



94 Series Epoxy Hybrid Topcoat

Description

High performance topcoat
 Superior weathering and chemical resistance
 Solid colors, metallics and iridescents
 Gloss and low semi-gloss finishes
 Non-isocyanate

Low VOC
 Corrosion resistant
 Cures at ambient temperature
 Fine finish quality

TECHNICAL DATA

% SOLIDS by volume	92% as applied
COATINGS VOC (as packaged)	max. 3 g/l (less water & exempt compounds)
SPRAYABLE VOC (as applied)	max. 89 g/l (less water & exempt compounds) includes cure volatiles
COMPONENTS	94 Series base 94C303 or 94C301 Converter
POT LIFE	4 hours @ 70° F, 21° C
SHELF LIFE	one year (unopened)
REDUCERS	Option use Oceanair's TR-108 VOC Exempt Reducer
FLASH POINT	109° F, 42.8° C
MIX RATIO	4:1 (4 parts base : 1 part converter)
RECOMMENDED DRY FILM THICKNESS	3-5 mils per coat (75-125 microns), 1 to 2 coats
THERORETICAL COVERAGE	492 – 295 sq. ft. at recommended DFT (theoretical)

SURFACE PREPARATION

94 Series may be applied over appropriately prepared steel, aluminum, galvanizing, fiberglass, concrete and coated surfaces. 94 Series may also be applied over appropriately primed substrates for best corrosion control. Good painting practices dictate that before applying coatings a test or mock-up be performed to ensure that the adhesion, appearance and color are compatible with the substrate and meet the expectations of the owner.

Steel – Clean the surface of all foreign material. Substrate must be clean and dry prior to application of 94 Series. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

Aluminum - Clean the surface of all foreign material. Substrate must be clean and dry prior to application of 94 Series. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

Galvanized Steel – Preparation shall meet ASTM D6386 –10. Remove all contaminants and check for the presence of chromates or other passivation treatments. If passivation treatment exists, brush-off blast cleaning. The complete removal of chromates or other passivating treatments must be confirmed by testing (ASTM B 201) prior to coating application.

Concrete – Surface must be cured, clean, dry, and free of contamination and disintegrated or chalky materials. SSPC-SP13 may be used for surface preparation of concrete. Substrate must be clean and dry prior to application of the 94 Series. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

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OCEANAIR PERFORMANCE COATINGS

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 512.688.7607
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Technical Data Sheet



Coated surfaces – Physically abrade existing coated surfaces thoroughly and completely with 220 grit or equivalent abrasive paper or scuff pad. . Substrate must be clean and dry prior to application of the 94 Series. For primed substrates, follow the surface preparation instructions and recoat times for the specific primer used.

INSTRUCTIONS – MIX RATIO

Stir or shake thoroughly to ensure uniform mixture. Mix 4 parts 94 Series base with 1 part Fast Converter 94C303 or Std Converter 94C301. Stir or drill motor mix thoroughly to ensure uniform mixture. Additional reduction is not usually necessary, but if needed use Oceanair TR-108 VOC Exempt Reducer.

APPLICATION

Apply using 40-55 PSI at the gun for siphon and gravity feed spray guns, 10 PSI max. at the air cap for HVLP spray guns. Apply 1-2 medium wet coats until desired coverage and flow is reached. Allow a 5 to 10 minute flash time between coats. Recommended film thickness is 3.0 to 5.0 mils DFT. Surface temperatures must be at least 5° F (3° C) above the dew point for application.

SPRAY GUN SET-UP & PRESSURE

<u>Type</u>	<u>Fluid Tip</u>	<u>Spraying Pressure</u>
Siphon Feed	1.4mm – 1.7mm	40-65-PSI
Gravity Feed	1.3mm – 1.4mm	40-65 PSI
HVLP Siphon	1.3mm – 1.5mm	max. 10 PSI @ the air cap
HVLP Gravity	1.3mm – 1.5mm	max. 10 PSI @ the air cap
Pressure Pot	1.1 mm- 1.3 mm	29 PSI - 58 PSI
Airless Spray	Double Orifice 312 through 512 Fine Finish Tips (for clears and solid colors only)	

ROLLER AND BRUSH APPLICATION

Brush – natural bristle

Roller – 1/4 to 3/8 inch nap, mohair or no-lint cover with a phenolic core

We do not recommend foam roller application

DRY TIMES

Dry times @ 70°F (21°C) and 50% RH

Tack Free	4 hours
Dry Time	24 hours
Recoat	Full recoat 24 hours

CLEAN UP

Follow local, state and federal regulations. Clean all spray equipment immediately after use. Acetone may be used to clean spray equipment. Oceanair's 2153 Gun Cleaner is a VOC exempt cleaner and is recommended for cleaning application equipment used to apply the 94 Series system. Refer to Material Safety Data Sheet for proper handling of products listed in this bulletin. Acetone may be used to clean application equipment immediately after use.

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***DISCLAIMER:** The technical information and suggestions for use have been compiled for your guidance and usage. Such information is based on experience and research and is believed to be reliable. As Oceanair Performance Coatings has no control over conditions in which the product is used, stored, or otherwise handled, the above information does not constitute a warranty. Buyers must assume responsibility for the suitability of the product for their purposes.*

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