Tufcote™ 3.5 HG-D™
High Gloss Alkyd DTM

GENERAL

DESCRIPTION
A high-gloss, single-package, 3.5 lbs./gal. VOC conforming, acrylic-modified V-T alkyd enamel. The resulting coating is designed to be quick drying and very durable in non-corrosive environments.

SUGGESTED USES:
As a quality high-gloss alkyd topcoat on carbon steel, dry wall, and wood where:
- Very quick dry times are required
- Wide variety of custom colors are needed
- Single-package easy-to-use product is required
- DTM (direct-to-metal) is required for interior exposure
- Application by brush and roller, in addition to spraying, may be necessary
- Electrostatic spray application is required

NOT RECOMMENDED FOR:
- Immersion service
- Harsh chemical environments
- Over galvanized metal
- Prolonged exterior exposure – will chalk

COMPATIBILITY WITH OTHER COATINGS
Tufcote 3.5 HG-D should be used over properly primed surfaces in exterior exposures. Recommended primers include: Tufcote 2.8 PR™, Tufcote 3.3 PR™, Tufcote 3.5 PR™, Corlar® 2.1 PR™, Corlar 3.2 PR™ and Corlar LV PR™. Tufcote 3.5 HG-D can be applied DTM (direct-to-metal) in mild interior exposures. It may be used over most aged and hard cured coatings in good condition. Testing for lifting, bubbling and adhesion is recommended to assure compatibility with unknown coatings. Contact Axalta Coating Systems for specific recommendations.

PERFORMANCE PROPERTIES
- Chemical: Fair in mild chemical environments
- Humidity: Good
- Weather: Fair

COLOR
Select factory pack colors, custom colors available on request.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS
Select factory packaged & mix colors. Bases are short filled to allow for colorant addition:
- 1LB34P™ 124 oz/gal
- 2MB34P™ 120 oz/gal
- 3DB34P™ 116 oz/gal
- 4NB34P™ 112 oz/gal

Not all colors available in all sizes. Please call Axalta Customer Service for availability

ACTIVATION
No activation required. Mix pigmented portion until uniform in color.
MIXING AND REDUCTION
No reduction necessary. Any addition of thinner will eliminate compliance with air pollution regulations limiting VOC’s to 3.5 lb/gal. If 3.5 VOC is not required, thin using up to 10% Axalta T-8805™ for spray or brush and Y-32035™ up to 10% for electrostatic spray.

APPLICATION THINNERS
Spray, Brush T-8805
Electrostatic Spray Y-32035

INDUCTION TIME
None

POT LIFE
Not applicable.

APPLICATION

APPLICATION CONDITIONS
Do not apply if material, substrate or ambient temperature is below 40°F (4°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

SURFACE PREPARATION
Surface should be clean dry and free of any oil and grease when extra corrosion resistance is required, prime steel surfaces with Tufcote 2.8 PR™, Tufcote 3.5 PR™ or other appropriate primer.

APPLICATION EQUIPMENT
Apply by spray, brush or roll. Spray application is the preferred method of application due to fast dry properties. Manufacturers listed below are a guide. Others may be used. Changes in pressure and tip size may be required to achieve proper application.

Hiding – Some colors may require multiple coats to achieve hiding.

Roll
Wooster® Pro/Doo-Z ¼”- ½” nap roller cover.
Keep roll wet. Roll in one direction, rewet, then cross roll.

Brush
Wooster China Bristle Brush 2”-4”

Spray
Conventional Pressure Fed Liquid

<table>
<thead>
<tr>
<th>Spray Gun:</th>
<th>Binks</th>
<th>DeVilbiss</th>
<th>Sata</th>
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</thead>
<tbody>
<tr>
<td>Fluid Nozzle:</td>
<td>63CSS</td>
<td>FF (1.4)</td>
<td>1.1</td>
</tr>
<tr>
<td>Pot Pressure:</td>
<td></td>
<td></td>
<td>10</td>
</tr>
<tr>
<td>Atomizing Pressure:</td>
<td></td>
<td></td>
<td>36</td>
</tr>
<tr>
<td>Air Cap:</td>
<td>63PR</td>
<td>765</td>
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<tr>
<td>Fluid lines 3/8” ID or larger are required for proper fluid delivery.</td>
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HVLP Pressure Fed

| Devilbiss | GTi | 1.4 | 2000 |
| Binks | Mach 1 | 94 (1.4) | 94P |

Airless Spray

| Pump: | Graco Extreme 33:1 |
| Airless Gun: | Graco 208663 |
| Fluid Hose: | 3/8” x 100’ max. |
| Tips: | 411-517 |
| Minimum pressure to avoid fingering: 2400 psi min |
CLEAN UP THINNERS
T-8805 or Y-32035

