.
- ❖ Force dried for 30 minutes at 140°F.
- ❖ Surface should be sanded for recoating after 3 days.
- ❖ Do not apply at temperatures below 40° F.

CLEAN UP

- ❖ Xylol to flush paint lines.
- ❖ N-9000 Gun Cleaner for removing dried coatings.

Finishing Recommendations

Triple C Inc.

Date: 7/23/2013

Paint Product Code: IC-9626 Black Minion Acrylic

Reducing Solvents: Minion Reducers

Cold N-9059 (70 deg or lower)

Med N-9070 (70-90)

Hot N-9090 (90+)

Applied Viscosity: 25-30" #2 Zahn @ 77 deg F.

Application Method: Conventional Air Spray

Fluid Pressure: 50-55 psi

Tip or Nozzle Size: .055

Oven Type: Batch IR

Atomizing Air Pressure: 40-45psi

Paint Heater Temp: N/A

Oven Temp: N/A

Wet Film Thickness: 3-4 mils

Dry Film Thickness: 1-2 mils

Film Thickness Charting

Dry Film Thickness in mils / 2-3 mils desired

<u>Date</u>	<u>1.24.13</u>	<u>3.7.13</u>	<u>4.23.13</u>	<u>7.23.13</u>
Number of Reads	65	50	50	60
Mil Thickness:				
Average	1.43	1.53	1.51	2.47
High	3.04	3.51	2.76	3.55
Low	0.76	0.43	0.49	1.64

Comments: All dft's are much better and averages are within the desired range.
Overall the finish looks real good.

Coatings Reduction Chart

Product: IC-9626 GLOSS BLACK ACRYLIC ENAMEL

Blended Viscosity:
Recommended Reducer:

<u>Date</u>	<u>Lot Number</u>	<u>Paint Temp</u>	<u>Checked Viscosity</u>	<u>Additions / Type & Amount</u>	<u>Reduced Viscosity</u>
-------------	-------------------	-------------------	--------------------------	--------------------------------------	--------------------------