PRODUCT PROFILE

**GENERIC DESCRIPTION**

A high-solids, low VOC epoxy coating used for a multitude of primer and topcoat applications. The tough, abrasion-resistant film of Series 49 provides durable protection to concrete, CMU, and steel, and it is immersion grade, making it an excellent choice for non-potable service environments. Excellent adhesion properties allow for use on marginally prepared surfaces when blast cleaning is not possible.

**COMMON USAGE**

Available in light- and mid-tone colors. Deep-tone and safety colors may be limited. Contact your Tnemec Representative for more information. Note: Epoxy chalk with extended exposure to sunlight, 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.

**COLORS**

Semi-gloss. Gloss can vary with texture, porosity of substrate and thickness of film.

**FINISH**

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

**NUMBER OF COMPONENTS**

Two: Part A (amine) and Part B (epoxy)

**THEORETICAL COVERAGE**

1.60 lbs/gal solids
Thinned 10% (No. 49 Thinner): 1.92 lbs/gal (250 grams/litre)
Thinned 10% (No. 2 Thinner): 0.80 lbs/gal (96 grams/litre)

**STORAGE TEMPERATURE**

Part A: 24 months; Part B: 12 months at recommended storage temperature

**CURING TIME**

Minimum 20°F (-7°C)   Maximum 120°F (49°C)

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

**FLASH POINT - SETA**

For optimum application properties, material temperature must be above 60°F (16°C) prior to application.

**SHELF LIFE**

Part A & Part B: 81°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.**

**CONSULTANT**

Contact your Tnemec Coatings Consultant for more information.

**PRODUCT DATA SHEET**

SERIES 49

**VOLUME SOLIDS**

82.0 ± 2.0% (mixed) †

**RECOMMENDED DFT**

4.0 to 10.0 mils (100 to 255 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 Handle</th>
<th>To Recoat</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>6-10 hours</td>
<td>16-18 hours ‡</td>
<td>7 days</td>
</tr>
</tbody>
</table>

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

‡ Maximum recoat time with itself is 21 days. If more than 21 days have elapsed between coats of Series 49 the coated surface must be scarified before topcoating.

**VOLATILE ORGANIC COMPOUNDS**

EPA Method 24 †

Unthinned: 0.80 lbs/gallon (96 grams/litre)
Thinned 10% (No. 2 Thinner): 1.92 lbs/gallon (250 grams/litre)
Thinned 10% (No. 49 Thinner): 0.80 lbs/gallon (96 grams/litre)

HAPS

Unthinned: 1.60 lbs/gal solids
Thinned 10% (No. 2 Thinner): 2.50 lbs/gal solids
Thinned 10% (No. 49 Thinner): 1.60 lbs/gal solids

**THEORETICAL COVERAGE**

1,315 mil sq ft/gal (32.3 m²/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS**

Two. Part A (amine) and Part B (epoxy)

**PACKAGING**

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

**NET WEIGHT PER GALLON**

14.70 ± 0.25 lbs (6.67 ± 0.11 kg) (mixed) †

**STORAGE TEMPERATURE**

Minimum 20°F (-7°C)   Maximum 120°F (49°C)

**TEMPERATURE RESISTANCE**

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

**SHELF LIFE**

Part A: 24 months; Part B: 12 months at recommended storage temperature

**FLASH POINT - SETA**

Part A & Part B: 81°F (27°C)

**APPLICATION**

Must be clean, dry and free of oil, grease, chalk and other contaminants.
**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</td>
<td>4.0 (100)</td>
<td>5.0 (125)</td>
<td>329 (30.5)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (255)</td>
<td>12.0 (305)</td>
<td>131 (12.2)</td>
</tr>
</tbody>
</table>

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 60°F (16°C) prior to mixing. Mixing ratio is one to one by volume. A large volume of material will set up quickly if not applied or reduced in volume. Caution: Do not reseal mixed material. An explosion hazard may be created.

**THINNING**

Use No. 2 Thinner. For air spray, airless spray or roller, thin up to 10% or 3/4 pint (380 mL) per gallon. For air pollution regulations.

**POT LIFE**

<table>
<thead>
<tr>
<th>Air Spray</th>
<th>2 1/2 hours at 60°F (16°C)</th>
<th>2 hours at 77°F (25°C)</th>
<th>1 hour at 100°F (38°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Low temperatures or longer hoses require higher pot pressure.</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Application Equipment</th>
<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 JGC</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16&quot; or 3/8&quot; (7.9 or 9.5 mm)</td>
<td>5/8&quot; or 1/2&quot; (9.5 or 12.7 mm)</td>
<td>60-90 psi (4.2-6.2 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
<td></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 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic woven nap covers. Note: When applying to concrete or CMU, the coating must be brushed, rolled, or sprayed and back-rolled. Two coats are normally recommended for lightweight block.

**BRush** Recommended for small areas only. Use high quality natural or synthetic bristle brushes. Note: Two or more coats may be required to obtain recommended film thicknesses.

**SURFACE TEMPERATURE**

<table>
<thead>
<tr>
<th>Minimum 60°F (16°C)</th>
<th>Maximum 135°F (57°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>The surface should be dry and at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature.</td>
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</table>

**CLEANUP**

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

† Values may vary with color.

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