



Tufcote™ 2.8 HG

High Gloss Acrylic Alkyd Topcoat

(Formerly Hy-Lux 3100 Series)



GENERAL

DESCRIPTION

Tufcote 2.8 HG is a durable, extremely high gloss enamel made from a premium quality, acrylic-modified, alkyd resin. Formulated to give long-term weather protection and a colorful appearance. Tufcote 2.8 HG is designed as a tough coating to provide exceptional performance on a wide variety of metal substrates. It is available in a wide selection of colors. May be applied by brush, roller or spray application.

Tufcote 2.8 HG can also be used as a Direct to Metal product, in certain select environments.

SUGGESTED USES

As an economy coating for use on a wide variety of properly prepared metal substrates on farm and construction equipment, interior trim, moldings, cabinets, and door and window frames where the following attributes are desirable:

- Extremely high gloss
- Tough and durable
- A true general purpose enamel
- Excellent hide and coverage
- Easily applied using conventional methods and equipment
- Stocked in well-known industrial colors
- As a DTM- in select environments- Contact Axalta for more information

COMPATIBILITY WITH OTHER COATINGS

- For best results, apply over Tufcote 1200, 4400, 7900, 690 or Tufcote 3.3PR series primers.
- Can also be applied over old coatings in good condition, after testing for adhesion.

COLOR

3100 White	3121 New National Blue
3101 Black	3125 Medium Green
3105 Baja Beige	3145 Light Yellow
3107 New Unit Rig Grey	3151 John Deere Green
3108 Platinum Grey	3164 Ford Safety Blue
3109 International Red	3165 Wimbledon White
3110 Safety Red	3176 Int'l Case & MF Yellow
3115 Safety Orange	3193 Silver Metallic
3116 International Orange	3195 New Cat Yellow
3117 Yellow	
3119 Cat Yellow	



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

MIXING

1 gallon container 100% full (128 oz.)

COMPONENTS

Tufcote 2.8 HG 31XX Topcoat

MIXING

Mix thoroughly before use and/or after thinning. Assure color is uniform and there are no solids on the bottom of the can. If thinning is required, use up to 10% of Tufcote 8020 Exempt thinner.



8499 POLYURETHANE CATALYST: For increased performance, 8499 Polyurethane Catalyst may be added to Tufcote 2.8 HG Topcoat. Refer to the 8499 Polyurethane Catalyst label for directions and precautions regarding applying products containing POLYISOCYANATES.

DIRECTIONS FOR USE: For temperatures greater than 80°F (27°C): Add 1/2 pint (8 oz) 8499 Additive to each unreduced gallon of mixed base. Mix thoroughly. If necessary, reduce the additive mixture to desired viscosity with Tufcote 82 Super Gloss & Flow Zero VOC Reducer or Tufcote 8020 Zero VOC Exempt Solvent, up to 10%.

For temperatures, less than 80°F (27°C): Add 1 pint (16 oz) 8499 Additive to each unreduced gallon of mixed base. Mix thoroughly. If necessary, Reduce the additive mixture to desired viscosity with Tufcote 82 Super Gloss & Flow Zero VOC Reducer or Tufcote 8020 Zero VOC Exempt Solvent, up to 10%.

Reduction

DO NOT EXCEED LOCAL VOC REQUIREMENTS. In regulated areas, use Tufcote 8020 Exempt Solvent.

For Spraying: Thin to spray viscosity

For Brushing or Rolling: Thin sparingly.

POT LIFE

n/a



APPLICATION

SURFACE PREPARATION

All surfaces to be painted must be clean, dry and in fit condition to be painted. Be sure to remove all wax, silicone, powdery or scaling rust, loose or peeling paint and all other foreign matter. Smooth, slick surfaces should be sanded to give a mechanical tooth to promote adhesion. Prime bare and uncoated surfaces with one of the following Tufcote primers: Tufcote Hydro 2.1 PR (1200 waterborne series), Tufcote LV PR (4400 series) or Tufcote Hydro LV PR (7900 series) primer, Tufcote 2.1 PR 680 or 690 series, or Tufcote 3.3PR.

BARE FERROUS METALS: Clean off all dirt, grease, oil, wax or other foreign matter. All loose, powdery or scaling rust must also be removed. A completely de-rusted surface is recommended. Prime bare and uncoated surfaces with Tufcote primer.

PAINTED SURFACES: Be sure all loose and peeling paint is completely removed, and the surface is clean. Remove excess chalkiness with a wire brush or by sanding. Feather edge and spot prime with Tufcote primer.

APPLICATION

Two coats are recommended. To avoid wrinkling, the second coat must be applied in 30 minutes to 2 hours, or after a minimum of one week from the time of applying the first coat.

CLEAN UP THINNERS

Do not allow catalyzed material to stand in equipment after use. Clean equipment immediately after use in an enclosed spray equipment cleaner with Tufcote 8020 Zero VOC Exempt Solvent.



DRY TIMES

Cure Time at Recommended Thickness @ 50% RH

	<u>77°F (25°C)</u>
Dust-Free	4 – 6 hours
To Handle	16 hours
Recoat Time	1/2 - 2 hours or after 7 days with sanding
Full Cure	7 days

DRYING SCHEDULE WITH 8499 POLYURETHANE CATALYST:

Dry times are based on recommended dry film thickness of 2.0 - 2.5 mils. Thicker films will extend dry times.

	<u>77°F (25°C)</u>
Dust-Free	1 - 2 hours
Tack-Free	4 - 6 hours
Tape-Free	24 hours
Force Dry	120°F - 40 minutes

Note: If recoating after 7 days with using 8499 catalysts, sanding should be done to assure adhesion.



PHYSICAL PROPERTIES

Viscosity	95 - 105 Krieb Units @ 77°F
Volume Solids	47% - 59%
Weight Solids	50% - 71%
Theoretical Coverage Per Gallon	758 – 957 ft ² per gallon @ 1 mil DFT
Solvents Used	Aliphatic Hydrocarbons/Aromatic Hydrocarbons/Esters/PCBTF
Flash Point	76°F/TCC
Gloss	Extremely High Gloss 80+
Shelf Life	12 months
Recommended DFT:	2-3 mils DFT (4-5 WFT).

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 35°F (2°C) and 90°F (32°C).

VOC REGULATIONS

VOC (Theoretical, varies with color).

2.8 lbs/gal (340 grams per liter) or less

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.



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.

All technical advice, recommendations and services are rendered by the Seller gratis. They are based on technical data which the Seller believes to be reliable, and are intended for professional use by persons having skill and know-how at their own discretion and risk. Seller assumes no responsibility for results obtained or damages incurred from their use by Buyer in whole or in part. Such recommendations, technical advice or services are not to be taken as a license to operate under or intended to suggest infringement of any existing patent.

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