**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Acrylic Copolymer Blend

**COMMON USAGE**
Phylon 624 is a unique acrylic copolymer, formulated to meet VOC requirements for curing compounds. Phylon 624 is a non-yellowing curing, sealing, hardening, dust-proofing and water repellent compound that exhibits a tough, long lasting, glossy film. Phylon 624 is designed for use on exterior and interior slabs as well as above grade architectural concrete.

**COLORS**
Clear. Dries to a clear, glossy finish.

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

**COATING SYSTEM**

**WATER REPELLENT PRETREATMENT**
Series 624 can be applied in conjunction with a solvent-based Series 660 or 664 water-repellent. Allow the water-repellent pretreatment to cure between 12 and 36 hours before applying Series 624.

**SURFACE PREPARATION**

**SEALING, HARDENING, DUSTPROOFING & WATER REPELLENT**
When using this product to seal, harden, dustproof or provide water repellency to concrete and masonry substrates, allow new concrete and mortar to cure 28 days. Verify dryness by testing for moisture with a “plastic film tape-down test” (Reference ASTM D 2803). Should moisture be detected on a horizontal surface, perform “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” (Reference ASTM 1869). Moisture content not to exceed three pounds per 1,000 sq. ft. in a 24-hour period.

Existing horizontal installations should be pressure washed to remove any water-soluble contaminants, loose or broken cement paste and aggregate. Following pressure washing, the surfaces should readily absorb water and show no signs of water beading.

Large voids, and other cavities should be filled with recommended filler or surfacer. Fill all cracks and re-point mortar joints if necessary. All surfaces to be treated must be sound, dry and free of dirt, oils, efflorescence, paint, curing compounds and all other contaminants, which may affect the performance of Phylon 624.

Protect glass, wood and other surfaces that are not intended to be treated from overspray. Any overspray should be removed immediately with lacquer thinner or toluene. Protect asphaltic surfaces, trees, shrubs and other landscaping from overspray.

When using this product to cure new concrete apply as soon as possible after the concrete has received final finishing, just as water sheen disappears and the concrete is hard enough to walk on. If application is delayed concrete must be kept wet (preferably by water spray mist) before application. Apply the first coat at 300-400 sq. ft./gal (7.5-10m²/L). A second coat is recommended for long-term durability.

**CURING NEW CONCRETE**
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**PREVIOUSLY COATED SURFACES**
A test patch is required prior to application on previously coated surfaces. Reference the latest version of Technical Bulletin 98-10.

**TECHNICAL DATA**

**VOLUME SOLIDS**
33.0 ± 2.0%

**CURING TIME**
Series 624 is fully cured for light traffic bearing within 72 hours at 75°F (24°C). Application at temperatures lower than 40°F (4°C) may reduce coverage rates and inhibit curing. Protect treated surfaces from rain and lawn sprinklers for 72 hours. Allow the water-repellent pretreatment to cure between 12 and 36 hours, then apply Series 624.

**VOLATILE ORGANIC COMPOUNDS**
Unthinned: 2.96 lbs/gallon (354 grams/litre)

**PACKAGING**
5 gallon (18.96 L) pails and 55 gallon (208.2 L) drums

**NET WEIGHT PER GALLON**
7.40 ± 0.25 lbs (3.36 ± .11 kg)

**STORAGE TEMPERATURE**
Minimum 35°F (2°C) Maximum 100°F (38°C)

**SHELF LIFE**
24 months at recommended storage temperature.

**FLASH POINT - SETA**
-4°F (-20°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.

Use only in well-ventilated or open areas. Use of respirators is mandatory when using this product in confined areas. Special precautions should be taken to avoid vapor transmission (fumes) from entering the building being treated. Ventilation systems and fresh air intakes should be turned off and closed. All direct routes of vapor ingress such as windows and doors must be secure. Notify occupants of the building prior to application, as vapors may be irritating. Use of gloves, goggles and other protective clothing is advised when using this product.

Keep out of the reach of children.
APPLICATION

COVERAGE RATES

Coverage rates are guidelines and will vary depending upon the texture of the surface and porosity of the substrate.

<table>
<thead>
<tr>
<th>Substrate</th>
<th>Sq. Ft./Gal.</th>
<th>m²/litre</th>
</tr>
</thead>
<tbody>
<tr>
<td>Non-Porous Floors</td>
<td>400 - 500</td>
<td>10.0 - 12.5</td>
</tr>
<tr>
<td>Porous Floors</td>
<td>250 - 300</td>
<td>6.3 - 7.5</td>
</tr>
<tr>
<td>CMU (porous)</td>
<td>75 - 100</td>
<td>1.8 - 2.5</td>
</tr>
<tr>
<td>CMU (normal)</td>
<td>100 - 125</td>
<td>2.5 - 3.1</td>
</tr>
<tr>
<td>Concrete</td>
<td>125 - 200</td>
<td>2.5 - 4.9</td>
</tr>
<tr>
<td>Stucco</td>
<td>100 - 125</td>
<td>2.5 - 3.1</td>
</tr>
<tr>
<td>Precast</td>
<td>150 - 200</td>
<td>3.7 - 4.9</td>
</tr>
<tr>
<td>Fired Clay Brick</td>
<td>150 - 200</td>
<td>3.7 - 4.9</td>
</tr>
</tbody>
</table>

Prior to application, a test area must be performed to determine proper application rate and required surface preparation. Product is supplied ready to use. Thoroughly mix before applying.

Do not thin.

APPLICATION EQUIPMENT

Apply using airless paint spray equipment, brush or deep nap roller. When using airless sprayer, use a 0.015 or 1.018 fan spray tip and reduce pressure to point of minimal misting or fogging to produce a wet application. Product forms a surface film quickly depending on temperature, humidity and wind conditions.

**Spray Unit:**
Apply by low-pressure high volume commercial grade solvent resistant sprayer with neoprene fittings. If spraying and back rolling, best application is to spray enough material that a second person can immediately back roll following the spray applicator. Follow roller instructions below. **Caution: Do not delay the back roll as the area will dry quickly.**

**Roller:**
Use only 1/4" nap mohair rollers. Do not over-work material; apply in a single lapping motion. Do not roll area back and forth, this can cause the product to become stringy. Do not run roller dry, keep a wet edge and do sections small enough to roll only once over wet material. Do not roll over dry material. Over rolling or using incorrect rollers will cause bubbles to form in the coating. Material should not be allowed to puddle. Disperse with a broom or squeegee excess. Do not allow sealed area to become wet with water until material has cured and is dry (reference cure table). Protect all areas from overspray. The sealer can be applied to damp surfaces; do not apply over puddled water. A uniform appearance requires even coats leaving no gaps. Some areas may be more porous than others, these areas may require additional coats to even out the appearance. **Caution: Do not over-apply material.**

SURFACE TEMPERATURE

Minimum 60°F (4°C)  Maximum 120°F (49°C)

Do not apply in direct sunlight when air temperature exceeds 90°F (32°C).

MAINTENANCE

Spills should be removed promptly and cleaned with a neutral (non-solvent) cleaner. Floors should be cleaned regularly. Periodic reapplication may be required as the sealer wears off.

CLEANUP

Clean all equipment immediately after use with lacquer thinner or toluene.