PRODUCT PROFILE

GENERIC DESCRIPTION
Polyamide Epoxy

COMMON USAGE
A multi-purpose epoxy coating with fast-cure and low temperature application properties. An excellent choice for shop and field application when rapid curing for fast turn-around is needed. Can be applied to a variety of substrates including steel, concrete, and CMU, as well as previously painted surfaces. Accepts a range of primers and topcoats for complete system selection.

COLORS
Available in light- and mid-tone colors. Deep-tone and safety colors may be limited. Contact your Tnemec Representative for more information.

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.

FINISH
Flat

COATING SYSTEM

PRIMERS
Steel: Self-priming or Series 1, 90-97, 135, 394
Concrete or CMU: Self-priming or Series 215, 218, 1254, 130

TOPCOATS
Series 73, 1026, 1028, 1029, 1074, 1075, 1095

Note: Other primer and topcoat options may be available. Contact your Tnemec Coatings Consultant for more information.

SURFACE PREPARATION

STEEL
SSPC-SP6/NACE 3 Commercial Blast Cleaning

CONCRETE
Allow new concrete to cure for 28 days. Abrasive blast referencing SSPC-SP13/NACE 6, ICRI-CSP3-5 Surface Preparation of Concrete and Tnemec’s Surface Preparation and Application Guide.

CMU
Allow mortar to cure for 28 days. Level protrusions and mortar spatter.

OVERCOATING
For overcoat applications, reference the latest revision of Tnemec Technical Bulletin No. 98-10 and contact your Tnemec representative.

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

TECHNICAL DATA

VOLUME SOLIDS
58.0 ± 2.0% (mixed) †

RECOMMENDED DFT
4.0 to 6.0 mils (100 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

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>To Recoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>1/2 hour</td>
<td>2 hours</td>
<td>3 hours</td>
</tr>
<tr>
<td>65°F (18°C)</td>
<td>3/4 hour</td>
<td>4 hours</td>
<td>5-6 hours</td>
</tr>
<tr>
<td>55°F (11°C)</td>
<td>1 hour</td>
<td>4-5 hours</td>
<td>6-8 hours</td>
</tr>
<tr>
<td>45°F (7°C)</td>
<td>1-2 hours</td>
<td>6-8 hours</td>
<td>9-12 hours</td>
</tr>
<tr>
<td>35°F (2°C)</td>
<td>2-3 hours</td>
<td>9-12 hours</td>
<td>12-15 hours</td>
</tr>
</tbody>
</table>

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

VOLATILE ORGANIC COMPOUNDS
Unthinned: 2.36 lbs/gallon (282 grams/litre)
Thinned 10% (No. 60 Thinner): 2.85 lbs/gallon (359 grams/litre)
Thinned 10% (No. 4 Thinner): 2.83 lbs/gallon (359 grams/litre) †

HAPS
Unthinned: 2.59 lbs/gal solids
Thinned 10% (No. 60 Thinner): 2.59 lbs/gal solids
Thinned 10% (No. 4 Thinner): 3.54 lbs/gal solids

THEORETICAL COVERAGE
930 mil sq ft/gal (22.8 m²/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
14.22 ± 0.25 lbs (6.45 ± .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
24 months at recommended storage temperature

FLASH POINT - SETA
Part A: 82°F (28°C) Part B: 80°F (27°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.

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### Application

<table>
<thead>
<tr>
<th>Coverage Rates</th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum (1)</td>
<td>4.0 (100)</td>
<td>7.0 (180)</td>
<td>233 (21.6)</td>
</tr>
<tr>
<td>Maximum</td>
<td>6.0 (150)</td>
<td>10.5 (265)</td>
<td>155 (14.4)</td>
</tr>
</tbody>
</table>

(1) Note: Roller or brush application requires 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: Both components should be above 50°F (10°C) prior to mixing. For applications to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, the material temperature should be above 60°F (16°C).

### Thinning

Use No. 60 or No. 4 Thinner. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, brush or roller, thin up to 5% or 1/4 pint (190 mL) per gallon.

### Pot Life

16 hours at 35°F (2°C)  2 hours at 77°F (25°C)  1/2 hour at 100°F (38°C)

### Application Equipment

- **Gun**
- **Fluid Tip**
- **Air Cap**
- **Air Hose ID**
- **Mat'l Hose ID**
- **Atomizing Pressure**
- **Pot Pressure**

| DeVilbiss JGA | E | 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) | 25-35 psi (1.7-2.4 bar) |

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;-0.019&quot; (380-485 microns)</td>
<td>4000-4800 psi (276-351 bar)</td>
<td>1/4&quot; or 3/8&quot; (6.4 or 9.5 mm)</td>
<td>60 mesh (250 microns)</td>
</tr>
</tbody>
</table>

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

### Roller

Roller application optional when environmental restrictions do not allow spraying. Use 5/8" 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 35°F (2°C)  Maximum 155°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 the recommended thinner or MEK.

† Values may vary with color.