



# SURFACING EPOXY SERIES 215

## PRODUCT PROFILE

<b>GENERIC DESCRIPTION</b>	Modified Polyamine Epoxy
<b>COMMON USAGE</b>	An advanced generation, 100% solids epoxy filler and surfacer for concrete or steel. Excellent material for surfacing, patching and filling voids and bugholes in concrete substrates. Generally topcoated with a variety of high performance epoxies and polyurethanes for use in mild to aggressive exposures.
<b>COLORS</b>	1200 White, 1212 Gray
<b>FINISH</b>	Semi-Gloss
<b>SPECIAL QUALIFICATIONS</b>	Ambient air cured Series 215 is acceptable for use on the interior of potable water storage tanks and reservoirs when overcoated with a Std. 61 certified protective coating. Contact your Tnemec representative for approved systems and additional information.

## COATING SYSTEM

<b>SURFACER/FILLER/PATCHER</b>	Self-patching or Series 218
<b>PRIMERS</b>	<b>Steel:</b> Self-priming, Series 1, L69, L69F, N69, N69F, V69, V69F, 90-97, H90-97, 90G-1K97, 91-H <sub>2</sub> O, 94-H <sub>2</sub> O, 201, 394 <b>Concrete:</b> Self-priming, L69, L69F, N69, N69F, V69, V69F, 201. <b>Note:</b> Primers may be necessary on some applications to minimize or eliminate the potential for outgassing. <b>CMU &amp; Cement Board:</b> Self-priming. Can also be used as a bedding coat for Series 273 Stranlok ML system.
<b>TOPCOATS</b>	Series 22, L69, L69F, N69, N69F, V69, V69F, 84, 104, 113, 114, 270, 273, 280, 281, 282, 287, 400, 406, 434, 435, 436, 446. <b>Note:</b> If the Series 215 surface is exterior exposed for more than seven days, scarification is required before topcoating.

## SURFACE PREPARATION

<b>STEEL</b>	<b>Non-Immersion Service:</b> SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum 3.0 mil angular anchor profile. <b>Immersion Service:</b> SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum 3.0 mil angular anchor profile.
<b>CONCRETE</b>	Allow new concrete to cure 28 days. Verify dryness by testing for moisture with a "plastic film tapedown test" (Reference ASTM D 4263). If necessary for testing horizontal surfaces, perform "Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride" (Reference ASTM F 1869). Moisture content not to exceed three pounds per 1,000 sq ft in a 24 hour period. Abrasive blast or mechanically abrade to remove laitance, form release agents, curing compounds, sealers and other contaminants and to provide surface profile. (Reference SSPC-SP13/NACE 6, ICRI-CSP3). Series 22, 400, 406, 434, 435, 436 and 446 require a minimum profile of ICRI-CSP5.
<b>CMU</b>	Allow mortar to cure for 14 days. Level protrusions and mortar spatter.
<b>ALL SURFACES</b>	Must be clean, dry and free of oil, grease, chalk and other contaminants.

## TECHNICAL DATA

<b>VOLUME SOLIDS</b>	100% (mixed) †
<b>RECOMMENDED DFT</b>	1/32" to 1/8" (0.8 mm to 3.2 mm) Up to 1/2" with the addition of Series 211 (see Mixing instructions) for filling honeycombs, blow holes and surface imperfections found in formed concrete surfaces. Larger imperfections may require multiple applications.
<b>CURING TIME</b>	

Temperature	To Touch	Dry Through	Maximum to Recoat
95°F (35°C)	4 hours	12 hours	14 days
75°F (24°C)	10 hours	24 hours	21 days
55°F (13°C)	18 hours	48 hours	21 days

<b>VOLITILE ORGANIC COMPOUNDS</b>	<b>Unthinned:</b> 0.08 lbs/gal solids (10 grams/litre) †
<b>HAPS</b>	<b>Unthinned:</b> 0.0 lbs/gal solids
<b>THEORETICAL COVERAGE</b>	1,604 mil sq ft/gal (39.4 m <sup>2</sup> /L at 25 microns). See APPLICATION for coverage rates. †
<b>NUMBER OF COMPONENTS</b>	Two: Part A and Part B (1 Part A to 1 Part B by volume)

