**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Epoxy Vinyl Ester Polymer Concrete

**COMMON USAGE**
Series 489 is a durable polymer concrete which exhibits fast curing and minimal shrinkage. Ideal for the rehabilitation of severely eroded concrete or for the corrosion-proofing of new concrete where superior chemical resistance is required throughout the complete topping system. Series 489 is ideal for pump and pad rebuilds in areas of strong acid and caustic exposure. Use to cast sumps and trenches off-site for time and labor savings.

**COLORS**
904 Medium Gray  **Note:** Batch-to-batch color variation can be expected.

**FINISH**
Flat (as poured).  **Note:** A semi-gloss finish can be achieved by troweling the surface.

**COATING SYSTEM**

**PRIMERS**
Series 1402

**SURFACE PREPARATION**

**CONCRETE**
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 a minimum ICRI-CSP 5 surface profile.

**ALL SURFACES**
Must be clean and free of oil, grease and other contaminants. Always take precautions to prohibit the surface from becoming contaminated prior to product application.

**TECHNICAL DATA**

**VOLUME SOLIDS**
100% (mixed)

**RECOMMENDED DFT**
3/8" to 10" (1.0 - 25 cm) in a single pour.

**CURING TIME**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Light Traffic/To Handle</th>
<th>Return to Service</th>
<th>Maximum Chemical Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>90°F (32°C)</td>
<td>1-2 hours</td>
<td>12-24 hours</td>
<td>24 hours</td>
</tr>
<tr>
<td>75°F (24°C)</td>
<td>2-4 hours</td>
<td>24 hours</td>
<td>24 hours</td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>8-10 hours</td>
<td>48 hours</td>
<td>48 hours</td>
</tr>
</tbody>
</table>

Curing times are based upon 3/8-inch of material, thicker castings and pours may result in longer set times.  **Note:** Certain immersion service times may require additional cure time, contact Tnemec Technical Services for additional information.

**VOLATILE ORGANIC COMPOUNDS**
0.02 lbs/gallon (1.9 grams/litre)

**THEORETICAL COVERAGE**
Coverage rates based on Casting/Topping Application:
- 110 sq ft (10.2 m²) at 3/8" per kit
- 85 sq ft (7.7 m²) at 1/2" per kit
- 41 sq ft (3.8 m²) at 1" per kit

See APPLICATION for additional coverage rates.

**PACKAGING**

<table>
<thead>
<tr>
<th></th>
<th>Part A (Partially Filled)</th>
<th>Part B (Partially Filled)</th>
<th>Part C</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Large Kit</strong></td>
<td>5 gallon pail (partial fill)</td>
<td>Pint bottle</td>
<td>5 - 70 lb bags</td>
<td>21.4 gallons (81.0 L)</td>
</tr>
<tr>
<td><strong>Small Kit</strong></td>
<td>1 gallon can</td>
<td>4 ounce bottle</td>
<td>1-70 lb bag</td>
<td>4.28 gallons (16.2 L)</td>
</tr>
</tbody>
</table>

**STORAGE TEMPERATURE**
Minimum 50°F (10°C)  Maximum 75°F (24°C)

**TEMPERATURE RESISTANCE**
(Dry) Continuous 300°F (95°C)

**SHELF LIFE**
Part A: 5 months at 35°F to 49°F (2°C to 9°C), 2 months at 50°F to 79°F (10°C to 26°C), 1 month at 80°F to 90°F (27°C to 32°C). Do not store at temperature below 35°F (2°C) or above 90°F (32°C).

**FLASH POINT - SETA**
Part A: 87°F (53°C)  Part B: 135°F (57°C)

**HEALTH & SAFETY**
Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product.  **Keep out of the reach of children.**

**APPLICATION**

**COVERAGE RATES**
Casting/Topping Application

<table>
<thead>
<tr>
<th></th>
<th>Cubic Feet (Cubic Meters)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>3.46 (.09)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>0.69 (.02)</td>
</tr>
</tbody>
</table>
For additional mixing instructions please reference the charts below:

### Casting/Topping (Large Kit as supplied):

<table>
<thead>
<tr>
<th>Part A</th>
<th>Part B</th>
<th>Part C</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 gallon pail</td>
<td>1 gallon can</td>
<td>5 - 70 lb bags</td>
</tr>
</tbody>
</table>

### Casting/Topping (Small Kit as supplied):

<table>
<thead>
<tr>
<th>Part A</th>
<th>Part B</th>
<th>Part C</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 gallon can</td>
<td>Quart can</td>
<td>1 - 70 lb bag</td>
</tr>
</tbody>
</table>

**WARRANTY & LIMITATION OF SELLER'S LIABILITY:** Tnemec Company, Inc. warrants only that its coatings represented herein meet the formulation standards of Tnemec Company, Inc. The Warranty described in the above paragraph shall be in lieu of any other warranty, expressed or implied, including but not limited to, any implied warranty of merchantability or fitness for a particular purpose. There are no warranties that extend beyond the description on the face hereof. The buyer's sole and exclusive remedy against Tnemec Company, Inc. shall be for replacement of the product in the event a defective condition of the product should be found to exist and the exclusive remedy shall not have failed its essential purpose as long as Tnemec is willing to provide comparable replacement product to the buyer. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Tnemec Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.