PRODUCT DATA SHEET

FREEDOMTUFF™ FT-6069-N

FREEDOM Chemical® Corporation

PRODUCT DESCRIPTION

FT-6069-N is an advanced generation epoxy primer formulated for the protection of steel and ductile iron substrates.

USES

- Primer for Metal Substrates

COLOR

Beige

Note: *Other colors available upon request, potentially for an additional charge and a minimum order size. Due to its chemical composition, FT-6069-N will discolor and chalk with exposure to UV radiation.*

CURING TIME AT 5 MILS DFT

Temperature	To Handle	To Recoat
90°F (32°C)	5 Hours	7 Hours
80°F (27°C)	7 Hours	9 Hours
70°F (21°C)	9 Hours	12 Hours
60°F (16°C)	16 Hours	22 Hours
50°F (10°C)	24 Hours	32 Hours

Curing time varies with surface temperature, air movement, humidity, and film thickness.

POT LIFE & SPRAY LIFE

Temperature	Pot Life Time	Spray Life Time
100°F (38°C)	1 Hour	-
75°F (24°C)	4 Hours	1 Hour
50°F (10°C)	6 Hours	-

COVERAGE RATES

	Dry Mils	Wet Mils	ft²/gal.
Suggested†	6 mils	9 mils	179 ft²/gal.
Minimum	2 mils	3 mils	537 ft²/gal.
Maximum	10 mils	15 mils	107 ft²/gal.

†Roller or brush application requires two or more coats to obtain recommended film thickness. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

TYPICAL PHYSICAL PROPERTIES

Property	Test Method	Value
Mix Ratio by Volume	NA	1:1
Recoat Window	Internal	36 hours
Volume Solids	NA	67% ± 2% (mixed)
VOC	NA	285 g/L
Net Weight per Gallon	NA	13.67 lbs ± 0.25 lbs

SURFACE PREPARATION

Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. Note: Commercial Blast Cleaning generally produces the best coating performance for this exposure. If conditions will not permit this, in moderate exposures FT-6069-N may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).

FREEDOMTUFF™ FT-6069-N

MIXING

Start with equal amounts of Part "A" and Part "B". Power mix contents of each container separately, ensuring no pigment remains on the bottom. Pour a measured amount of Part "B" into a clean container large enough to hold both components. Add an equal amount of Part "A" to Part "B" while under agitation. Continue mixing until the two components are thoroughly mixed. **Note:** Both components must be above 50°F (10°C) prior to mixing. For optimal mixing and application properties, the material should be above 60°F (16°C).

APPLICATION EQUIPMENT

Air Spray

Item	Recommendation
Gun	DeVilbiss JGA
Fluid Tip	E
Air Cap	765 or 704
Air Hose ID	5/16" or 3/8"
Material Hose ID	3/8" or 1/2"
Atomizing Pressure	50-80 psi
Pot Pressure	10-20 psi

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Item	Recommendation
Tip Orfice	0.015"-0.019"
Atomizing Pressure	3,000-4,800 psi
Material Hose ID	1/4" or 3/8"
Manifold Filter	60 mesh

Use appropriate tip/atomizing pressure for equipment, applicator technique, and weather conditions.

APPLICATION EQUIPMENT CONT...

Roller: Use 3/8" or 1/2" synthetic woven nap roller cover. Use longer nap to obtain penetration on rough surfaces. **Brush:** Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

- Minimum: 50°F (10°C)
- Maximum: 135°F (57°C)

The surface should be completely dry and at least 5°F (3°C) above the dew point and rising. Coating will not cure below minimum surface temperature.

CLEAN UP

User is responsible for reading, understanding, and following all recommendations on SDS. Dispose of all packaging and containers in accordance with local, state, and federal laws and regulations. Excess liquid materials should be mixed and allowed to cure. Once cured, dispose of cured material in accordance with local, state, and federal laws and regulations.

Flush and clean all equipment immediately after use with MEK.

SHELF LIFE & STORAGE

Shelf life is one (1) year from the date of manufacture in original, unopened, factory-sealed containers under specified storage conditions.

Shipping and storage temperatures is 65°F to 90°F at (or below) 50% Relative Humidity. Avoid freezing temperatures. Do not store containers directly on ground. Always store on pallets or otherwise elevated.

Do not open containers until ready to use. Partially filled containers should be purged of air using nitrogen blanketing and sealed tightly when not in use.