



TNEMEC-FASCURE SERIES 161

PRODUCT PROFILE

- GENERIC DESCRIPTION** Polyamide Epoxy
- COMMON USAGE** Low temperature-cure, corrosion-resistant coating for protection against abrasion, immersion and mild chemical contact. Fast recoat at 75°F (24°C).
- COLORS** Refer to Tnemec Color Guide. **Note:** Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, miscatalyzation 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
- PERFORMANCE CRITERIA** Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

- PRIMERS** **Steel:** Self-priming or Series 20, FC20, 37H, 66, N69, N69F, 90, 160, 530
Galvanized Steel and Non-Ferrous Metal: Self-priming or Series 66, N69
Concrete: Self-priming or 54-660, 130, 201, 214
CMU: 54-562, 54-660, 130, 216, 218
Drywall: 51-792 for dry interior environments
- TOPCOATS** 46H-413, 66, N69, 73, 84, 104, 113, 114, 161, 175, 262, 265, 290, 291, 1074, 1075. Refer to COLORS on applicable topcoat data sheets for additional information.

SURFACE PREPARATION

- STEEL** **Immersion Service:** SSPC-SP10 Near-White Blast Cleaning
Non-Immersion Service: SSPC-SP6 Commercial Blast Cleaning
- GALVANIZED STEEL & 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** Contact your Tnemec representative or Tnemec Technical Services.
- CONCRETE** Allow new concrete to cure 28 days. For optimum results and/or immersion service, abrasive blast referencing SSPC-SP13/NACE 6 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.
- 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 161 prime coat surface by abrasive-blasting with a fine abrasive before topcoating if:
 (a) the Series 161 has been exterior exposed for 60 days or longer and 46H-413, 66, N69 or 161 is the specified topcoat;
 (b) the Series 161 prime coat has been exterior exposed for 14 days or longer and Series 104 is the specified topcoat; (c) the Series 161 prime coat has been exterior exposed for 7 days or longer and Series 262 or 265 is the specified topcoat.
- ALL SURFACES** Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

- VOLUME SOLIDS** 58.0 ± 2.0% (mixed) †
- RECOMMENDED DFT** 2.0 to 6.0 mils (50 to 150 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Handle	To Recoat	Immersion
75°F (24°C)	1 hour	2-3 hours	3-4 hours	3 days
65°F (18°C)	2 hours	4-5 hours	5-6 hours	4-5 days
55°F (13°C)	3-4 hours	6-8 hours	10-12 hours	6-7 days
45°F (7°C)	6-7 hours	12-14 hours	16-18 hours	9-10 days
35°F (2°C)	8-10 hours	16-18 hours	20-22 hours	12-14 days

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS

- Unthinned:** 2.92 lbs/gallon (349 grams/litre)
- Thinned 5%:** 3.11 lbs/gallon (372 grams/litre)
- Thinned 10%:** 3.28 lbs/gallon (393 grams/litre) †

THEORETICAL COVERAGE

930 mil sq ft/gal (22.8 m²/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

12.50 ± 0.25 lbs (5.67 ± .11 kg) †

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: 64°F (18°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.

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APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested (1)	4.0 (100)	7.0 (180)	232 (21.6)
Minimum	2.0 (50)	3.5 (90)	465 (43.2)
Maximum	6.0 (150)	10.5 (265)	155 (14.4)

(1) Note: Roller or brush application may require two or more coats to obtain suggested film thickness. 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 50°F (10°C) prior to mixing. For application to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, blended components should be above 60°F (16°C). **Note:** Mixing ratio is one to one by volume.

THINNING

Use No. 4 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 (190 mL) per gallon.

POT LIFE

16 hours at 35°F (2°C) 2 hours at 75°F (24°C) 1/2 hour at 100°F (38°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss MBC or JGA	E	765 or 78	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-100 psi (5.2-6.9 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"-0.019" (380-485 microns)	1800-3000 psi (124-207 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.

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: Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic nap covers.

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 (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.

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