**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Polyamide Epoxy

**COMMON USAGE**
A high-solids, low VOC, pure polyamide epoxy that offers exceptional protection to a variety of substrates in atmospheric and immersion environments. Applied as a primer, intermediate, or topcoat, this versatile coating also accepts a wide-range of finish coats, allowing for a coating system tailored to specific exposure conditions.

**COLORS**
Refer to Tnemec Color Guide. **Note:** Epoxies chalk with extended exposure to sunlight and may yellow on aging. Lack of ventilation, incomplete mixing, miscalculation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may accelerate any potential yellowing. Special color bases are recommended for immersion service. Contact your Tnemec representative for more information.

**FINISH**
Satin

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**COATING SYSTEM**

**SURFACE/FILLER/PATCHER**

<table>
<thead>
<tr>
<th>Surface Type</th>
<th>Type</th>
<th>Blend</th>
<th>Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steel</td>
<td>Self-priming or Series 1, 20HS, FC20HS, 27, 27WB, 90-97, 90E-92, 90G-1K97, 91-H2O, 94-H2O, 394, V530, 161HS</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Concrete</td>
<td>Self-priming, 20HS, FC20HS, 161HS</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**PRIMERS**

<table>
<thead>
<tr>
<th>Surface Type</th>
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<td>Self-priming, 20HS, FC20HS, 161HS</td>
<td></td>
<td></td>
</tr>
<tr>
<td>CMU</td>
<td>Self-priming, 130, 1254</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**TOPCOATS**

<table>
<thead>
<tr>
<th>Surface Type</th>
<th>Type</th>
<th>Blend</th>
<th>Application</th>
</tr>
</thead>
<tbody>
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<td></td>
</tr>
<tr>
<td>CMU</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**SURFACE PREPARATION**

**PRIMED STEEL**

**Immersion Service:** Scuff the epoxy primer coat surface by abrasive-blasting with a fine abrasive before topcoating if more than 60 days has elapsed since initial application.

**Steel**

**Immersion Service:** SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

**Non-Immersion Service:** SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. **Note:** Commercial Blast Cleaning generally produces the best coating performance for this exposure. If conditions will not permit this, in moderate exposures Series 66HS may be applied to SSPC-Mf2 or Sf3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).

**Galvanized Steel & Non-Ferrous Metal**

Surface preparation recommendations will vary depending on substrate and exposure conditions. Consult the latest version of Tnemec Technical Bulletin 10-78 or contact your Tnemec representative or Tnemec Technical Services.

**Cast/Ductile Iron**

Contact your Tnemec representative or Tnemec Technical Services.

**Concrete**

Allow mortar to cure for 28 days. Prepare in accordance with SSPC-SP13/NACE 6 to level protrusions and mortar spatter and remove other contaminants.

**Painted Surfaces**

**Non-Immersion Service:** Ask your Tnemec representative for specific recommendations.

**All Surfaces**

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

**TECHNICAL DATA**

**VOLUME SOLIDS**

<table>
<thead>
<tr>
<th>Blend</th>
<th>Solids Content</th>
</tr>
</thead>
<tbody>
<tr>
<td>Recommended DFT</td>
<td>78% ± 2.0% (mixed)†</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Blend</th>
<th>Solids Content</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.0 to 10.0 mils (50 to 254 microns) per coat</td>
<td><strong>Note:</strong> Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.</td>
</tr>
</tbody>
</table>

**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>50-54 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: 1.54 lbs/gallon (384 grams/litre)

Thinned 10% (No. 4 Thinner): 2.02 lbs/gallon (243 grams/litre)

Thinned 20% (No. 4 Thinner): 2.43 lbs/gallon (292 grams/litre)

**THEORETICAL COVERAGE**

1,249 ml 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.

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**HI-BUILD EPoxoline® | SERIES 66HS**

### Packaging

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Large Kit</strong></td>
<td>6 gallon pail</td>
<td>5 gallon pail</td>
<td>10 gallons (37.9 L)</td>
</tr>
<tr>
<td><strong>Small Kit</strong></td>
<td>1 gallon can</td>
<td>1 gallon can</td>
<td>2 gallons (7.57 L)</td>
</tr>
</tbody>
</table>

**Net Weight Per Gallon:**
- Large Kit: 13.11 lbs ± 0.25 lbs (5.95 ± .11 kg) (mixed)
- Small Kit: 13.11 lbs ± 0.25 lbs (5.95 ± .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
- Part B: 24 months

**Flash Point - Seta:**
- Part A: 85°F (29°C)
- Part B: 105°F (41°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.

### Coverage Rates

<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>Suggested</td>
<td>5.0 (125)</td>
<td>6.5 (165)</td>
<td>250 (23.2)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>2.5 (65)</td>
<td>626 (58.1)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (254)</td>
<td>13.0 (330)</td>
<td>125 (11.6)</td>
</tr>
</tbody>
</table>

**Note:** Roller or brush application may require two or more coats to obtain recommended film thickness. 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.
- If using Series 44-705 accelerator, slowly add three (3) fluid ounces per gallon of the Series 66HS material while under agitation.

**Note:** The use of more than the recommended amount of 44-705 will adversely affect performance.

### Thinning

- 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.
- For air, airless spray, roller or brush applications thin up to 10% or 12.8 ounces (380 mL) per gallon with No. 4 Thinner.
- For a finer finish, thin up to 20% or 25.6 ounces (760 mL) per gallon with No. 4 Thinner.

### Pot Life & Spray Life

<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>

**10% Thinning**
- Temperature: 95°F (35°C)
- Pot Life: 2 hours
- Spray Life: 75 minutes

**20% Thinning**
- Temperature: 95°F (35°C)
- Pot Life: 3 hours
- Spray Life: 1.5 hours

### Application Equipment

**Air Spray**
- Gun: DeVilbiss JGA E
- Fluid Tip: 765 or 704
- Air Cap: 5/16" or 5/8" (7.9 or 9.5 mm)
- Mat'l Hose ID: 3/8" or 1/2" (9.5 or 12.7 mm)
- Atomizing Pressure: 50-80 psi (3.4-5.5 bar)
- Pot Pressure: 20-25 psi (1.4-1.7 bar)

**Airless Spray**
- Tip Orifice: 0.015"-0.021" (380-530 microns)
- Atomizing Pressure: 3000-4500 psi (207-310 bar)
- Mat'l Hose ID: 3/8" or 1/2" (9.5 or 12.7 mm)
- Manifold Filter: 60 mesh (250 microns)

**Surface Temperature**
- Minimum 50°F (10°C)
- Maximum 155°F (67°C)

**Cleanup**
- Flush and clean all equipment immediately after use with No. 4 thinner or MEK.

**† Values may vary with color.**
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