**Product Profile**

**Generic Description**
Polyamide Epoxy

A high-solids, lower VOC version of Tnemec’s proven polyamide epoxy technology. Provides excellent protection to steel and concrete substrates, and is certified for use in potable water immersion. Excellent choice for tanks, valves, and pipes.

**Colors**
1211 Red, 1255 Beige, 00WH Tnemec White, 15BL Tank White, 35GR Black and 39BL Delft Blue. **Note:** Epoxies chalk with extended exposure to sunlight and may yellow on aging. Lack of ventilation, incomplete mixing, mis-catalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may accelerate any potential yellowing.

**Finish**
Satin

Certified by NSF International in accordance with NSF/ANSI Std. 61. Seven day ambient air cured Series 20HS is qualified for interior use on tanks and reservoirs of 300 gallons (1,135 L) capacity or greater, pipes 18 inches (46 cm) in diameter or greater, valves 3.5 inches (9 cm) in diameter or greater, fittings 1 inch (2.5 cm) in diameter or greater and pumps 5.5 inches (9 cm) in diameter or greater. Sixty day ambient air cured Series 20HS is qualified for use on pipes 14 inches (35 cm) in diameter or greater. Reference the "Search Listing" section of the NSF website at www.nsf.org for details on the maximum allowable DFT. Conforms to AWWA D102 Inside Systems No.1 and No.2. Conforms to AWWA C210 (without 44-705). Contact your Tnemec representative for systems and additional information.

**Technical Data**

**Volume Solids**
78% ± 2.0% (mixed) †

**Recommended DFT**
2.0 to 10.0 mils (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>95°F (35°C)</td>
<td>1 hour</td>
<td>3 hours</td>
<td>6-7 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>75°F (24°C)</td>
<td>2 hours</td>
<td>8 hours</td>
<td>12-16 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>55°F (13°C)</td>
<td>4 hours</td>
<td>22-24 hours</td>
<td>40-54 hours</td>
<td>12-14 days</td>
</tr>
</tbody>
</table>

Curing time varies with surface temperature, air movement, humidity and film thickness. **Note:** For faster curing and low temperature applications, add No. 44-705 Epoxy Accelerator, see separate product data sheet for cure information.

**Volatile Organic Compounds**

| HAPs | Unthinned: 1.17 lbs/gal solids | Thinned 10% (No. 4 Thinner): 1.88 lbs/gal solids |

**Theoretical Coverage**

1,249 mil sq ft/gal (30.7 m²/L at 25 microns). See APPLICATION for coverage rates. †

**Number of Components**
Two. Part A (epoxy) and Part B (polyamide)

**Mixing Ratio**
One (Part A) to one (Part B) by volume.
**APPLICATION**

**COVERAGE RATES**

<table>
<thead>
<tr>
<th>Part A</th>
<th>Part B</th>
<th>When Mixed Yield</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>5 gallon pail</td>
<td>5 gallon pail</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 gallon can</td>
</tr>
</tbody>
</table>

13.11 lbs ± 0.25 lbs (5.95 ± 1.11 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 (27°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.

**MIXING**

Powers 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. If using Series 44-705 accelerator, slowly add three (3) fluid ounces per gallon to the Series 20HS material while under agitation. **Note:** The use of more than the recommended amount of 44-705 will adversely affect performance.

Thin by volume and thoroughly mix. Failure to thoroughly mix the Part A and Part B components prior to thinning can affect product's gloss and performance. Do not use mixed material beyond pot life limits. **Note:** For applications between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. To avoid thinning induction time, both components should be above 60°F (16°C) prior to mixing. Mixing ratio is one to one by volume.

For air, airless spray, roller or brush applications thin up to 10% or 12.8 ounces (380 mL) per gallon with No. 4 Thinner. **Caution:** Series 20HS NSF/ANSI Std. 61 certification is based on thinning with No. 4 Thinner. Use of any other thinner voids NSF/ANSI Std. 61 certification.

**THINNING**

**POT LIFE & SPRAY LIFE**

**APPLICATION EQUIPMENT**

**Air Spray**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Pot Life</th>
<th>Spray Life</th>
</tr>
</thead>
<tbody>
<tr>
<td>95°F (35°C)</td>
<td>2 hours</td>
<td>75 minutes</td>
</tr>
<tr>
<td>75°F (24°C)</td>
<td>2.5 hours</td>
<td>1.5 hours</td>
</tr>
<tr>
<td>55°F (13°C)</td>
<td>4 hours</td>
<td>1.5 hours</td>
</tr>
</tbody>
</table>

**Airless Spray**

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

**Roller**

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

**Surface Temperature**

Minimum 50°F (10°C)  | Maximum 155°F (7°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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**PACKAGING**

<table>
<thead>
<tr>
<th>NET WEIGHT PER GALLON</th>
<th>STORAGE TEMPERATURE</th>
<th>TEMPERATURE RESISTANCE</th>
<th>SHELF LIFE</th>
<th>FLASH POINT - SETA</th>
<th>HEALTH &amp; SAFETY</th>
<th>COVERAGE RATES</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>5 gallon pail</td>
<td>5 gallon pail</td>
<td>10 gallons (37.9 L)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 gallon can</td>
<td>2 gallons (7.57 L)</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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**LTD**

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