



TNEME-GLAZE SERIES 280

PRODUCT PROFILE

GENERIC DESCRIPTION	Modified Polyamine Epoxy
COMMON USAGE	A glaze-like corrosion resistant coating for walls, ceilings, floors and other surfaces; resistant to frequent pressurized hot water and detergent cleaning. Used as a topcoat/sealer for heavy duty wall and floor systems or in a stand-alone high-performance function. Excellent chemical, stain- and abrasion-resistance for a variety of substrates.
COLORS	Available in the 16 standard StrataShield colors. Special colors available, please contact your Tnemec representative. Note: Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting. Caution should be taken when selecting white and light pastel colors. 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 amine blush, possibly affecting adhesion of subsequent topcoats.
FINISH	Gloss. (Roller application provides an orange peel finish.)

COATING SYSTEM

SURFACER/FILLER/PATCHER	Series 63-1500, 130, 214, 218, 219. Note: A repair kit of 201, with Part C fumed silica, is available for small patching/surfacing repairs. For more extensive repairs and additional information, contact your Tnemec representative or Tnemec Technical Services.
PRIMERS	Concrete: Self-priming or Series 201, 203, 205 CMU: Self-priming over filled CMU Wood & Drywall: Self-priming or Series 201, 203
INTERMEDIATE TOPCOATS	Series 210, 237, 238, 270, 273 Series 73, 280, 290, 291, 294, 295, 297, 1074, 1075

SURFACE PREPARATION

	Prepare surfaces by method suitable for exposure and service. Refer to the appropriate primer data sheet for specific recommendations.
HORIZONTAL CONCRETE	When self-priming: Allow new concrete to cure 28 days. Verify dryness by testing for moisture with a "plastic film tape-down test." (Reference ASTM D 4263) Should moisture be detected, 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, curing compounds, hardeners, sealers and other contaminants and to provide surface profile. Large voids and other cavities should be filled with recommended filler or surfacer. (Reference SSPC-SP13/NACE 6, ICRI CSP3)
VERTICAL CONCRETE	When self-priming: Allow new concrete to cure 28 days. Abrasive blast or mechanically abrade concrete to remove laitance, form release agents, curing compounds, hardeners, sealers and other contaminants and to provide surface profile. (Reference SSPC-SP13)
CMU	When self-priming: Allow new mortar to cure 28 days. Surfaces must be clean, dry, sound and free of all contaminants. Level all protrusions and mortar spatter. For pinhole free surface, use recommended surfacer/filler/patcher.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	100% (mixed) †
RECOMMENDED DFT	Horizontal: 6.0 to 12.0 mils (150 to 305 microns) per coat. Vertical: 4.0 to 8.0 mils (100 to 205 microns) per coat Additional coats may be required for appearance or hiding.

CURING TIME

Temperature	To Topcoat	To Place in Service
75°F (24°C)	8-24 hours	24 hours

Note: If more than 24 hours have elapsed between coats, the coated surface must be mechanically abraded before topcoating.

VOLATILE ORGANIC COMPOUNDS	0.2 lbs/gallon (25 grams/litre) †
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THEORETICAL COVERAGE	1,604 mil sq ft/gal (39.4 m ² /L at 25 microns). See APPLICATION for coverage rates. †
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NUMBER OF COMPONENTS	Two: Part A and Part B (2 Parts A to 1 Part B by volume)
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PACKAGING

	PART A	PART B	When Mixed
Large Kit	2-5 gallon pails	1-5 gallon pail	15 gallons (56.8 L)
Small Kit	2-1 gallon cans	1-1 gallon pail	3 gallons (11.4 L)

NET WEIGHT PER GALLON	11.85 ± 0.25 lbs (5.37 ± .11 kg) mixed †
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STORAGE TEMPERATURE	Minimum 40°F (4°C) Maximum 90°F (32°C) Note: Material should be stored at temperatures between 70°F and 90°F (21°C and 32°C) for at least 48 hours prior to use.
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TEMPERATURE RESISTANCE	(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)
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SHELF LIFE	12 months at recommended storage temperature.
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FLASH POINT - SETA	N/A
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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.

APPLICATION

COVERAGE RATES

Before commencing, obtain and thoroughly read the StrataShield Installation and Application Guide for floors.

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Horizontal	6.0-12.0 (150-305)	6.0-12.0 (150-305)	131-267 (12.2-24.8)
Vertical	4.0-8.0 (100-205)	4.0-8.0 (100-205)	200-401 (18.6-37.3)

Allow for overspray, surface irregularities and waste. 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

Use a variable speed drill with a PS Jiffy blade. Slowly mix 2 parts A component, and while under agitation add 1 part B component and mix for a minimum of two minutes. Ensure that all Part B is blended with Part A by scraping the pail walls with a flexible spatula. Apply the mixed material within pot life limits after agitation.
Note: A large volume of material will set up quickly if not applied or reduced in volume.
Caution: Do not reseal mixed material. An explosion hazard may be created.

THINNING

Normally not required. May thin up to 5% or 1/4 pint (190 mL) per gallon to improve application properties. Brush and roll application use No. 2 Thinner. Spray application use No. 42 Thinner.

POT LIFE

25 to 30 minutes at 70°F (21°C) 15 to 20 minutes at 80°F (27°C) 8 to 10 minutes at 90°F (32°C)
 Increasing material temperatures will significantly reduce the pot life.

APPLICATION EQUIPMENT

Brush, roller, squeegee and airless spray.
Roller: Use high quality 3/8" to 1/2" nap, shed resistant, woven fabric roller cover.
Brush: Use high quality synthetic or nylon bristle brush.
Horizontal: Squeegee and backroll. Brush small areas only.
Vertical: Roll or spray and backroll. Brush small areas only.
 Spray application equipment includes a Graco "King" 45:1 or 56:1 airless spray pump or other airless spray equipment of equal or greater configuration and capability. Pump assembly should include a moisture trap and oiler, air regulator with gauge and fluid outlet drain valve. When spraying these nonfibered coatings, a high pressure manifold and 60 mesh filter is recommended. Use a 3/8" to 1/2" I.D. material hose (4,000-5,000 psi working pressure rating). A Graco silver gun or equivalent may be used. The preferred tips with orifices ranging from .019" to .033" should be mounted in a Graco H.D. RAC Housing/Guard assembly. The suggested operating pressure should be between 3,500 and 4,500 psi at the gun (approximately 80 to 90 psi operating air pressure). **Spraying should only be considered as means to transfer the material to the surface and should be followed by backrolling.**

SURFACE TEMPERATURE

Minimum of 55°F (13°C), optimum 65°F to 80°F (18°C to 27°C), maximum of 90°F (32°C). The substrate temperature should be at least 5°F (3°C) above the dew point. To avoid outgassing, concrete temperature should be stabilized or in a descending temperature mode.

MATERIAL TEMPERATURE

For optimum application, handling and performance, the material temperature during application should be between 70°F and 90°F (21°C and 32°C). 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 or MEK.

† Values may vary with color.

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