

## PRODUCT PROFILE

<b>GENERIC DESCRIPTION</b>	Polyamide Epoxy-Coal Tar
<b>COMMON USAGE</b>	A corrosion resistant coating providing protection for concrete and steel in a variety of chemical, non-potable immersion and underground conditions. Excellent for use on pilings, penstocks, non-potable pipes and tanks, dam gates, or wherever a durable barrier coat is needed.
<b>COLORS</b>	Black
<b>FINISH</b>	Semi-gloss
<b>SPECIAL QUALIFICATIONS</b>	Meets the Corps of Engineers C-200 and C-200a, and SSPC Paint 16 specifications.

## COATING SYSTEM

<b>PRIMERS</b>	<b>Steel:</b> Self-priming or Series 1, 66, N69, N69F, 90-97, H90-97, 161 <b>Galvanized Steel:</b> Series 66, N69, N69F, 161 <b>Concrete:</b> Self-priming, 218
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## SURFACE PREPARATION

<b>STEEL</b>	<b>Immersion Service:</b> SSPC-SP10 Near-White Blast Cleaning <b>Non-Immersion Service:</b> SSPC-SP6 Commercial Blast Cleaning
<b>GALVANIZED STEEL</b>	Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.
<b>CAST/DUCTILE IRON</b>	Contact your Tnemec representative or Tnemec Technical Services.
<b>CONCRETE</b>	Allow new concrete to cure for 28 days. Abrasive blast all surfaces referencing SSPC-SP13/NACE 6, ICRI CSP 2-4 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.
<b>PRIMED SURFACES</b>	<b>Immersion Service:</b> Surface must be scarified by blasting with fine abrasive after 60 days.
<b>ALL SURFACES</b>	Must be clean, dry and free of oil, grease and other contaminants.

## TECHNICAL DATA

<b>VOLUME SOLIDS</b>	75 ± 2.0% (mixed)
<b>RECOMMENDED DFT</b>	6.0 to 16.0 (150 to 406 microns)
<b>CURING TIME</b>	

Temperature	To Touch	To Recoat (Min./Max)	Immersion
95°F (35°C)	2 hours	5-12 hours	2 days
75°F (24°C)	8-10 hours	18-72 hours	4 days
55°F (13°C)	14 hours	48-72 hours	7 days

Curing time varies with surface temperature, air movement, humidity and film thickness. Use the above times as guidelines only. Scarify the surface with fine abrasive before recoating if the maximum recoat time has been exceeded.

<b>VOLATILE ORGANIC COMPOUNDS</b>	<b>Unthinned:</b> 1.82 lbs/gallon (219 grams/litre) <b>Thinned 5% (No. 2 Thinner):</b> 2.08 lbs/gallon (250 grams/litre)
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**THEORETICAL COVERAGE** 1,203 mil sq ft/gal (29.5 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates.

**NUMBER OF COMPONENTS** Two: Part A and Part B

**MIXING RATIO** By volume: Four (Part A) to one (Part B)

**PACKAGING** KIT CONSISTS OF:

	PART A	PART B	Yield (mixed)
Large Kit	5 gallon pail (partial fill)	1 gallon can	5 gallons (18.9L)

**NET WEIGHT PER GALLON** 10.62 ± 0.25 lbs (4.82 ± .11 kg) (mixed)

**STORAGE TEMPERATURE** Minimum 20°F (-7°C) Maximum 110°F (43°C)

**TEMPERATURE RESISTANCE** (Dry) Continuous 200°F (93°C) Intermittent 250°F (121°C)

**SHELF LIFE** 18 months at recommended storage temperature.

**FLASH POINT - SETA** Part A: 94°F (34°C) Part B: 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.**

# TNEME-TAR | SERIES 47

## APPLICATION

**COVERAGE RATES**

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Minimum	6.0 (150)	8.0 (205)	201 (18.6)
Maximum	16.0 (406)	21.0 (533)	75 (7.0)

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 the container marked Part A, making sure no pigment remains on the bottom. Add the contents of the can marked 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. **Note:** Both components should be above 50°F (10°C) prior to mixing. For application to surfaces between 50°F to 60°F (10°C to 16°C), allow mixed material to stand thirty (30) minutes and restir before using. For optimum application properties, the material temperature should be above 60°F (16°C).

**THINNING**

Use No. 2 Thinner. For airless spray, thin up to 5% or 1/4 pint (190 mL) per gallon.

**POT LIFE**

4 hours at 75°F (24°C)

**APPLICATION EQUIPMENT**

**Airless Spray**

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.021" (430-530 microns)	2500-3000 psi (172-206 bar)	3/8" or 1/2" (9.5 or 12.7 mm)	NA

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

**Brush:** Brushing is recommended on small areas only. Ladle material on and then use flat side of brush to spread. Do not brush out to thin film as with conventional coatings.

**SURFACE TEMPERATURE**

Minimum 50°F (10°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Coating won't cure below minimum surface temperature.

**CLEANUP**

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

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