



# TNEME-GLAZE SERIES 280FC

## PRODUCT PROFILE

- GENERIC DESCRIPTION** Modified Polyamine Epoxy
- COMMON USAGE** A fast-cure 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 130, 215, 218, 1254. **Note:** A repair kit of 201, 208 or 233 mixed with 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 27WB, 201, 205, 208, 233, 237, 238, 241.  
**CMU:** Self-priming over filled CMU  
**Wall board, Wood & Drywall:** Self-priming or Series 151, 201, 233. **Note:** For taping joints on drywall, use a high quality compound such as Sheetrock brand Durabond 90.
- INTERMEDIATE TOPCOATS** Series 206, 210, 237, 237SC, 238, 241, 242, 245, 270, 273, 280FC  
Series 73, 247, 248, 280FC, 290, 291, 297, 1074, 1075, 1080, 1081

## SURFACE PREPARATION

Prepare surfaces by method suitable for exposure and service. Refer to the appropriate primer data sheet for specific recommendations.

**HORIZONTAL CONCRETE** Allow new poured-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness in accordance with ASTM F 1869 “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” (moisture vapor transmission should not exceed three pounds per 1,000 square feet in a 24 hour period), F 2170 “Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes” (relative humidity should not exceed 80%), or D 4263 “Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method” (no moisture present). **Note:** The testing listed above cannot guarantee avoidance of future moisture related problems particularly with existing concrete slabs. This is especially true if the use of an under slab moisture vapor barrier cannot be confirmed or concrete contamination from oils, chemical spills, unreacted silicates, chlorides or Alkali Silica Reaction (ASR) is suspected.

Prepare concrete surfaces in accordance with NACE No. 6/SSPC-SP13 Joint Surface Preparation Standards and ICRI Technical Guidelines. Abrasive blast, shot-blast, water jet or mechanically abrade concrete surfaces to remove laitance, curing compounds, hardeners, sealers and other contaminants and to provide a minimum ICRI-CSP 3 or greater surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer. **Note:** For moisture content exceeding 3 lbs per 1,000 sq ft or relative humidity in excess of 80%, Series 208 or 241 may be substituted for the primer. Refer to the Series 208 or 241 product data sheet for more information.

**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.

**WALL BOARD, WOOD & DRYWALL** Must be clean, dry and free of oil, grease and other contaminants. **Note:** When using moisture resistant and/or high impact wall board or cement board in wet environments, utilize Series 215 and fiberglass tape or compound suitable for wet environments.

**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)	5-7 hours

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

- VOLATILE ORGANIC COMPOUNDS** **Unthinned:** 0.19 lbs/gallon (22 grams/litre)  
**Thinned 5% (No. 2 Thinner):** 0.52 lbs/gallon (63 grams/litre)  
**Thinned 5% (No. 42 Thinner):** 0.50 lbs/gallon (60 grams/litre) †

**THEORETICAL COVERAGE** 1,604 mil sq ft/gal (39.4 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS** Two: Part A and Part B (2 Parts A to 1 Part B by volume)

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<b>PACKAGING</b>		<b>PART A</b>	<b>PART B</b>	<b>When Mixed</b>
	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)
<b>NET WEIGHT PER GALLON</b>	11.85 ± 0.25 lbs (5.37 ± .11 kg) mixed †			
<b>STORAGE TEMPERATURE</b>	Minimum 40°F (4°C) Maximum 90°F (32°C) <b>Note:</b> 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.			
<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>	N/A			
<b>HEALTH &amp; SAFETY</b>	This product contains chemical ingredients which are considered hazardous. Read container label warning and Safety Data Sheet for important health and safety information prior to the use of this product. <b>Keep out of the reach of children.</b>			

## APPLICATION

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

	<b>Dry MILS (Microns)</b>	<b>Wet MILS (Microns)</b>	<b>Sq Ft/Gal (m<sup>2</sup>/Gal)</b>
Horizontal	6.0-12.0 (150-305)	6.0-12.0 (150-305)	134-267 (12.4-24.8)
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 6.4 ounces (190 mL) per gallon to improve application properties. Brush and roll application use No. 2 Thinner. Spray application use No. 42 Thinner.

**POT LIFE** 20 minutes at 60°F (16°C) 15 minutes at 70°F (21°C)  
Increasing material temperatures will significantly reduce the pot life.

**APPLICATION EQUIPMENT** Brush, roller, squeegee and airless spray.

### Airless Spray

<b>Pump</b>	<b>Tip Orifice</b>	<b>Atomizing Pressure</b>	<b>Mat'l Hose ID</b>	<b>Manifold Filter</b>
Graco "King" 45:1 or 56:1	0.019"-0.033" (485-840 microns)	4,000-5,000 psi (275-344 bar)	3/8" to 1/2" (9.5 to 12.7 mm)	60 mesh (250 microns)

**Roller:** Use high quality 3/8" to 1/2" shed resistant, synthetic woven nap 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. **Spraying should only be considered as a 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 should not be applied in direct sunlight.

**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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