PRODUCT PROFILE

GENERIC DESCRIPTION	Cycloaliphatic Amine Epoxy
COMMON USAGE	Tightly cross-linked epoxy with excellent corrosion and chemical resistance. Principally used for immersion service, including fuel storage, chemical containment and wastewater treatment.
COLORS	5002 Beige (prime coat) and 5001 Gray (finish coat)
FINISH	Semi-gloss
SPECIAL QUALIFICATIONS	A two-coat system of Series 61 at 4.0-6.0 dry mils (100-150 dry microns) per coat passes the performance requirements of **MIL-C-4556E.**
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS

Steel: Self-priming
Concrete: Self-priming or Series 214, 218
CMU: Series 218

SURFACE PREPARATION

STEEL	**Immersion Service:** SSPC-SP10 Near-White Blast Cleaning obtaining a minimum anchor pattern of 2.0 mils (50 microns).
CONCRETE	Allow new concrete to cure for 28 days. Abrasive blast referencing SSPC-SP13/NACE 6 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS* 82.0 ± 2.0% (mixed)

RECOMMENDED DFT

1. For JP-4, JP-5, JP-8, Aviation Gas and Jet A-1: 4.0 to 6.0 mils (100 to 150 microns) per coat (minimum of two coats).
2. Most Other Applications: 8.0 to 12.0 mils (205 to 305 microns) per coat (minimum of two coats). Contact your Tnemec representative for specific recommendations.

CURING TIME

Temperature	To Handle	To Recoat	Immersion
75°F (24°C)	6 hours at 4.0 mils (100 microns)	16-18 hours•	5 to 7 days
	11 hours at 12.0 mils (305 microns)	16-18 hours•	5 to 7 days

Curing time varies with surface temperature, air movement, humidity and film thickness.
• Maximum recoat time is 72 hours. If more than 72 hours have elapsed between coats, the coated surface must be scarified before topcoating.

VOLATILE ORGANIC COMPOUNDS*	Unthinned	Thinned 10%
EPA Method 24	0.36 lbs/gallon (45 grams/litre)	1.94 lbs/gallon (232 grams/litre)
HAPS	1.59 lbs/gal solids	2.49 lbs/gal solids

THEORETICAL COVERAGE* 1,315 mil sq ft/gal (32.3 m^2/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Part A and Part B

PACKAGING 5 gallon (18.9L) pails and 1 gallon (3.79L) cans — Order in multiples of 2.

NET WEIGHT PER GALLON* 13.10 ± 0.25 lbs (5.94 ± .11 kg)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)
For optimum application properties, material temperature should be above 60°F (16°C) prior to application.

TEMPERATURE RESISTANCE
(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)
Uninsulated Tanks (Immersion Service):
Continuous 120°F (49°C) Intermittent 140°F (60°C)
Insulated Tanks (Immersion Service):
Continuous 180°F (82°C) Intermittent 210°F (99°C)
Performance in high temperature immersion applications depends on liquid media, temperature and substrate. Contact your Tnemec representative for more information.

TECHNICAL DATA continued

SHELF LIFE 24 months at recommended storage temperature.

FLASH POINT - SETA Parts A & B: 81°F (27°C)

HEALTH AND 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*

	For JP-4, JP-5, JP-8 Aviation Gas, Jet A-1 Service			Most Other Applications		
	Dry Mils (Microns)	**Wet Mils (Microns)**	**Sq Ft/Gal (m^2/Gal)**	**Dry Mils (Microns)**	**Wet Mils (Microns)**	**Sq Ft/Gal (m^2/Gal)**
Suggested	5.0 (125)	6.0 (150)	263 (24.4)	10.0 (255)	12.0 (305)	132 (12.2)
Minimum	4.0 (100)	5.0 (125)	329 (30.6)	8.0 (205)	10.0 (255)	164 (15.3)
Maximum	6.0 (150)	7.5 (190)	219 (20.4)	12.0 (305)	14.5 (355)	110 (10.2)

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 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. Do not use mixed material beyond pot life limits. **Note:** Both components should be above 60°F (16°C) prior to mixing. Mixing ratio is one to one by volume.

POT LIFE 2½ hours at 60°F (16°C) 1½ to 2 hours at 77°F (25°C) ¾ to 1 hour at 100°F (38°C)

THINNING Use No. 2 Thinner. For air spray, thin up to 10% or ¾ pint (380 mL) per gallon. For airless spray or brush, thin up to 5% or ¼ pint (190 mL) per gallon.

SURFACE TEMPERATURE Minimum 60°F (16°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.

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
Binks Model 95	66	63 PB	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	60-90 psi (4.2-6.2 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.021" (380-535 microns)	2400-3000 psi (165-207 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.
Note: Two or more coats may be required to obtain recommended film thicknesses.

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

*Values may vary with color.