TECHNICAL DATA

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-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

GALVANIZED STEEL & NON-FERROUS METAL

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 NAPA 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 scarified until 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 Vapor 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), F 2170 ‘Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes’ (relative humidity should not exceed 80%), or D 4263 “Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method” (no moisture present). 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 2-5 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfercer.

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

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

PRIMED SURFACES
Immersion Service: Scarify the Series V69F prime coat surface by abrasive-blasting with a fine abrasive before topcoating if the Series V69F 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.

Satin

NOTE: Epoxy 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.

COLORS


NOTE: The following recoat times apply for Series V69F: Immersion Service—Surface must be scarified after 30 days. Atmospheric Service—After 50 days, scarification or an epoxy tie-coat is required. When topcoating with Series 740 or 750, recoat time for V69F is 14 days. Contact your Tnemec representative for specific recommendations.

FINISH

Satin

COATING SYSTEM

SERIES 215, 217, 218

Epoxy Chalk

Note:

69.0 ± 2.0% (mixed) †

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

Note: The number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

RECOMMENDED DFT

2.0 to 10.0 mils (50 to 255 microns) per coat

PDSV69F Page 1 of 3

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<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoat</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>28-32 hours</td>
<td>12-15 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 time varies with surface temperature, air movement, humidity and film thickness.

**Unthinned:** 1.90 lbs/gallon (228 grams/litre)
**Thinned 3.5% (No. 4 Thinner):** 2.08 lbs/gallon (250 grams/litre) †

**Unthinned:** 2.00 lbs/gal solids
**Thinned 3.5% (No. 4 Thinner):** 2.20 lbs/gal solids

1.107 mil sq ft/gal (27.2 m²/L at 25 microns). See APPLICATION for coverage rates. †

**To Handle:**
- Large Kit: 5 gallon pail
- Small Kit: 1 gallon can
- 10 gallons (37.9 L)
- 2 gallons (7.6 L)

<table>
<thead>
<tr>
<th>Packaging</th>
<th>Part A</th>
<th>Part B</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>5 gallon pail</td>
<td>5 gallon pail</td>
<td>10 gallons (37.9 L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>1 gallon can</td>
<td>2 gallons (7.6 L)</td>
</tr>
</tbody>
</table>

**Net Weight Per Gallon:** 13.90 ± 0.25 lbs (6.31 ± .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: 12 months at recommended storage temperature.

**Flash Point - SetA:** Part A: 82°F (28°C) Part B: 86°F (30°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.**

**APPLICATION**

**Coverage Rates**

<table>
<thead>
<tr>
<th></th>
<th>Dry Milts (Microns)</th>
<th>Wet Milts (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>184 (17.1)</td>
</tr>
<tr>
<td>Minimum</td>
<td>2.0 (50)</td>
<td>3.0 (75)</td>
<td>553 (51.4)</td>
</tr>
<tr>
<td>Maximum</td>
<td>10.0 (250)</td>
<td>15.0 (375)</td>
<td>111 (10.3)</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 V69F 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 (290 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. †

**Mixing**
Start with equal amounts of Series V69F 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 60°F (16°C) for optimum mixing and application properties, the material should be above 60°F (16°C).

Use No. 4 Thinner. A maximum of 3.5% of No. 4 Thinner may be used to comply with VOC regulations.

**Spray Application**

**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>
</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>
</tr>
</tbody>
</table>

**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” (380-885 microns)</td>
<td>3000-4800 psi (207-330 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.

**Note:** Spray application of first coat on CMU should be followed by backrolling.

**Tip:** 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.
<table>
<thead>
<tr>
<th><strong>SURFACE TEMPERATURE</strong></th>
<th>Minimum 35°F (2°C)</th>
<th>Maximum 135°F (57°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>The surface should be dry and at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature.</td>
<td></td>
</tr>
</tbody>
</table>

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

† Values may vary with color.