



PRODUCT PROFILE

**GENERIC DESCRIPTION** Polyamide Epoxy

**COMMON USAGE** Industry standard for potable water epoxy coatings for nearly 30 years. Known for its forgiving application characteristics in adverse and varied conditions, and for its benchmark performance.

**COLORS** 1211 Red, 1255 Beige, 11WH White, 15BL Tank White, 39BL Delft Blue.  
**Note:** Epoxies chalk with extended exposure to sunlight. 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 cause yellowing to occur.

**SPECIAL QUALIFICATIONS** Certified by **NSF International** in accordance with **ANSI/NSF Std. 61**. Ambient air cured Series 20 is qualified for use on the interior of potable water storage tanks and reservoirs of 5,000 gallons (18,927 L) capacity or greater. Conforms to **AWWA D 102 Inside Systems No. 1 and 2**. Contact your Tnemec representative for approved systems and additional information on potential uses.

**PERFORMANCE CRITERIA** Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

**PRIMERS** Self-priming, 1, FC20, N140, N140F, 91-H<sub>2</sub>O, 94-H<sub>2</sub>O. **Note:** 91-H<sub>2</sub>O is ANSI/NSF Std. 61 certified by UL as a primer for Series 20. Refer to the 91-H<sub>2</sub>O product data sheet for additional information.

**TOPCOATS** **Interior:** Series 20, FC20, N140, N140F, 264, 265  
**Exterior:** Series 20, FC20, 66, N69, N69F, 73, N140, N140F, 161, 700, 701, 1074, 1075. **Note:** When topcoating with Series 700 or 701, an intermediate coat of Series 73 or 1075 is required. Refer to COLORS on applicable topcoat data sheets for additional information.

SURFACE PREPARATION

**STEEL** **Immersion Service:** SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum angular anchor profile of 1.5 mils. **Non-Immersion Service:** SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

**CAST/DUCTILE IRON** Contact your Tnemec representative or Tnemec Technical Services.

**CONCRETE** Allow new concrete to cure for 28 days. Abrasive blast referencing SSPC-SP13/NACE 6, ICRI CSP 2-3 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide. Holes, pits, voids and cracks should be filled with 63-1500 Filler and Surfacer.

**PRIMED SURFACES** **Immersion Service:** Scarify the Series 20 or FC20 prime coat by brush-blasting with fine abrasive before topcoating if it has been exterior exposed for 60 days or longer.

**ALL SURFACES** Must be clean, dry and free of oil, grease, chalk and other contaminants.

TECHNICAL DATA

**VOLUME SOLIDS** 57.0 ± 2.0% (mixed) †

**RECOMMENDED DFT** 2.0 to 6.0 mils (50 to 150 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME	Temperature	To Handle	To Recoat	Immersion
		75°F (24°C)	10 hours	12 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.  
**Ventilation:** When used in enclosed areas, provide adequate ventilation during application and cure.

**VOLATILE ORGANIC COMPOUNDS** **Unthinned:** 3.02 lbs/gallon (362 grams/litre)  
**Thinned 10%:** 3.37 lbs/gallon (404 grams/litre) †

**HAPS** **Unthinned:** 4.18 lbs/gal solids  
**Thinned 10%:** 5.16 lbs/gal solids

**THEORETICAL COVERAGE** 898 mil sq ft/gal (22.0 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS** Two: Part A and Part B

**PACKAGING** 5 gallon (18.9L) pails and 1 gallon (3.79L) cans — Order in multiples of 2.

**NET WEIGHT PER GALLON** 12.50 ± 0.25 lbs (5.7 ± .11 kg) (mixed) †

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

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

**SHELF LIFE** Part A: 24 months at recommended storage temperature.  
 Part B: 12 months at recommended storage temperature.

**FLASH POINT - SETA** Part A: 82°F (28°C) Part B: 64°F (18°C)

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

# POTA-POX® | SERIES 20

**APPLICATION**

**COVERAGE RATES**

	Dry MILS (MICRONS)	Wet MILS (MICRONS)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Suggested	4.0 (100)	7.0 (180)	225 (20.9)
Minimum	2.0 (50)	3.5 (90)	450 (41.8)
Maximum	6.0 (150)	10.5 (265)	150 (13.9)

**Note:** The above reflects the total range to which Series 20 can be applied for specific applications. To insure the proper thickness and number of coats is specified for certain substrates and exposures, consult the Tnemec Guide Specifications and/or contact your Tnemec representative. **Note:** Roller or brush application requires two or more coats to obtain recommended film thickness. Allow for overspray and surface irregularities. 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:** Both components must be above 50°F (10°C) prior to mixing. For application to surfaces between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C). Mixing ratio is one (Part A) to one (Part B) by volume.

**THINNING**

Use No. 4 Thinner. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, roller or brush, thin up to 5% or 1/4 pint (190 mL) per gallon. **Caution: Series 20 NSF certification is based on thinning with No. 4 Thinner. Use of any other thinner voids ANSI/NSF Std. 61 certification.**

**POT LIFE**

20 hours at 50°F (10°C) 10 hours at 77°F (25°C) 4 hours at 100°F (38°C)

**APPLICATION EQUIPMENT**

**Air Spray**

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E .070"	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-100 psi (5.2-6.9 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

**Airless Spray**

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	1800-3000 psi (124-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

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

**Plural Component Spray:** Contact your Tnemec representative or Tnemec Technical Services.

**Roller:** Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic woven nap covers.

**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 dry and at least 5°F (3°C) above the dew point. Coating won't cure below minimum surface temperature.

**CLEANUP**

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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