



PRODUCT PROFILE

GENERIC DESCRIPTION Acrylic Emulsion

COMMON USAGE Decorative, high-build protection against weather, driving rain, industrial fumes and alternate freezing-thawing. Formulated to resist mildew growth on the paint film. Available in smooth (Series 180) and sand-texture (Series 181) finishes for concrete, CMU and properly primed steel. Spray application "dry-falls" under certain conditions.

COLORS Refer to Tnemec Color Guide.

FINISH Flat, sand texture

PERFORMANCE CRITERIA Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Self-priming on concrete, masonry, brick, stucco and lightweight block.
Split-Face & Split-Fluted CMU: Series 54, 130, 1254
Steel: 10, 37H, 66, L69, N69, V69, N69F, V69F, 90E-92, L140, N140, V140, N140F, V140F, 161

TOPCOATS Series 1028, 1029

SURFACE PREPARATION

PAINTED SURFACES Prepare surfaces by method suitable for exposure and service. Refer to the primer data sheet.
 Remove chalk and old paint not tightly bonded to the surface. Patch cracks.

ALL SURFACES Must be clean, dry and free of oil, grease, form release agents and other contaminants. Allow new concrete, masonry and stucco to cure 7 days. Level protrusions and mortar spatter. Reference SSPC-SP13/NACE 6.

TECHNICAL DATA

VOLUME SOLIDS 44.0 ± 2.0% †

RECOMMENDED DFT 4.0 to 10.0 mils (100 to 255 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. See APPLICATION and/or contact your Tnemec representative.

CURING TIME

Temperature	To Touch	To Recoat
75°F (24°C)	1 hour	3 hours

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

VOLATILE ORGANIC COMPOUNDS

Unthinned: 0.82 lbs/gallon (98 grams/litre)
Thinned 5%: 0.82 lbs/gallon (98 grams/litre) †

THEORETICAL COVERAGE 705 mil sq ft/gal (17.3 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS

One

PACKAGING

5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

NET WEIGHT PER GALLON

11.50 ± 0.25 lbs (5.22 ± .11 kg)

STORAGE TEMPERATURE

Minimum 35°F (2°C) Maximum 110°F (43°C)

TEMPERATURE RESISTANCE

(Dry) Continuous 170°F (77°C) Intermittent 200°F (93°C)

SHELF LIFE

24 months at recommended storage temperature.

FLASH POINT - SETA

NA

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.**

W.B. TNEME-CRETE® | SERIES 181

APPLICATION

COVERAGE RATES

Dense Concrete, Masonry and Filled CMU

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Minimum	4.0 (100)	9.5 (240)	176 (16.3)
Maximum	8.0 (205)	19.0 (485)	88 (8.2)

CMU (First Coat)

Minimum	8.0 (205)	19.0 (485)	88 (8.2)
Maximum	10.0 (255)	24.0 (610)	71 (6.5)

Primed Steel

Minimum	4.0 (100)	9.5 (240)	176 (16.3)
Maximum	6.0 (150)	14.5 (370)	118 (10.9)

Allow for application losses and surface irregularities. Spreading rates are approximate and variable based on the roughness and porosity of substrates; also the method of application. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Wet and dry film thicknesses are calculated from the sq ft/gal figures. There is no method for accurately measuring the applied film thickness of texture coatings. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

Important: Protection against weather, driving rain and alternate freezing and thawing is obtained when coating is applied to form a continuous, void-free film. The coating must be brushed, rolled or sprayed and back-rolled onto block. Grooves in scored and fluted block must be brushed. Two coats are normally recommended for lightweight block. Split-face and split-fluted block must be filled. Contact your Tnemec representative for specific coating system recommendations.

**MIXING
THINNING
APPLICATION EQUIPMENT**

Stir thoroughly with a power mixer, making sure no pigment remains on the bottom of the can.

Normally not required. Can be thinned up to 5% or 6 ounces (190 mL) per gallon with clean water.

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss (1)	D AC	64HD 62HD	5/16" or 3/8" (7.9 or 9.5 mm)	1/2" (12.7 mm)	50-70 psi (3.4-4.8 bar)	30-40 psi (2) (2.1-2.8 bar)

(1) With heavy duty spring (JGA 191K2).

(2) Increased production may be achieved by using a low pressure transfer pump designed for texture coatings, instead of a pressure pot, such as the Graco 987-429 10:1 president pump, rubber packed (up to 1,000 psi with 3 gpm max fluid delivery). It is equipped with an air evenflo control that includes pump and atomizing air regulators. Contact Tnemec Technical Service for more information.

Roller: Use a synthetic cover. For smooth surfaces use 3/8" to 3/4" (9.5 mm to 19.0 mm) nap. For rough surfaces use 3/4" (19.0 mm) or longer nap. To obtain proper penetration for rough or porous surfaces, thin up to 5% or 1/4 pint (190 mL) per gallon. Force material into voids and hairline cracks with a brush or squeegee. Smooth out build-up at laps. Multiple coats may be required to achieve recommended film thickness, depending on applicator technique and roller nap size.

Brush: Use a stiff nylon brush. Work material into voids and avoid brushing out too thin.

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 90°F (32°C)
The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with water.

CAUTION

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions, equipment adjustment and proper thinning. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

† Values may vary with color.

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