



RUUPAYWA: SONGS OF THE WATERSHED

Material Sample Review

San Francisco Arts Commission

Site	Alameda Creek Watershed Center
Artist	Walter Kitundu - Kitundu Studio in partnership with the Muwekma Ohlone Tribe
Fabricator	Vector Custom Fabrication
Engineering	Tipping Structural Engineers
Sound Consulting	ARUP

SCULPTURE RENDERINGS



Fig. 2 Environmental view with Watershed Center visitor

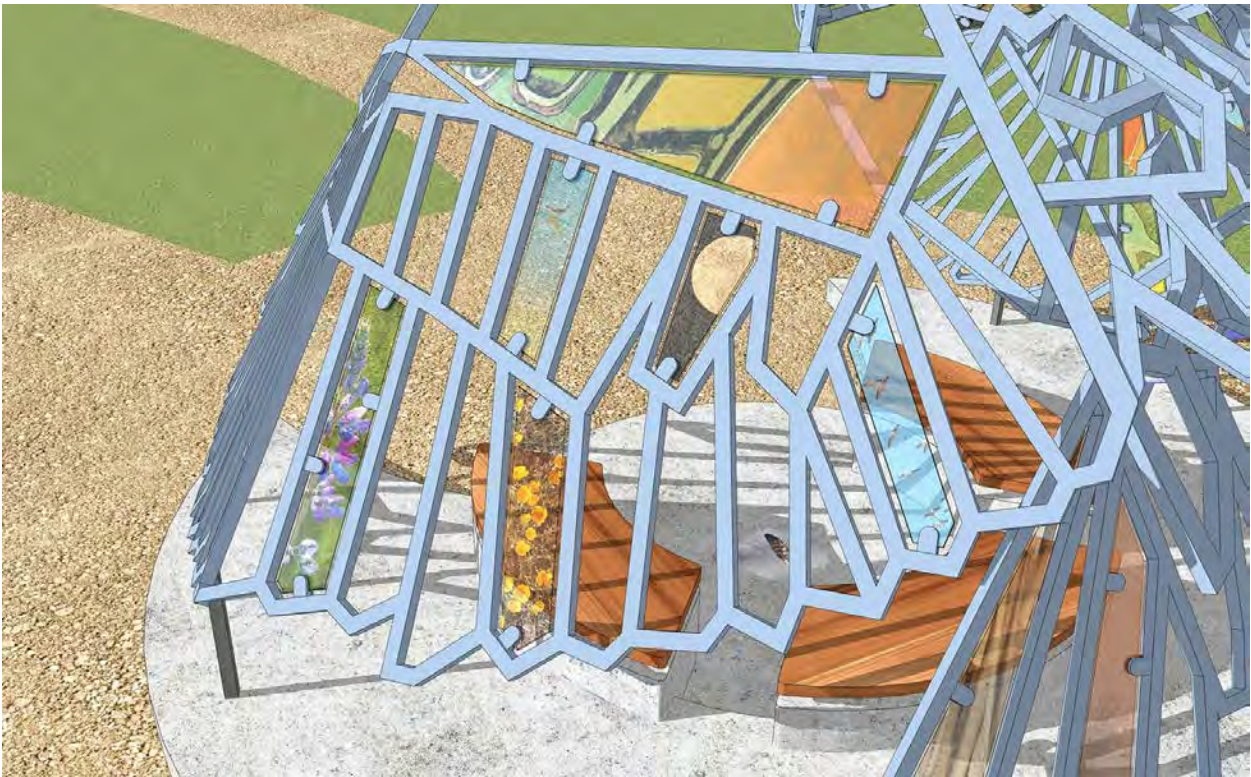


Fig. 3 Glass panels will cast color-filled shadows on sunny days

















MATERIALS AND FINISHES

Fig. 11 Welded steel sample parts prior to finishing



- The eagle sculpture is fabricated from 2" square, 1/8" wall, steel tubing, welded, sandblasted, and painted to withstand the elements (pictured prior to finishing). All elements that protrude into the public sphere will be rounded and smooth.
- Paint: Tnemec "Blue Bell" (see Fig. 12). Surface finish: Satin. Description: Advanced Thermoset Solution Fluoropolymer. A low VOC, fluoropolymer coating that provides an ultra-durable finish with user friendly brush, roll and conventional spray application. It has outstanding color and gloss retention even in the most severe exposures.

