**Product Profile**

**Generic Description**
Polyamide Epoxy

**Common Usage**
A high-solids, low VOC, pure polyamide epoxy offering excellent protection to a wide range of substrates in atmospheric and immersion environments. Its fast-cure characteristics are ideal for shop or low temperature application. Versatile use as a primer, intermediate, or topcoat is complimented by a variety of finish coat options.

**Colors**
Refer to Tnemec Color Guide. **Note:** Epoxies chalk with extended exposure to sunlight and may yellow on aging. Lack of ventilation, incomplete mixing, miscatalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may accelerate any potential yellowing. **Note:** Special color bases are recommended for immersion service. Contact your Tnemec representative for more information.

**Finish**
Satin

**Coating System**

**Surface/ filler/patcher**
215, 217, 218

**Primers**
- **Steel:** Self-priming or Series 1, 20HS, FC20HS, 27, 27WB, 66HS, 90-97, 90-98, 90E-92, 90G-1K97, 91-H2O, 94-H2O, 135, 394, V380
- **Concrete:** Self-priming, 20HS, FC20HS, 66HS
- **CMU:** 130, 1254

**Topcoats**
46H-413, 27WB, 30, 72, 73, 104, 113, 114, 115, 141, 161HS, 262, 265, 290, 291, 740, 750, 1026, 1028, 1029, 1070, 1070V, 1071, 1071V, 1072, 1072V, 1074U, 1075, 1075U, 1080, 1081, 1095. **Note:** When topcoating Series 161HS, the following maximum recoat times apply: with 262 or 265, 7 days; with 740 or 750, 14 days; with 1095, 30 days; with itself, 46H-413, 27WB, 104, 113, 114, 290, 291, 1070, 1070V, 1071, 1071V, 1072, 1072V, 1080 or 1081, 60 days; with 72, 73, 1074, 1074U, 1075 or 1075U, 90 days. Scuff the Series 161HS surface before topcoating if maximum recoat time has elapsed.

**Surface Preparation**

**Primed Steel**
- **Immersion Service:** Scarify the epoxy prime coat surface by abrasive-blasting with a fine abrasive before topcoating if more than 60 days has elapsed since initial application.

**Steel**
- **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 Series 161HS may be applied to SSPC-SP2 or N/P3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).

**Galvanized steel & Non-Ferrous Metal**
Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

**Cast/Ductile Iron**
Contact your Tnemec representative or Tnemec Technical Services.

**Concrete**
Allow mortar to cure for 28 days. Prepare in accordance with SSPC-SP13/NACE 6 to level protrusions and mortar spatter and remove other contaminants.

**CMU**
Allow mortar to cure for 28 days. Prepare in accordance with SSPC-SP13/NACE 6 Surface Preparation of Concrete and Tnemec’s Surface Preparation and Application Guide.

**Painted Surfaces**
Non-Immersion Service: Ask your Tnemec representative for specific recommendations.

**All Surfaces**
Must be clean, dry and free of oil, grease and other contaminants.

**Technical Data**

**Volume Solids Recommended DFT**
78% ± 2% (mixed) †

2.0 to 10.0 mls (50 to 254 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

**Curing Time**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
<th>Immersion†</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>1 hour</td>
<td>6 hours</td>
<td>7-8 hours</td>
<td>5 days</td>
</tr>
<tr>
<td>65°F (18°C)</td>
<td>2 hours</td>
<td>6-8 hours</td>
<td>8-10 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>55°F (13°C)</td>
<td>3 hours</td>
<td>10-12 hours</td>
<td>14-16 hours</td>
<td>9 days</td>
</tr>
<tr>
<td>45°F (7°C)</td>
<td>5 hours</td>
<td>18-20 hours</td>
<td>22-24 hours</td>
<td>10 days</td>
</tr>
<tr>
<td>35°F (2°C)</td>
<td>6 hours</td>
<td>30 hours</td>
<td>36-40 hours</td>
<td>16 days</td>
</tr>
</tbody>
</table>

† For water immersion only. Chemical storage will require additional cure time. Curing time varies with surface temperature, air movement, humidity and film thickness.

**Volatile Organic Compounds**
- **Unthinned:** 1.53 lbs/gal (184 grams/litre)
- **Thinned 10% (No. 4 Thinner):** 2.02 lbs/gallon (242 grams/litre)
- **Thinned 20% (No. 4 Thinner):** 2.43 lbs/gallon (291 grams/litre) †

**THEORETICAL COVERAGE**
1,248 mil sq ft/gal (30.7 m²/L at 25 microns). See APPLICATION for coverage rates. †
Two: Part A (epoxy) and Part B (polyamide)

One (Part A) to one (Part B) by volume.

