



FILLER AND SURFACER SERIES 63-1500

PRODUCT PROFILE

GENERIC DESCRIPTION Modified Amine Epoxy

COMMON USAGE A non-shrinking, trowel-grade filler and surfacer for concrete or steel, with high bond strength and outstanding resistance to abrasion, impact, wet conditions, corrosive fumes and chemical contact.

COLORS Mixed: Beige

SPECIAL QUALIFICATIONS Ambient air cured 63-1500 is acceptable for use on the interior of potable water storage tanks and reservoirs when overcoated with a Std. 61 certified protective coating. Contact your Tnemec representative for approved systems and additional information.

COATING SYSTEM

PRIMERS **General Use, Concrete or Steel:** Self-priming or Series 27, 46H-413, 61, 66, N69, N69F, 84, 104, 161
Potable Water Use, Concrete or Steel: Self-priming or Series 20, FC20, 91-H₂O (steel only), N140

TOPCOATS **General Use:** Series 27, 46H-413, 54-660, 61, 66, N69, 104, 113, 114, 161, 201
Potable Water Use: Series 20, FC20, N140

SURFACE PREPARATION

PRIMED STEEL **Severe Exposure or Immersion Service:** Scarify the epoxy prime coat surface by abrasive blasting before topcoating with 63-1500 if the prime coat has been exterior exposed for 14 days or longer. Scarify the 63-1500 surface by abrasive blasting before topcoating if the 63-1500 has been exterior exposed for 14 days or longer.

STEEL **Severe Exposure:** SSPC-SP10/NACE 2 Near-White Blast Cleaning
Mild Exposure: SSPC-SP6/NACE 3 Commercial Blast Cleaning

CONCRETE Allow new concrete to cure 28 days. For optimum results, abrasive blast referencing SSPC-SP13/NACE 6 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.

ALL SURFACES Must be clean, dry and free of oil, grease, chalk and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 100% (mixed)

RECOMMENDED DFT **Trowelled:** 1/32" to 1/16" (0.8 mm to 1.6 mm)
Filling and Patching: Up to 2" (5 cm) deep

CURING TIME

Temperature	To Touch	To Handle	To Recoat
75°F (24°C)	2-3 hours	24 hours	3 hours †

Curing time varies with surface temperature, air movement, humidity and film thickness.
 † 12 hours if succeeding coat is squeegeed, rolled or brushed.

VOLITILE ORGANIC COMPOUNDS 0.07 lbs/gallon (8 grams/litre)

THEORETICAL COVERAGE 1,604 mil sq ft/gal (39.4 m²/L at 25 microns). One quart will cover 13 square feet (1.2 m²) at 31.0 dry mils (790 microns), or 1/32" (0.8 mm); or will fill 56 cubic inches (920 cm³).

NUMBER OF COMPONENTS Two: Part A and Part B

PACKAGING Small kit—1 gallon (3.79 L) yield

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

SHELF LIFE 24 months at recommended storage temperature.

FLASH POINT - SETA N/A

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.

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APPLICATION

SPREADING RATE	One quart will cover 13 square feet (1.2 m ²) at 31.0 dry mils (790 microns), or 1/32" (0.8 mm); or will fill 56 cubic inches (920 cm ³).
MIXING	Cut off tops of cans with a can opener to facilitate removal of contents. Add Part B (Curing Agent) to Part A (Base). Mix with a power mixer until the two components are thoroughly blended. Do not use mixed material beyond pot life limits.
THINNING	Do not thin.
POT LIFE	35 minutes at 77°F (25°C) 15 minutes at 100°F (38°C)
APPLICATION EQUIPMENT	Spot fill holes and cracks with a putty knife or pointing trowel. Apply to large surfaces with a trowel and spread uniformly with a medium hardness rubber float or trowel. Follow with a rubber squeegee or trowel dipped in MEK or xylene if a smoother finish is desired.
SURFACE TEMPERATURE	Minimum 35°F (2°C) Maximum 100°F (38°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 mixing equipment immediately after use with MEK. Application equipment should be cleaned occasionally during application.

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