Fig. 12 Paint color chosen to integrate well with garden setting while still reading clearly against background vegetation. (computer monitors, screens, and printers may not reproduce color accurately)





TNEMEC COMPANY, INC.
+1 816-483-3400 tnemec.com

1070V - 05BL
LOW VOC FLUORONAR
GAINESBORO
REF;ALAMEDA CREEK
WATERSHED SCULPTURE

This custom display sample was produced under laboratory conditions and may not always represent the appearance of field applications.

BENCHTOP MATERIAL

Fig. 13 Redwood



- Sustainably sourced redwood
- Benchtops will be glue-ups, panels made up of 3-5 smaller boards assembled with floating tenons and waterproof exterior glue (long grain connections). This allows us to use sustainably sourced wood which comes in smaller dimensions.

GLASS SPECIFICATIONS

- 23 Panels, approx. 40 square feet, of Skyline custom digital ceramic frit on surface #2 or #3 of 9/16" laminated glass.
- Make-up: 1/4" Starphire, tempered, 0.060 clear interlayer 1/4" Starphire, heat strengthened.
- Glass to be pattern cut with polished perimeter, inside corners will have small radius (TBD).
- 83 Glass Clamps, figured as SADEV 62 x 45 mm round, 3/4" perimeter gap required. No glass prep; Alloy 316 stainless steel, suitable for aggressive environments (seaside, chorine)

Fig. 14 Glass printing example - Nick Cave, Garfield Park Station, Chicago

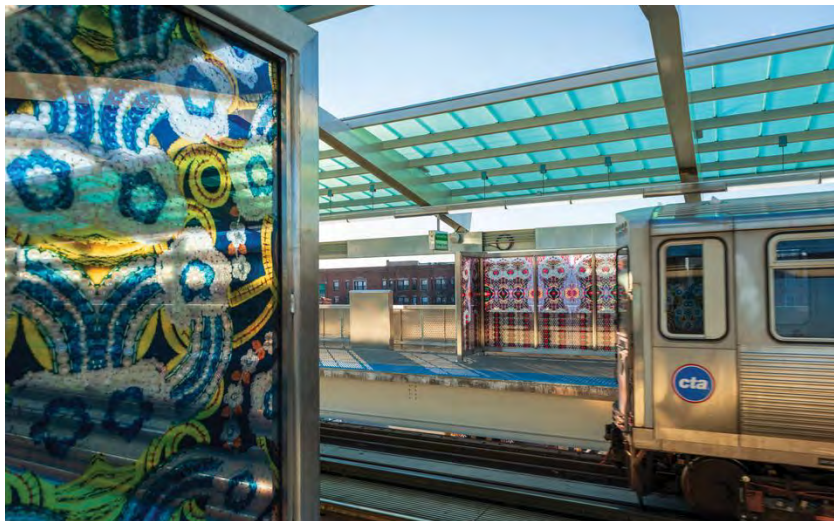


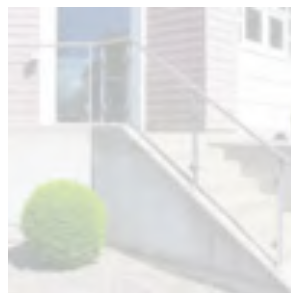
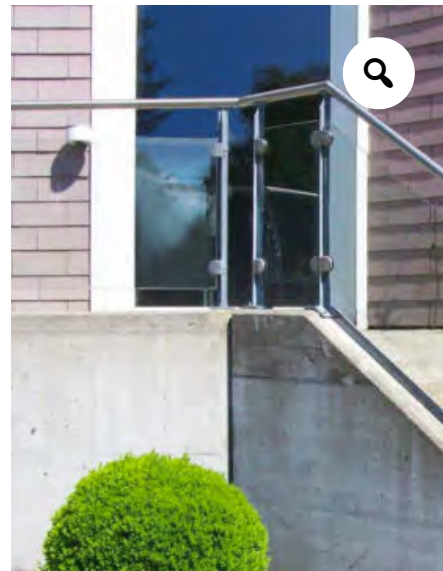
Photo: Patrick Pyszka



