**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Polyamidoamine Epoxy

**COMMON USAGE**
An advanced generation epoxy for protection and finishing of steel and concrete. It has excellent resistance to abrasion and is suitable for immersion as well as chemical contact exposure. Contact your local Tnemec representative for a list of chemicals. This product can also be used for lining storage tanks that contain demineralized, deionized or distilled water.

**COLORS**
Refer to Tnemec Color Guide. **Note:** Epoxies chalk with extended exposure to sunlight. 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 cause yellowing to occur.

**FINISH**
Satin

**COATING SYSTEM**

**SURFACER/FILLER/PATCHER**

**PRIMERS**

**SERIES N69**

**TOPCOATS**

**SERIES N69**

**SPECIAL SURFACE HANDLING**

**HANDLING DURING APPLICATION**

**HANDLING AFTER APPLIANCE**

**TECHNICAL DATA**

**VOLUME SOLIDS**
67.0 ± 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 substrate, application method and exposure. Contact your Tnemec representative.
Spray application after listed times will adversely affect ability to achieve recommended dry film thickness.

Note:

Without 44-700: 1 hour at 75°F (24°C)  
With 44-700: 30 minutes at 75°F (24°C)

With 44-700: 2 hours at 50°F (10°C)  
1 hour at 75°F (24°C)  
30 minutes at 100°F (38°C)

Without 44-700: 6 hours at 50°F (10°C)  
4 hours at 75°F (24°C)  
1 hour at 100°F (38°C)

For application of the unaccelerated version to surfaces between 50°F to 60°F (10°C to 16°C) or the accelerated version to surfaces between 55°F to 50°F (13°C to 10°C), allow mixed material to stand 30 minutes and restir before using.

Start with equal amounts of Series N69 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. If Series 44-700 is not being used, proceed with mixing and add an equal volume of Part A to Part B while under agitation. Continue agitation until the two components are thoroughly mixed.

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.

Curing time varies with surface temperature, air movement, humidity and film thickness. Note: For faster curing and low-temperature applications, add No. 44-700 Epoxy Accelerator; see separate product data sheet for cure information.

Unthinned: 2.40 lbs/gallon (285 grams/litre)

Thinned 10% (No. 4 Thinner): 2.80 lbs/gallon (334 grams/litre)

Thinned 10% (No. 60 Thinner): 2.80 lbs/gallon (334 grams/litre)

1,074 mil sq ft/gal (26.4 m²/L at 25 microns). See APPLICATION for coverage rates. †

Two: Part A (amine) and Part B (epoxy) — One (Part A) to one (Part B) by volume.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoat</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>90°F (32°C)</td>
<td>5 hours</td>
<td>7 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>80°F (27°C)</td>
<td>7 hours</td>
<td>9 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>70°F (21°C)</td>
<td>9 hours</td>
<td>12 hours</td>
<td>7 days</td>
</tr>
<tr>
<td>60°F (16°C)</td>
<td>16 hours</td>
<td>22 hours</td>
<td>9 to 12 days</td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>24 hours</td>
<td>32 hours</td>
<td>12 to 14 days</td>
</tr>
</tbody>
</table>

Suggested (1)  
Minimum  
Maximum

Dry Mils (Microns)  
Wet Mils (Microns)  
Sq Ft/Gal (m²/Gal)

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 N69 can be spray applied to an optional high-build film thickness range of 8.0 to 10.0 dry mils (205 to 255 dry microns) or 11.5 to 14.5 wet mils (209 to 370 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. †

If using Series N69 accelerator, slowly add four (4) fluid ounces of 44-700 per gallon to Series N69 Part A material while under agitation and proceed with adding Part B. Note: The use of more than the recommended amount of 44-700 will adversely affect performance.

If using Series N69 accelerator, slowly add four (4) fluid ounces of 44-700 per gallon to Series N69 Part A material while under agitation and proceed with adding Part B. Note: The use of more than the recommended amount of 44-700 will adversely affect performance.

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 of the unaccelerated version to surfaces between 50°F to 60°F (10°C to 16°C) or the accelerated version to surfaces between 55°F to 50°F (13°C to 10°C), allow mixed material to stand 30 minutes and restir before using.

Use No. 4 or No. 60 Thinner. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, roller or brush, thin up to 5% or 1/4 pint (390 mL) per gallon.

Without 44-700: 6 hours at 50°F (10°C)  
4 hours at 75°F (24°C)  
1 hour at 100°F (38°C)

With 44-700: 2 hours at 50°F (10°C)  
1 hour at 75°F (24°C)  
30 minutes at 100°F (38°C)

Without 44-700: 1 hour at 75°F (24°C)  
With 44-700: 30 minutes at 75°F (24°C)

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

### Air Spray

<table>
<thead>
<tr>
<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>
<th>Atomizing Pressure</th>
<th>Pot Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td>DeVilbiss JGA</td>
<td>E</td>
<td>765 or 704</td>
<td>5/16” or 3/8” (7.9 or 9.5 mm)</td>
<td>3/8” or 1/2” (9.5 or 12.7 mm)</td>
<td>50-80 psi (3.4-5.5 bar)</td>
<td>10-20 psi (0.7-1.4 bar)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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”-0.019” (380-485 microns)</td>
<td>3000-4800 psi (207-350 bar)</td>
<td>1/4” or 3/8” (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.

† 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 cover. 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 50°F (10°C)  Maximum 135°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.