



PRODUCT PROFILE

**GENERIC DESCRIPTION** Aliphatic Polyester Polyurethane

**COMMON USAGE** Extremely hard, chemical-resistant polyurethane floor coating with superb flow characteristics. Excellent resistance to abrasion, wet conditions, corrosive fumes and chemical contact. Gloss and color retention among the best of air dried finishes. **Note:** For horizontal surfaces only.

**COLORS** Available in the 16 standard StrataShield colors and limited custom colors. Contact Tnemec Company for availability. **Note:** Certain colors may require multiple coats depending on method of application and finish coat color. When feasible, the preceding coat should be in the same color family (blue, gray, etc.), but noticeably different.

**FINISH** Gloss

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

COATING SYSTEM

**PRIMERS** **Horizontal Concrete:** Series 201, 205, 280, 281, 287.

**INTERMEDIATE** Series 104, 205, 210, 237, 238, 239, 280, 281, 287  
**Note:** Before topcoating with Series 291, any Tnemec epoxy exterior exposed for more than three weeks must be scarified or reprimed with itself. Mechanically abrading or power-sanding is the preferred method of scarification. The maximum recoat time of Series 210, 237, 238, 239, 280 and 281 is 24 hours. Refer to those product data sheets for more information.

SURFACE PREPARATION

**ALL SURFACES** Prepare surfaces by method suitable for exposure and service. Refer to the appropriate primer data sheet for specific recommendations.  
 Must be clean, dry and free of oil, grease and other contaminants. Existing coatings require scarification and compatibility testing.

TECHNICAL DATA

**VOLUME SOLIDS** 62% ± 2.0% (mixed) †

**RECOMMENDED DFT** 2.0 to 3.0 mils (50 to 75 microns) per coat. **Note:** Number of coats will vary depending on color, substrate (surface) and other variables. Contact your Tnemec representative.

**CURING TIME**

Temperature	To Recoat	To Service	Chemical Resistance
75°F (24°C)	12-48 hours	24 hours	7 days

Curing time varies with surface temperature, air movement, humidity and film thickness.  
**Note:** If more than 48 hours have elapsed between coats, the coated surface must be mechanically abraded before topcoating.

**VOLITILE ORGANIC COMPOUNDS** **Unthinned:** 2.91 lbs/gallon (348 grams/litre)  
**Thinned 15%:** 3.34 lbs/gallon (401 grams/litre) †

**THEORETICAL COVERAGE** 994 mil sq ft/gal (24.4 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS** Two: Part A and Part B (2.5 Parts A to 1 Part B by volume)

**PACKAGING**

	PART A (Partially filled)	PART B	When Mixed Yield
Large Kit	3 gallon pail	1 gallon can	3 gallons (11.36L)
Small Kit	1 gallon can	1/2 gallon can	1 gallon (3.79L)

**NET WEIGHT PER GALLON** 10.40 ± 0.25 lbs (4.72 ± .11 kg) (mixed) †

**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: 92°F (33°C) Part B: >200°F (93°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.**

# CRU | SERIES 291

## APPLICATION

### COVERAGE RATES

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Suggested	2.5 (65)	4.0 (100)	398 (37.0)
Minimum	2.0 (50)	3.0 (75)	497 (46.2)
Maximum	3.0 (75)	5.0 (125)	331 (30.8)

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

Stir contents of each container, making sure no pigment remains on the bottom. Add Part B to Part A while under agitation. Continue agitation until the two components are thoroughly mixed. Do not use mixed material beyond pot life limits. Part B is moisture-sensitive and will react with atmospheric moisture. Unused material must be kept tightly closed at all times.

### THINNING

Thin up to 15% or 19 ounces (360 mL) per gallon with No. 39 Thinner. **Note:** Thinning is required for proper application. **Caution: Do not add thinner if more than thirty (30) minutes have elapsed after mixing.**

### POT LIFE

1 1/2 hours at 60°F (16°C)    1 1/4 hours at 77°F (25°C)    1 hour at 100°F (38°C)

### APPLICATION EQUIPMENT

**Roller:** Use a 1/4" (6.4 mm) high quality and shed-resistant synthetic woven nap roller cover. Do not use medium or long nap roller covers.

**Brush:** Use high quality natural or synthetic bristle brushes.

### Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.011"-0.015" (230-330 microns)	2700-3300 psi (207-241 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	100 mesh (150 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

### SURFACE TEMPERATURE

Minimum 40°F (4°C)    Maximum 135°F (57°C)

The surface should be dry and at least 5°F (3°C) above the dew point. This product is moisture-sensitive until cured. Application of the coating above the maximum recommended dry film thickness may cause bubbles to form in the cured film.

### CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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