Home / Interior design - DECOR - COLCOM / Glass clamps / Round glass clamp

Round glass clamp

ROUND GLASS CLAMP STAINLESS STEEL AISI 316 - ADAPTER FOR SQUARE OR ROUND BALUSTRADE POSTS



AVANTAGES

Most economical and minimalist guardrail solution

Features

- 3 models of glass tongs
- For installation on flat or tubular supports
- Stainless steel 316
- Suitable for aggressive environments (seaside, chlorine...)
- Suitable for the installation of French balconies
- Optional adapter (for tube mounting)
- Optional locking pins
- Black chrome plating possible

Product code

N/A

Dimensions / Type

(* Tailored products and solutions on demand)

- > 62 x 45 mm
- > 67 x 50 mm
- > 72 x 55 mm

Materials

- > Stainless steel AISI 316



Finishing

Adaptator \varnothing 25 mm

Adaptator \varnothing 42,4 mm

Adaptator \varnothing 48,3 mm

Without adaptator

Glasses

08 -> 12 mm

13,52 -> 17,52 mm

21,52 -> 25,52 mm Tailor-made



ENDURA-SHIELD® SERIES 73

PRODUCT PROFILE

GENERIC DESCRIPTION	Aliphatic Acrylic Polyurethane
COMMON USAGE	A coating highly resistant to abrasion, wet conditions, corrosive fumes, chemical contact and exterior weathering. Direct-to-Metal capability allows for a labor-saving, high-build, single coat application. NOT FOR IMMERSION SERVICE.
COLORS	Refer to Tnemec Color Guide. Note: Certain colors may require multiple coats depending on method of application and finish coat color. When feasible, the preceding coat should be in the same color family (blue, gray, etc.), but noticeably different.
FINISH	Semi-gloss
SPECIAL QUALIFICATIONS	Series 73 meets the accelerated weathering requirements of SSPC Paint Standard 36.
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS	<p>Steel: Self-priming or Series 1, 20, FC20, 27, 37H, 66, L69, L69F, N69, N69F, V69, V69F, 90-97, H90-97, 90G-1K97, 91-H₂O, H91-H₂O, 94-H₂O, 135, L140, L140F, N140, N140F, V140, V140F, 141, 161, 394, 530</p> <p>Galvanized Steel & Non-Ferrous Metal: Series 66, L69, L69F, N69, N69F, V69, V69F, 161</p> <p>Concrete: Series 66, L69, L69F, N69, N69F, V69, V69F, 141, 161, 1254</p> <p>CMU: Series 1254</p> <p>Note: Series 530 exterior exposed more than 24 hours, Series L69, N69, V69, 135, L140, N140, or V140 exterior exposed more than 60 days, Series L69F, N69F, V69F, L140F, N140F or V140F exterior exposed more than 30 days, or Series 141 exterior exposed more than 14 days must first be scarified or reprimed with themselves. Brush blasting with fine abrasive is the preferred method of scarification. Recoat windows for other primers may apply. See those data sheets for additional information.</p>
TOPCOATS	Series 700, 701, 740, 750, 1070, 1070V, 1071, 1071V, 1072, 1072V, 1074, 1074U, 1075, 1075U, 1077, 1078

SURFACE PREPARATION

STEEL	SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 2.0 mils.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants. See primer product data sheet for surface preparation recommendation.

TECHNICAL DATA

VOLUME SOLIDS	58.0 ± 2.0% (mixed) †
RECOMMENDED DFT	<p>Topcoat Service: 2.0 to 5.0 mils (50 to 125 microns) per coat.</p> <p>Direct-to-Metal Service: 3.5 to 5.0 mils (89 to 125 microns).</p> <p>Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.</p>

CURING TIME	Temperature	To Touch	To Handle	To Recoat
	75°F (24°C)	1 hour	5-8 hours	12 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	Thinned 10% (Max) (No. 39 Thinner)	Thinned 10% (Max) (No. 42 Thinner)	Thinned 10% (Max) (No. 48 Thinner)	Thinned 10% (Max) (No. 56 Thinner)	Thinned 10% (Max) (No. 63 Thinner)
	2.70 lbs/gallon (324 grams/litre)	3.05 lbs/gallon (366 grams/litre)	3.10 lbs/gallon (371 grams/litre)	3.15 lbs/gallon (378 grams/litre)	2.76 lbs/gallon (331 grams/litre)	3.07 lbs/gallon (368 grams/litre)

