



MULTI-PURPOSE EPOXY SERIES 48

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamide Epoxy
COMMON USAGE	A multi-purpose epoxy coating with fast-cure and low temperature application properties. An excellent choice for shop and field application when rapid curing for fast turn-around is needed. Can be applied to a variety of substrates including steel, concrete, and CMU, as well as previously painted surfaces. Accepts a range of primers and topcoats for complete system selection.
COLORS	Available in light- and mid-tone colors. Deep-tone and safety colors may be limited. Contact your Tnemec Representative for more information. Note: Epoxies chalk with extended exposure to sunlight. 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 yellowing to occur.
FINISH	Flat

COATING SYSTEM

PRIMERS	Steel: Self-priming or Series 1, 90-97, 135, 394 Concrete or CMU: Self-priming or Series 215, 218, 1254, 130
TOPCOATS	Series 73, 1026, 1028, 1029, 1074, 1075, 1095
	Note: Other primer and topcoat options may be available. Contact your Tnemec Coatings Consultant for more information.

SURFACE PREPARATION

STEEL	SSPC-SP6/NACE 3 Commercial Blast Cleaning
CONCRETE	Allow new concrete to cure for 28 days. Abrasive blast referencing SSPC-SP13/NACE 6, ICRI-CSP3-5 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.
CMU	Allow mortar to cure for 28 days. Level protrusions and mortar spatter.
OVERCOATING	For overcoat applications, reference the latest revision of Tnemec Technical Bulletin No. 98-10 and contact your Tnemec representative.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	58.0 ± 2.0% (mixed) †
RECOMMENDED DFT	4.0 to 6.0 mils (100 to 150 microns) per coat. Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME	Temperature	To Touch	To Handle	To Recoat
	75°F (24°C)	1/2 hour	2 hours	3 hours
	65°F (18°C)	3/4 hour	4 hours	5-6 hours
	55°F (11°C)	1 hour	4-5 hours	6-8 hours
	45°F (7°C)	1-2 hours	6-8 hours	9-12 hours
	35°F (2°C)	2-3 hours	9-12 hours	12-15 hours

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS	Unthinned: 2.36 lbs/gallon (282 grams/litre) Thinned 10% (No. 60 Thinner): 2.83 lbs/gallon (339 grams/litre) Thinned 10% (No. 4 Thinner): 2.83 lbs/gallon (339 grams/litre) †
HAPS	Unthinned: 2.59 lbs/gal solids Thinned 10% (No. 60 Thinner): 2.59 lbs/gal solids Thinned 10% (No. 4 Thinner): 3.54 lbs/gal solids
THEORETICAL COVERAGE	930 mil sq ft/gal (22.8 m ² /L at 25 microns). See APPLICATION for coverage rates. †
NUMBER OF COMPONENTS	Two: Part A and Part B
PACKAGING	5 gallon (18.9L) pails and 1 gallon (3.79L) cans — Order in multiples of 2.
NET WEIGHT PER GALLON	14.22 ± 0.25 lbs (6.45 ± .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	24 months at recommended storage temperature
FLASH POINT - SETA	Part A: 82°F (28°C) Part B: 80°F (27°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.

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APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Minimum (1)	4.0 (100)	7.0 (180)	233 (21.6)
Maximum	6.0 (150)	10.5 (265)	155 (14.4)

(1) Note: Roller or brush application requires two or more coats to obtain recommended film thickness. Allow for overspray and surface irregularities. Wet 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

Power mix contents of each container, making sure no pigment remains on the bottom. Pour a measured amount of Part B into a clean container large enough to hold both components. Add an equal volume of Part A to Part B 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 applications to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand thirty (30) minutes and stir before using. For optimum application properties, the material temperature should be above 60°F (16°C).

THINNING

Use No. 60 or No. 4 Thinner. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray, brush or roller, thin up to 5% or 1/4 pint (190 mL) per gallon.

POT LIFE

16 hours at 35°F (2°C) 2 hours at 77°F (25°C) 1/2 hour at 100°F (38°C)

APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	765 or 704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	75-100 psi (5.2-6.9 bar)	25-35 psi (1.7-2.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	4000-4800 psi (276-331 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

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

Roller: Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic woven nap covers.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 35°F (2°C) Maximum 135°F (57°C)

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

CLEANUP

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

† Values may vary with color.

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