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.

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

COMPATIBILITY WITH OTHER COATINGS
- For best results, apply over Tufcote 1200, 4400 & 7900 Series Primers.
- Can also be applied over old coatings in good condition, after testing for adhesion.

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

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

MIXING

COMPONENTS
Tufcote 2.8 HG 31XX Topcoat	1 gallon container 100% full (128 oz.)

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 80ºF (27ºC): 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 80ºF (27ºC): 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.

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

	77°F (25°C)
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.

	77°F (25°C)
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 Kreb Units @ 77°F
Volume Solids	47% - 59%
Weight Solids	50% - 71%
Theoretical Coverage Per Gallon	758 – 957 ft² per gallon @ 1 mil DFT
Solvents Used	Aliphatic Hydrocarbons/Aromatic Hydrocarbons/Esters/PCBTF
Flash Point	76ºF/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 35ºF (2ºC) and 90ºF (32ºC).

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.

Revised: August 2017

In the United States:
1.855.6.AXALTA
axalta.us

In Canada:
1.800.668.6945
axalta.ca