HAPS	Unthinned	Thinned 10% (Max) (No. 39 Thinner)	Thinned 10% (Max) (No. 42 Thinner)	Thinned 10% (Max) (No. 48 Thinner)	Thinned 10% (Max) (No. 56 Thinner)	Thinned 10% (Max) (No. 63 Thinner)
	0.27 lbs/gal solids	0.27 lbs/gal solids	0.27 lbs/gal solids	0.27 lbs/gal solids	0.27 lbs/gal solids	0.32 lbs/gal solids

THEORETICAL COVERAGE 930 mil sq ft/gal (22.8 m²/L at 25 microns). †

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Four (Part A) to one (Part B)

PACKAGING

	PART A	PART B	When Mixed
5 Gallon Kit	5 gallon pail (partial fill)	1 gallon can	5 gallons (18.9L)
1 Gallon Kit	1 gallon pail (partial fill)	1 quart can (partial fill)	1 gallon (3.79L)

NET WEIGHT PER GALLON 12.13 ± 0.25 lbs (5.50 ± .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 Part A: 24 months at recommended storage temperature.

Part B: 12 months at recommended storage temperature.

FLASH POINT - SETA Part A: 55°F (13°C) Part B: 112°F (43°C)

ENDURA-SHIELD® | SERIES 73

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

Topcoat Service

	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.5 (115)	372 (34.6)
Minimum	2.0 (50)	3.5 (90)	465 (43.2)
Maximum	3.0 (75)	5.0 (155)	310 (28.8)

Direct to Metal Service

	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	4.0 (100)	7.0 (180)	233 (21.6)
Minimum	3.5 (90)	6.0 (150)	266 (24.7)
Maximum	5.0 (125)	8.5 (215)	186 (17.3)

(1) Can be spray applied at 3.0 to 5.0 mils (75 to 125 microns) DFT per coat when extra protection or the elimination of a coat is desired.

(2) Can be sprayed, brushed or rolled at 2.0 to 3.0 mils (50 to 75 microns) DFT per coat for use in systems requiring a conventional build topcoat.

Allow for overspray and surface irregularities. Wet 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 contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. When used with 44-710 Urethane Accelerator, first blend 44-710 into Part A under agitation; continue as above. Do not use mixed material beyond pot life limits. **Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Keep unused material tightly closed at all times.**

THINNING

For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon by volume with No. 42 Thinner if temperatures are below 80°F (27°C), use No. 48 Thinner for temperatures above 80°F (27°C). Thin up to 5% or 1/4 pint (190 mL) per gallon for airless spray. For brush or roller, thin 5% to 10% or 1/4 to 3/4 pint (190 to 380 mL) per gallon with No. 39 or No. 63 Thinner. Thinning is required for proper brush or roller application. **Note:** A maximum of 10% of No. 56 Thinner may be used to comply with VOC regulations. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.**

POT LIFE

8 hours at 40°F (4°C) 4 hours at 77°F (25°C) 2 hours at 100°F (38°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss 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)	75-90 psi (5.2-6.2 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)	2700-3300 psi (186-228 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.

Roller: Use 1/4" to 3/8" (6.4 mm to 9.5 mm) synthetic woven nap roller cover. Do not use long nap roller covers. **Note:** Two coats are required to obtain dry film thickness above 3.0 mils (75 microns).

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes. **Note:** Two or more coats may be required to obtain recommended film thicknesses.

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.

