**Surface Preparation**

**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-SP5/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 L69F may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).

**Galvanized Steel and Non-Ferrous Metal**

Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.

**Cast/Ductile Iron**

All external surfaces of ductile iron pipe and fittings shall be delivered to the application facility without asphalt or any other protective lining on the exterior surface. All oils, small deposits of asphalt paint, grease, and soluble deposits should be removed and uniformly abrasive blasted using angular abrasive in accordance with NAPF 500-03-04: External Pipe Surface Condition. When viewed without magnification, the exterior surfaces shall be free of all visible dirt, dust, loose annealing oxide, rust, mold coating and other foreign matter. Any area where rust reappears before application shall be reblasted. The surface shall contain a minimum angular anchor profile of 1.5 mils (38.1 microns) (Reference NACE RP0287 or ASTM D 4417, Method C).

**Concrete**

Allow new cast-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness in accordance with ASTM F 1869 "Standard Test Method for Measuring Moisture Vapour Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride" (moisture vapor transmission should not exceed three pounds per 1,000 square feet in a 24 hour period), or D 4263 "Standard Test Method for Indicating Moisture in Concrete by the Plastic Emulsion Method" (moisture vapor transmission should not exceed 10% relative humidity), or ASTM D 4417, Method C). Prepare concrete surfaces in accordance with NACE No. 6/SSPC-SP13 Joint Surface Preparation Standards and ICRI Technical Guidelines. Abrasive blast, shot-blast, water jet or mechanically abrade concrete surfaces to remove laitance, curing compounds, hardeners, sealers and other contaminants and to provide an ICRI-CSP 2-3 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.

**CMU**

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

**Painted Surfaces**

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

**Primed Surfaces**

Immersion Service: Scarify the Series L69F prime coat surface by abrasive-blasting with a fine abrasive before topcoating if the Series L69F prime coat has been in exterior exposure for 60 days or longer and Series 66, L69, L69F, N69, N69F, V69, V69F or 161 is the specified topcoat.

**All Surfaces**

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

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**Technical Data**

**Volume Solids**

66.0 ± 2.0% (mixed) †

**Recommended DFT**

2.0 to 10.0 mils (50 to 255 microns) per coat. **Note:** The number of coats and thickness requirements will vary with substrates, application method and exposure. Contact your Tnemec representative for specific recommendations.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoot</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>4 hours</td>
<td>5 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>65°F (18°C)</td>
<td>7-8 hours</td>
<td>9-11 hours</td>
<td>8 days</td>
</tr>
<tr>
<td>55°F (13°C)</td>
<td>12-14 hours</td>
<td>16-20 hours</td>
<td>9-10 days</td>
</tr>
<tr>
<td>45°F (7°C)</td>
<td>18-22 hours</td>
<td>26-32 hours</td>
<td>12-13 days</td>
</tr>
<tr>
<td>35°F (2°C)</td>
<td>28-32 hours</td>
<td>46-50 hours</td>
<td>16-18 days</td>
</tr>
</tbody>
</table>

Curing times vary with surface temperature, air movement, humidity and film thickness.
HI-BUILD EPOXOLINE® II | SERIES L69F

PRODUCT DATA SHEET

APPLICATION

Coverage Rates

<table>
<thead>
<tr>
<th>Moisture Condition</th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested (1)</td>
<td>6.0 (150)</td>
<td>9.0 (230)</td>
<td>176 (16.4)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.0 (75)</td>
<td>521 (48.4)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (250)</td>
<td>15.0 (375)</td>
<td>104 (9.6)</td>
</tr>
</tbody>
</table>

Dense Concrete & Masonry: From 100 to 150 sq ft (9.3 to 13.9 m²) per gallon.
CMU: From 75 to 100 sq ft (7.0 to 9.3 m²) per gallon.

(1) Note for Steel: Roller or brush application requires two or more coats to obtain recommended film thickness. Also, Series L69F can be air spray applied to an optional high-build film thickness range of 8.0 to 10.0 dry mils (205 to 255 dry microns) or 12.5 to 15.5 wet mils (320 to 395 wet microns). 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

Start with equal amounts of Series L69F Parts A and B. Power mix contents of each container separately, 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. Note: Both components must be above 50°F (10°C) prior to mixing. For optimum mixing and application properties, the material should be above 60°F (16°C).

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 application to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand 30 minutes and re-stir before using.

Use No. 49 Thinner. For air spray, thin up to 5% or 1/4 pint (190 mL) per gallon. No thinning is necessary for airless spray. For roller or brush application, thin up to 5% or 1/4 pint (190 mL) per gallon.

Pot Life

2 hours at 50°F (10°C)  1 hour at 75°F (24°C)  30 minutes at 100°F (38°C)
30 minutes at 75°F (24°C)

Note: Spray application after listed times will adversely affect ability to achieve recommended dry film thickness.

Spray Life (1)

Air Spray (1)

Gun | Fluid Tip | Air Cap | Air Hose ID | Mat'l Hose ID | Atomizing Pressure | Pot Pressure |
---|----------|---------|-------------|---------------|-------------------|-------------|
DeVilbiss JGA | E | 70i | 5/16" or 3/8" (7.9 or 9.5 mm) | 3/8" or 1/2" (9.5 or 12.7 mm) | 50-80 psi (3.4-5.5 bar) | 10-20 psi (0.7-1.4 bar) |

Low temperatures or longer hoses require higher pot pressure.

Airless Spray (1)

<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>3500-5100 psi (241-351 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.

(1) Spray application of first coat on CMU should be followed by backrolling.

Note: Application over inorganic zinc-rich primers: Apply a wet mist coat and allow tiny bubbles to form. When bubbles disappear in 1 to 2 minutes, apply a full wet coat at specified mil thickness.

Roller: Use 3/8" or 1/2" (9.5 mm or 12.7 mm) synthetic woven nap roller covers. Use longer nap to obtain penetration on rough or porous surfaces.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

Surface Temperature

Minimum 35°F (2°C)  Maximum 135°F (57°C)
The surface should be dry and at least 5°F (5°C) above the dew point. Coating will not cure below minimum surface temperature.

Clean-up

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

† Values may vary with color.
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