DRY TIMES
Cure Times at suggested DFT

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
<th>Hard Dry</th>
</tr>
</thead>
<tbody>
<tr>
<td>70°F (21°C)</td>
<td>20 minutes</td>
<td>1 hour</td>
<td>after 30 minutes up to 2 hours, then after 24 hours</td>
<td>4 hours</td>
</tr>
</tbody>
</table>

PHYSICAL PROPERTIES

- Maximum Service Temperature: 200°F (93°C) in continuous service
- Gloss (ASTM D 523): High gloss 90+ @ 60°
- Weight Solids (Avg. varies by color): 61% ± 3% average
- Weight per gallon-(Avg. varies by color): 8.96 ± 0.5 lb/gal average
- Flash Point-Tag Closed Cup: 73 L
- Volume Solids (Avg. varies by color): 49% ± 2% average
- Shipping Weight (varies by color): 1 gallon container: 11 lbs, 5 gallon container: 47 lbs
- Shelf Life: 1 year minimum
- Theoretical Coverage Per Gallon: 785 ft² /gal at 1 mil DFT, 392 ft² /gal at 2 mil DFT

Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Suggested Film Builds: 4.0 mils (100 µm) wet, 2.0 mils (50 µm) dry

Application by brush and roller may require additional coats to achieve recommended films thickness.

STORAGE CONDITIONS
Store in a dry, well-ventilated area. Storage conditions should be between –30°F (-34°C) and 120°F (-48°C). Tufcote 3.5 HG-D may settle. Agitate before each use.

THEORETICAL VOC
VOC less water and exempt compounds
- Tufcote 3.5 HG-D no reduction: 3.5 lbs/gal max.
- Tufcote 3.5 HG-D reduced: 3.8 lbs/gal max.
- 10% with T-8805™

ASTM INFORMATION
Physical properties are for Tufcote 3.3 PR™ and Tufcote 3.5 HG-D. For other system recommendations, please contact Axalta Coating Systems.

Paint System: Tufcote 3.3 PR/Tufcote 3.5 HG-D/Tufcote 3.5 HG-D 681-704™ / 34P™ / 34P™
Type/Color: alkyd red oxide / alkyd white / alkyd white
DFT: 2.1 / 2.4 / 2.2

TEST RESULTS
Salt Fog (ASTM B117)
- 1000 hours: no rusting, very few #6 blisters at the scribe
- 2000 hours: no rusting, very few #6 blisters at the scribe
- 3000 hours: no rusting, few #4 & #6 blisters at the scribe
Relative Humidity (ASTM D2247)  
- 1000 hours: no rusting, few #2 blisters on the face of the panel
- 2000 hours: no rusting, few #2 blisters on the face of the panel
- 3000 hours: no rusting, few #2 blisters on the face of the panel

Dry Heat (ASTM D2485)  
- 250°F for 24 hours: no cracking, no blisters, no loss of adhesion, severe discoloration

Electrical Resistance (ASTM D2457):  
- 5.2X10^15

Adhesion (ASTM D4521 A2):  
- 1467 psi: cohesive failure within the primer

Cleveland Cond (ASTM D4585):  
- 1000 hours: no rusting, few #2 and dense #8 blisters on the face of the panel

UV Con (ASTM D4587)*  
- 3000 hours: Gloss before exposure 89.8, Gloss after exposure 2.7, Evaluation no rusting, no blisters, no delamination

Impact (ASTM D2794):  
- 0 inch pounds

Mandrel Bend (ASTM D522):  
- % Elongation - 0%

Taber Abrasion (ASTM D4060):  
- weight loss in grams - 0.38

*8 hr UV @ 50°C, 4 hr condensation @ 40°C, gloss readings @ 60°

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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