

# **NORTHSTAR**

## **TNEK Epoxy Primer**

### **DESCRIPTION**

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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**

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

### **MIXING RATIO**

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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**

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8 hours

### **CLEAN UP**

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Use **NORTHSTAR** Lacquer Thinner or zero VOC reducers. (Check local regulations)

### **PHYSICAL DATA**

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Solids by weight as mixed	44%
VOC as mixed	2.1
Color	Light Gray

### **DRY / FLASH TIMES**

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#### **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
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Force dry time

30 minutes at 140° F

## **GUN SETUPS**

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### **Conventional**

Gravity Feed

1.5 mm – 1.8 mm

Siphon Feed

1.5 mm – 1.8 mm

## **AIR PRESSURES**

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### **Conventional at Gun**

Gravity Feed

35 – 45 psi

Siphon Feed

40 – 50 psi

HVLP at cap

8 – 10 psi

## **SURFACE PREPARATION**

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

## **APPLICATION**

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

## **SAFETY**

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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.

## **NORTHSTAR COATINGS**

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