Cure time necessary to resist direct contact with moisture at surface temperature:

40°F (4°C): 24 to 40 hours 50°F (10°C): 18 to 26 hours 60°F (16°C): 12 to 16 hours

70°F (21°C): 4 to 8 hours 90°F (32°C): 2 to 4 hours 100°F (38°C): 2 to 3 hours

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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TNEME-ZINC SERIES 90-97

PRODUCT PROFILE

GENERIC DESCRIPTION	Aromatic Urethane, Zinc-Rich
COMMON USAGE	An advanced technology, two-component, moisture-cured, zinc-rich primer providing extraordinary performance. It's user friendly and rapid curing so chemical- and corrosion-resistant topcoats can be applied the "same-day." Also used for field touch-up of inorganic zinc coating. Application methods include "dry-fall" under certain conditions (see Application).
COLORS	90-97 Reddish-gray
ZINC PIGMENT	83% by weight in dried film
SPECIAL QUALIFICATIONS	Series 90-97 meets AISC requirements of Class B surface with a mean slip coefficient no less than 0.50 and a tension creep not in excess of .005 inches (.13mm). Tnemec-Zinc uses a zinc pigment which meets the requirements of ASTM D 520 Type III and contains less than .002% lead. This level qualifies it to be classed as "non-lead" (less than 0.009% lead by weight) as defined in 16 CFR Part 1303 of the Consumer Product Safety Commission regulations. Conforms to SSPC Paint 20, Type II .
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

TOPCOATS	Series 1, 6, 27, 27WB, 46H-413, 66, L69, L69F, N69, N69F, V69, V69F, 73, 104, 113, 114, 115, 135, 161, 394, 1028, 1029, 1074, 1074U, 1075, 1075U Note: Certain topcoat colors may not provide one-coat hiding depending on method of application. Contact your Tnemec representative. Note: Series 90-97 must be exterior exposed for three days prior to topcoating with Series 1028 or 1029. Note: Series 90-97 must be exterior exposed for one day prior to topcoating with Series 27WB.
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SURFACE PREPARATION

Severe Exposure: SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum angular anchor profile of 1.5 mils.
Moderate Exposure: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

TECHNICAL DATA

VOLUME SOLIDS	63.0 ± 2.0% (mixed)
RECOMMENDED DFT	2.5 to 3.5 mils (65 to 90 microns) per coat.
CURING TIME	Without 44-710

Temperature †	To Handle	To Recoat
75°F (24°C)	1 hour	4 hours
65°F (18°C)	1 1/2 hours	5 hours
55°F (13°C)	2 hours	6 hours
45°F (7°C)	2 1/2 hours	7 hours
35°F (2°C)	3 hours	8 hours

† 50% relative humidity. Curing time will vary with surface temperature, humidity and film thickness.
Note: For faster curing, low humidity and low-temperature applications, add No. 44-710 Urethane Accelerator (see separate product data sheet).

VOLATILE ORGANIC COMPOUNDS	Unthinned: 2.68 lbs/gallon (321 grams/litre) Thinned 2.5% (No. 2 or No. 3 Thinner): 2.79 lbs/gallon (334 grams/litre) Thinned 10% (No. 2 or No. 3 Thinner): 3.10 lbs/gallon (371 grams/litre)
HAPS	Unthinned: 5.12 lbs/gal solids Thinned 2.5%: 5.41 lbs/gal solids (No. 2 Thinner); 5.13 lbs/gal solids (No. 3 Thinner) Thinned 10%: 6.27 lbs/gal solids (No. 2 Thinner); 5.16 lbs/gal solids (No. 3 Thinner)
THEORETICAL COVERAGE	1,011 mil sq ft/gal (24.8 m ² /L at 25 microns). See APPLICATION for coverage rates.
NUMBER OF COMPONENTS	Two: Part A and Part B
PACKAGING	Four-Gallon and One-Gallon Kits: Consist of one premeasured container of liquid (Part A) and one premeasured container of powder (Part B). When mixed, yields four gallons (15.1L) or one gallon (3.79L).
NET WEIGHT PER GALLON	23.94 ± 0.60 lbs (10.86 ± .27 kg)
STORAGE TEMPERATURE	Minimum 20°F (-7°C) Maximum 110°F (43°C)
TEMPERATURE RESISTANCE	Dry (Continuous) 250°F (121°C) Intermittent 300°F (149°C)
SHELF LIFE	Part A: 12 months at recommended storage temperature. Part B: 24 months at recommended storage temperature.
FLASH POINT - SETA	Part A: 78°F (26°C) Part B: N/A
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.

