Commercial Performance Coatings

TMP-304

CPC 80

Acrylic Bake Primer

PRODUCT DESCRIPTION	
TMP-304 ACRYLIC BAKE PRIMER **Component A** (Pigmented)	**TMP-301 ACRYLIC BAKE PRIMER HARDENER** **Component B**

TYPE: Acrylic Bake

RECOMMENDED USE
TMP-304/TMP-301 Acrylic Bake Primer is recommended for industrial use on properly prepared surfaces. Applications include metal fabrication, castings, cabinets and machinery.

PHYSICAL CONSTANTS			
WEIGHT PER GALLON:	12.5 lbs +/- 0.2 lbs	**FLASH POINTS:**	
PERCENT SOLIDS BY WEIGHT:	75.7% +/- 2.0%	TMP-304:	71°F (22°C)
PERCENT SOLIDS BY VOLUME:	57.7% +/- 2%	TMP-301:	141°F (60°C)
		VOC	3.50 lbs/gallon (maximum)
		SHELF LIFE:	12 months each component

PERFORMANCE FEATURES	
Color:	Gray
Gloss @ 60^{O} Angle:	20 - 60
Pencil Hardness:	H – 5H
Adhesion:	5B - Excellent
Topcoats:	ALK-100, ALK-200, TMX-350, TMX-400, AUE-100, AUE-300
Above results obtained over iron phosphated Cold Rolled Steel panels	

CHEMICAL/SOLVENT RESISTANCE	
100 Hours Humidity Resistance	Excellent

SURFACE PREPARATION

The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.

Metal	Recommended Topcoats	Direct To Properly Treated Substrate
Cold Rolled Steel	N/A	Excellent
Hot Rolled Steel	N/A	Excellent
Plastic/Fiberglass	N/A	

APPLICATION DATA

MIXING DIRECTIONS
Add 2.5% by weight or 1 pint TMP-301 catalyst per 5 gallons of TMP-304.

THINNING
Xylene or MEK

POT LIFE
N/A

RECOMMENDED WET FILM BUILD
Spray Application: 1.5 – 2.0 mils

RECOMMENDED DRY FILM BUILD
0.8 – 1.2 mils

Film in excess or below these recommended film builds might cause problems such as, adhesion failure, pigment floatation, solvent popping, and slow cure.

DRYING TIME

Force Dry
Flash: 10 minutes @ ambient
20 minutes 225°F (peak metal temperature)

Drying time listed may vary, depending upon film build and temperature.

Application of film thickness in excess of that recommended for this product will substantially extend dry time.

RECOMMENDED SPREADING RATE
925 sq. ft. at 1.0 mil dry film per U.S. Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.

CLEAN UP
Xylene or MEK

APPLICATION PRECAUTIONS AND LIMITATIONS
Apply only when air, product or surface temperature is above 50°F. Reduce or higher levels of catalyst addition will require higher or lower bake cycles for proper cross linking of the film

Brush and roller application is not recommended

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 or equivalent	NA	45	NA	66SD
Conventional	Graco Delta Air or equivalent	¼" Fluid Line	10	60	.042
Air Assisted Airless	Graco Alpha A.A. or equivalent	NA	1000 – 1500	20 – 30	.011 or .015
HVLP	Binks 2001 HVLP or equivalent	NA	50	NA	NA

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.

SAFETY

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (304) 843-1300. CANADA (514) 645 - 1320 Have label information available. **MATERIAL SAFETY DATA SHEET**

Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.

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Commercial Coatings
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