### PACKAGING

	PART A	PART B	When Mixed
Large Kit	3 gal. pail (partial fill)	5 gal. pail (partial fill)	4 gallons (15L)
Small Kit	1 gallon pail	3 gal. pail (partial fill)	2 gallons (7.5L)
Touch-Up Kit	1 quart can	1 quart can	1/2 gallon (1.89L)

<b>NET WEIGHT PER GALLON</b>	13.28 ± 0.25 lbs (6.02 ± .11 kg) (mixed) †
<b>STORAGE TEMPERATURE</b>	Minimum 20°F (-6°C) Maximum 110°F (43°C) Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested the material be stored at these temperatures at least 48 hours prior to use.
<b>TEMPERATURE RESISTANCE</b>	(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)
<b>SHELF LIFE</b>	12 months at recommended storage temperature.
<b>FLASH POINT - SETA</b>	Part A and Part B: N/A

### HEALTH & SAFETY

This product contains 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

### COVERAGES RATES

Thickness	Large Kit	Small Kit
1/32" (31 mils)	207 sq ft (19.2 m <sup>2</sup> )	103 sq ft (9.6 m <sup>2</sup> )
1/16" (62 mils)	103 sq ft (9.6 m <sup>2</sup> )	52 sq ft (4.8 m <sup>2</sup> )
1/8" (125 mils)	51 sq ft (4.8 m <sup>2</sup> )	26 sq ft (2.4 m <sup>2</sup> )
1/2" (500 mils)	13 sq ft (1.2 m <sup>2</sup> )	6 sq ft (0.6 m <sup>2</sup> )

### MIXING

Mix the entire contents of Part A and Part B separately. Scrape all of the Part A material from the pail and into the Part B container by using a flexible spatula. Use a variable speed drill with a PS Jiffy blade and mix the blended components for a minimum of two minutes. Apply the mixed material within the pot life limits after agitation. **Note:** Tnemec Series 211-0211 fumed silica may be added to Part B where a thicker consistency is required to achieve the desired application and film build properties. Mix with Part A as directed in Mixing Instructions. Multiple lifts may be required. A large volume of material will gel quickly if not applied or reduced in volume.

**Caution: Do not reseal mixed material. An explosion hazard may be created.**

### THINNING

Normally not required.

### POT LIFE

45 minutes at 70°F (21°C) – 25 minutes at 90°F (32°C)  
Material temperatures above 90°F (32°C) will significantly reduce the pot life.

### APPLICATION EQUIPMENT

Mortar hawk, trowels, broad knives and rubber floats are recommended. Series 215 can also be spray transferred using spray texture gun equipment.

#### Air Spray

Pump	Fluid Line	Spray Gun	Fluid Tips	Fluid Pressure	Atomizing Pressure	Hopper
WTWA 410 9:1 Ratio	25' 1" Diameter 10' 3/4" Diameter	WTWA Pole Gun	1/4" to 3/8"	180 to 360 psi (Adjust as necessary)	Adjust at gun for proper atomization	6.5 Gallons Stainless Steel

Cart mounted 9:1 ratio, air operated pump with air filter, regulator and lubricator, air control manifold, fluid outlet drain with drain valve and control air hose assembly. Refer to the operation manual for application instructions. Air requirements 80 CFM at 100 psi. **Atomization air must be dry, the use of an after cooler is recommended.**

### SURFACE TEMPERATURE

Minimum 45°F (7°C), maximum 130°F (54°C). The surface temperature should be at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature. To minimize outgassing, concrete temperature should be stabilized or in a descending temperature mode and the concrete primed with a suitable epoxy primer.

### MATERIAL TEMPERATURE

Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested the material be stored at these temperatures at least 48 hours prior to use. Temperature will affect the workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

### CLEANUP

Flush and clean all equipment immediately after use with xylene, MEK or No. 74 Thinner.

† Values may vary with color.

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