TNEME-ZINC | SERIES 90-97

APPLICATION

COVERAGE RATES

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	3.0 (75)	5.0 (125)	337 (31.3)
Minimum	2.5 (65)	4.0 (100)	404 (37.5)
Maximum	3.5 (90)	5.5 (140)	289 (26.9)

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

Always use the entire contents of A and B components. Use an air-driven power mixer and keep material under constant agitation while mixing. Slowly sift powder (Part B) into liquid (Part A).
-Do Not Reverse This Procedure- Adjust mixer speed to break up lumps and mix until the two components are thoroughly blended. Strain through a 35 to 50 mesh (300 to 600 microns) screen before using. For spray application, keep under low RPM agitation to prevent settling. For brush or roller application, stir frequently to prevent settling. Do not use mixed material beyond pot life limits.

THINNING

For spray, thin up to 10% or 3/4 pint (380 mL) per gallon with No. 2 Thinner if temperatures are below 80°F (27°C). Thin up to 10% or 3/4 pint (380 mL) per gallon with No. 3 Thinner if temperatures are above 80°F (27°C). For brush or roller, thin up to 10% or 3/4 pint (380 mL) with No. 3 Thinner.

POT LIFE

8 hours at 77°F (25°C) and 50% R.H.
Caution: This product cures with moisture acting as a catalyst. Incorporation of moisture or moisture laden air (humidity) during use will shorten pot life. Avoid continual agitation at high RPM. When feasible keep containers of mixed material covered during use.

APPLICATION EQUIPMENT

Note: When finish coats are white or light colors, best hiding of this dark color primer can be achieved by spray application.

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss 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)	40-50 psi (2.8-3.4 bar)	10-20 psi (0.7-1.4 bar)

† (with heavy mastic spring) Low temperatures or longer hoses will require additional pressure. Use pressure pot equipped with an agitator and keep pressure pot at same level or higher than the spray gun. Compressed air must be dry.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.021" (430-535 microns) Reversible Tip	2400-3000 psi (165-207 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. Keep material agitated to prevent settling.

Roller: Use 1/4" or 3/8" (6.4 mm or 9.5 mm) synthetic woven nap roller covers. Stir material frequently or keep under agitation to prevent settling.

Brush: Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 35°F (2°C) Maximum 140°F (60°C) Maximum for Brush & Roller 120°F (49°C)
 The surface should be dry and at least 5°F (3°C) above the dew point. **Note:** Series 44-710 Accelerator must be used if the surface temperature is 35°F to 60°F (2°C to 16°C) and 20% to 40% relative humidity.

AMBIENT HUMIDITY

Minimum 20% Maximum 90%

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or xylene.

CAUTION

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions and equipment adjustment. Low temperature is of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that surface temperatures can be higher than air temperatures.

WARRANTY & LIMITATION OF SELLER'S LIABILITY: Tnemec Company, Inc. warrants only that its coatings represented herein meet the formulation standards of Tnemec Company, Inc. THE WARRANTY DESCRIBED IN THE ABOVE PARAGRAPH SHALL BE IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF. The buyer's sole and exclusive remedy against Tnemec Company, Inc. shall be for replacement of the product in the event a defective condition of the product should be found to exist and the exclusive remedy shall not have failed its essential purpose as long as Tnemec is willing to provide comparable replacement product to the buyer. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, ENVIRONMENTAL INJURIES OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Tnemec Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.



PRODUCT PROFILE

GENERIC DESCRIPTION Advanced Thermoset Solution Fluoropolymer

COMMON USAGE A low VOC, fluoropolymer coating that provides an ultra-durable finish with user friendly brush, roll and conventional spray application. It has outstanding color and gloss retention even in the most severe exposures. Under certain conditions, it may be used to restore aged fluoropolymer coil applied coatings or for OEM applications. Contact Tnemec Technical Services or your local Tnemec representative for details.

COLORS Refer to Tnemec Color Guide. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. The preceding coat should be in the same color family, but noticeably different. Upon selection of the finish coat color, the intermediate coat color may be selected by Tnemec Company.

FINISH Semi-Gloss

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Series 1, 27, 27WB, 66, L69, L69F, N69, N69F, V69, V69F, 90-75, 90-97, H90-97, 91-H₂O, 94-H₂O, 115, 118, 135, 161, 394, 1224. **Note:** Series 1 and 394 require an intermediate coat prior to topcoating with Series 1071V. **Note:** Series 118 is typically used to overcoat, sound, existing coating systems. See product data sheet for more information.