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
<th>When Mixed Yield</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>6 gallon pail (partially filled)</td>
<td>5 gallon pail</td>
<td>10 gallons (37.9 L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 gallon can</td>
<td>2 gallons (7.57 L)</td>
</tr>
</tbody>
</table>

13.03 lbs ± 0.25 lbs (5.91 ± .11 kg) (mixed)

Minimum 20°F (-7°C) Maximum 110°F (43°C)

(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

Part A: 24 months; Part B: 24 months at recommended storage temperature.

Part A: 80°F (29°C) Part B: 105°F (41°C)

Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product. Keep out of the reach of children.

APPLICATION

COVERAGE RATES

<table>
<thead>
<tr>
<th></th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested</td>
<td>5.0 (125)</td>
<td>6.5 (165)</td>
<td>250 (23.2)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>2.5 (65)</td>
<td>625 (58.0)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (254)</td>
<td>13.0 (330)</td>
<td>125 (11.6)</td>
</tr>
</tbody>
</table>

Note: Roller or brush application may require two or more coats to obtain recommended film thickness. Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING

Power mix contents of each container, making sure 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 volume of Part A to Part B while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits.

Note: For applications between 35°F to 50°F (2°C to 10°C), allow mixed material to stand thirty (30) minutes and restir before using. To avoid this induction time, both components should be above 50°F (10°C) prior to mixing. Mixing ratio is one to one by volume.

THINNING

For air, airless spray, roller or brush applications, thin up to 10% or 12.8 ounces (380 mL) per gallon with No. 4 Thinner. For a finer finish, thin up to 20% or 25.6 ounces (760 mL) per gallon with No. 4 Thinner.

POT LIFE & SPRAY LIFE

<table>
<thead>
<tr>
<th></th>
<th>Temperature</th>
<th>Pot Life</th>
<th>Spray Life</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>75°F (24°C)</td>
<td>1.5 hours</td>
<td>75 minutes</td>
</tr>
<tr>
<td></td>
<td>55°F (13°C)</td>
<td>2 hours</td>
<td>1.5 hours</td>
</tr>
</tbody>
</table>

10% Thinning:

<table>
<thead>
<tr>
<th></th>
<th>Temperature</th>
<th>Pot Life</th>
<th>Spray Life</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>75°F (24°C)</td>
<td>2.5 hours</td>
<td>1.5 hours</td>
</tr>
<tr>
<td></td>
<td>55°F (13°C)</td>
<td>3 hours</td>
<td>2 hours</td>
</tr>
</tbody>
</table>

20% Thinning:

<table>
<thead>
<tr>
<th></th>
<th>Temperature</th>
<th>Pot Life</th>
<th>Spray Life</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>75°F (24°C)</td>
<td>5 hours</td>
<td>2 hours</td>
</tr>
<tr>
<td></td>
<td>55°F (13°C)</td>
<td>6 hours</td>
<td>3 hours</td>
</tr>
</tbody>
</table>

APPLICATION EQUIPMENT

Air Spray

<table>
<thead>
<tr>
<th>Gun</th>
<th>Fluid Tip</th>
<th>Air Cap</th>
<th>Air Hose ID</th>
<th>Mat'l Hose ID</th>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16&quot; or 5/8&quot; (7.9 or 9.5 mm)</td>
<td>3/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>50-80 psi (3.4-5.5 bar)</td>
<td>20-25 psi (1.4-1.7 bar)</td>
</tr>
</tbody>
</table>

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

<table>
<thead>
<tr>
<th>Tip Orifice</th>
<th>Atomizing Pressure</th>
<th>Mat'l Hose ID</th>
<th>Manifold Filter</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.015&quot;-0.021&quot; (380-530 microns)</td>
<td>3000-4500 psi (207-510 bar)</td>
<td>3/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

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

Note: A minimum pump size of 45:1 is required for proper airless spray application.

Roller: Use 3/8" or 1/2" (9.5 mm to 12.7 mm) high quality synthetic woven nap covers.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

Minimum 35°F (2°C) Maximum 135°F (57°C)

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

CLEANUP

Flush and clean all equipment immediately after use with No. 4 Thinner or MEK.

† Values may vary with color.
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