



HI-BUILD EPOXOLINE SERIES 66

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamide Epoxy
COMMON USAGE	Industry standard for epoxy coatings for over 30 years. Known for its forgiving application characteristics in adverse and varied conditions, and for benchmark performance.
COLORS	Refer to Tnemec Color Guide. Note: Epoxies chalk with extended exposure to sunlight and may yellow on aging. 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 accelerate any potential yellowing.
FINISH	Satin
SPECIAL QUALIFICATIONS	Meets the performance requirements of AWWA C 210 (not for potable water contact). Contact your Tnemec representative for system recommendations.
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS	<p>Steel: Self-priming or Series 1, 20, FC20, 37H, N69, 90, 91-H₂O, 94-H₂O, 161, 394, 530</p> <p>Galvanized Steel and Non-Ferrous Metal: Self-priming</p> <p>Concrete: Self-priming, 54-660, 201, 216, 218</p> <p>CMU: 54-562, 54-660, 130, 216, 218</p> <p>Drywall: 51-792 for dry interior environments</p> <p>Note: A maximum recoat time may apply depending on the topcoat specified. Refer to the applicable topcoat product sheet for information on product specific maximum recoat times.</p>
TOPCOATS	46H-413, 66, N69, 73, 84, 104, 113, 114, 161, 262, 265, 290, 291, 1070, 1071, 1072, 1074, 1074U, 1075, 1075U, 1077, 1078. Refer to COLORS on applicable topcoat data sheets for additional information. Note: A maximum recoat time may apply depending on the topcoat specified. Refer to the applicable topcoat product sheet for information on product specific maximum recoat times.

SURFACE PREPARATION

PRIMED STEEL	Immersion Service: Scarify the Series 66 prime coat surface by abrasive-blasting with a fine abrasive before topcoating if: (a) the 66 prime coat has been in exterior exposure for 60 days or longer and 66, 46H-413, N69 or 161 is the specified topcoat; (b) the 66 prime coat has been in exterior exposure for 14 days or longer and Series 104 is the specified topcoat; (c) the 66 prime coat has been in exterior exposure for 7 days or longer and Series 262 or 265 is the specified topcoat.
STEEL	Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning
GALVANIZED STEEL & NON-FERROUS METAL	Surface preparation recommendations will vary depending on the substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.
CAST/DUCTILE IRON	Contact your Tnemec representative or Tnemec Technical Services.
CONCRETE	Allow new concrete to cure 28 days. For optimum results and/or immersion service, abrasive blast referencing SSPC-SP13/NACE 6 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide.
CMU	Allow mortar to cure for 28 days. Prepare in accordance with SSPC-SP13/NACE 6 to level protrusions and mortar spatter, and remove other contaminants.
PAINTED SURFACES	Non-Immersion Service: Ask your Tnemec representative for specific recommendations.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	56.0 ± 2.0% (mixed) †
RECOMMENDED DFT	2.0 to 6.0 mils (50 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	Immersion
	75°F (24°C)	2 hours	10 hours	12 hours	7 days

Curing time varies with surface temperature, air movement, humidity and film thickness.
Ventilation: When used as a tank lining or in enclosed areas, provide adequate ventilation during application and cure. Reference guidelines contained in the latest edition of AWWA D 102.

VOLATILE ORGANIC COMPOUNDS	<p>Unthinned: 3.02 lbs/gallon (362 grams/litre)</p> <p>Thinned 5%: 3.20 lbs/gallon (384 grams/litre)</p> <p>Thinned 10%: 3.37 lbs/gallon (404 grams/litre) †</p>
THEORETICAL COVERAGE	898 mil sq ft/gal (22.0 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	12.50 ± 0.25 lbs (5.67 ± .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.

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FLASH POINT - SETA Part A: 82°F (28°C) Part B: 64°F (18°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.

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	4.0 (100)	7.0 (180)	225 (20.9)
Minimum	2.0 (50)	3.5 (90)	450 (41.8)
Maximum	6.0 (150)	10.5 (265)	150 (13.9)

Note: The above reflects the total range to which Series 66 can be applied for specific applications. To insure the proper thickness and number of coats is specified for certain substrates and exposures, consult the Tnemec Guide Specifications and/or contact your Tnemec representative. **Note:** Roller or brush application may require 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 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, blended components should be above 60°F (16°C). Mixing ratio is one to one by volume.

THINNING

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

POT LIFE

20 hours at 50°F (10°C) 10 hours at 77°F (25°C) 4 hours 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)	10-20 psi (0.7-1.4 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)	3000-4000 psi (207-276 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.

Note: Application over inorganic zinc-rich primers: Apply a wet mist coat and allow tiny bubbles to form. When bubbles disappear in 1 to 2 minutes, apply a full wet coat at specified mil thickness.

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 50°F (10°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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