INTERMEDIATE Series 73, 750, 1075, 1075U, 1095 (Intermediate coat may be required for some applications, please contact your Tnemec coating consultant.)

Note: When topcoating with Series 1071V, the following maximum recoat times apply: Over 27, 66, L69, L69F, N69, N69F, V69, V69F, 135, 161, 14 days; over itself and 90-75, 30 days; over 750, 1075, 1075U, 1095, 45 days; over 1, 394, 60 days; over 27WB, 73, 90-97, H90-97, 91-H₂O, 94-H₂O, 1224, 90 days.

SURFACE PREPARATION

EXTERIOR EXPOSURE See primer product data sheet for surface preparation recommendation.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 61.0 ± 2.0% (mixed) †

RECOMMENDED DFT 2.0 to 3.0 mils (50 to 75 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Handle	Minimum Recoat ‡
90°F (32°C)	30 minutes	4-6 hours	6-8 hours
70°F (21°C)	30 minutes	6-8 hours	10-12 hours
50°F (10°C)	1 hour	12-15 hours	16-24 hours

‡ Maximum recoat: 30 days. 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:** 1.05 lbs/gallon (125 grams/litre)
Unthinned: 0.51 lbs/gallon (61 grams/litre) (TBAC Exempt)
Thinned 10% (No. 65 Thinner): 1.05 lbs/gallon (125 grams/litre)
Thinned 10% (No. 65 Thinner): 0.51 lbs/gallon (61 grams/litre) (TBAC Exempt)
Thinned 10% (No. 63 Thinner): 1.71 lbs/gallon (205 grams/litre)
Thinned 10% (No. 63 Thinner): 1.29 lbs/gallon (154 grams/litre) (TBAC Exempt) †

HAPS **Unthinned:** 0.01 lbs/gal solids
Thinned 10% (No. 65 Thinner): 0.01 lbs/gal solids
Thinned 10% (No. 63 Thinner): 0.07 lbs/gal solids †

THEORETICAL COVERAGE 878 mil sq ft/gal (24.0 m²/L at 25 microns) †

NUMBER OF COMPONENTS Two: Part A and Part B

MIXING RATIO By volume: Eight (Part A) to one (Part B)

PACKAGING

	PART A (partially filled)	PART B (partially filled)	Yield (mixed)
Medium Kit	5 gallon pail	1/2 gallon can	3 gallons (11.35L)
Small Kit	1 gallon can	1 pint can	1 gallon (3.79L)

NET WEIGHT PER GALLON 13.31 ± 0.25 lbs (6.03 ± .11 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 12 months at recommended storage temperature

FLASH POINT - SETA Part A: 86°F (28°C) Part B: >200°F (93°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.

FLUORONAR® | SERIES 1071V

APPLICATION

COVERAGE RATES

	Dry MILS (MICRONS)	Wet MILS (MICRONS)	Sq Ft/Gal (m ² /Gal)
Suggested	2.5 (65)	4.0 (101)	385 (35.8)
Minimum	2.0 (50)	3.5 (90)	481 (44.7)
Maximum	3.0 (75)	5.0 (127)	321 (29.8)

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 contents of the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. **Caution: Part B is moisture-sensitive and will react with atmospheric moisture. Keep unused material tightly closed at all times.**

THINNING

Thinning is required for proper application. For brush, roller, and air spray, thin up to 10% (82 mL) per gallon with No. 63 Thinner. **Note:** In areas that require lower VOC, use No. 65 Thinner. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.**

POT LIFE

2 hours at 50°F (10°C) 2 hours at 70°F (21°C) 1 hour at 90°F (32°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss 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 (4.9-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

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.

Cure time necessary to resist direct contact with moisture at surface temperature:

Temperature	To Resist Moisture
100°F (38°C)	2 hours
90°F (32°C)	3 1/2 hours
80°F (27°C)	5 hours
70°F (21°C)	7 hours
60°F (16°C)	11 hours
50°F (10°C)	21 1/2 hours
40°F (4°C)	44 hours

If the coating is exposed to moisture before the preceding cure parameters are met, dull, flat or spotty-appearing areas may develop. Actual times will vary with air movement, film thickness and humidity.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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