



**PRODUCT PROFILE**

**GENERIC DESCRIPTION** Acrylic Emulsion

**COMMON USAGE** Decorative, high-build protection against weather, driving rain, industrial fumes and alternate freezing-thawing. Formulated to resist mildew growth on the paint film. Available in smooth and sand-texture finishes for concrete, CMU and properly primed steel. Spray application "dry-falls" under certain conditions.

**COLORS** Refer to Tnemec Color Guide.

**FINISH** Series 180: Flat, smooth    Series 181: Flat, sand texture

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

**COATING SYSTEM**

**PRIMERS** Self-priming on concrete, masonry, brick, stucco and lightweight block.  
**Split-Face & Split-Fluted CMU:** Series 130, 54-562  
**Steel:** 10-99, 37H, 66, N69, 90E-92, N140, 161

**TOPCOATS** Prepare surfaces by method suitable for exposure and service. Refer to the primer data sheet.

**SURFACE PREPARATION**

**PAINTED SURFACES** Prepare surfaces by method suitable for exposure and service. Refer to the primer data sheet.  
 Remove chalk and old paint not tightly bonded to the surface. Patch cracks

**ALL SURFACES** Must be clean, dry and free of oil, grease, form release agents and other contaminants. Allow new concrete, masonry and stucco to cure 7 days. Level protrusions and mortar spatter.

**TECHNICAL DATA**

**VOLUME SOLIDS** 44.0 ± 2.0% †

**RECOMMENDED DFT** 4.0 to 10.0 mils (100 to 255 microns) per coat. **Note:** Number of coats and thickness requirements will vary with substrate, application method and exposure. See APPLICATION and/or contact your Tnemec representative.

**CURING TIME**

Temperature	To Touch	To Recoat
75°F (24°C)	1 hour	3 hours

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

**VOLITILE ORGANIC COMPOUNDS**

**Unthinned:** 0.82 lbs/gallon (98 grams/litre)  
**Thinned 5%:** 0.82 lbs/gallon (98 grams/litre) †

**THEORETICAL COVERAGE** 705 mil sq ft/gal (17.3 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS** One

**PACKAGING** 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

**NET WEIGHT PER GALLON** 11.50 ± 0.25 lbs (5.22 ± .11 kg) †

**STORAGE TEMPERATURE** Minimum 35°F (2°C)    Maximum 110°F (43°C)

**TEMPERATURE RESISTANCE** (Dry) Continuous 170°F (77°C)    Intermittent 200°F (93°C)

**SHELF LIFE** 24 months at recommended storage temperature.

**FLASH POINT - SETA** N/A

**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.**

# W.B. TNEME-CRETE® | 180 & 181

**APPLICATION**

**COVERAGE RATES**

**Dense Concrete, Masonry and Filled CMU**

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Minimum	4.0 (100)	9.5 (240)	176 (16.3)
Maximum	8.0 (205)	19.0 (485)	88 (8.2)

**CMU (First Coat)**

Minimum	8.0 (205)	19.0 (485)	88 (8.2)
Maximum	10.0 (255)	24.0 (610)	71 (6.5)

**Primed Steel**

Minimum	4.0 (100)	9.5 (240)	176 (16.3)
Maximum	6.0 (150)	14.5 (370)	118 (10.9)

Allow for application losses and surface irregularities. Spreading rates are approximate and variable based on the roughness and porosity of substrates; also the method of application. Film thickness is rounded to the nearest 0.5 mil or 5 microns. Wet and dry film thicknesses are calculated from the sq ft/gal figures. There is no method for accurately measuring the applied film thickness of texture coatings. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

*Important: Protection against weather, driving rain and alternate freezing and thawing is obtained when coating is applied to form a continuous, void-free film.* The coating must be brushed, rolled or sprayed and back-rolled onto block. Grooves in scored and fluted block must be brushed. Two coats are normally recommended for lightweight block. Split-face and split-fluted block must be filled. Contact your Tnemec representative for specific coating system recommendations. †

**MIXING  
THINNING  
APPLICATION EQUIPMENT**

Stir thoroughly with a power mixer, making sure no pigment remains on the bottom of the can.

Normally none required. Can be thinned up to 5% or 1/4 pint (190 mL) per gallon with clean water.

**Series 180 or 181**

**Air Spray**

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss (1)	D AC	64HD 62HD	5/16" or 3/8" (7.9 or 9.5 mm)	1/2" (12.7 mm)	50-70 psi (3.4-4.8 bar)	30-40 psi (2) (2.1-2.8 bar)

(1) With heavy duty spring (JGA 191K2).

(2) Series 181 air spray. An alternative to using a pressure pot for air spray of texture coatings that should increase production time is using a low pressure transfer pump designed for texture coatings, such as Graco 987-429 10:1 president pump rubber packed (up to 1,000 psi with 3 gpm max fluid delivery) equipped with an air evenflo control with pump and atomizing air regulators. Contact Tnemec Technical Service for more information.

**Series 180 only**

**Airless Spray**

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.023"-0.031" (585-785 microns)	2000-2800 psi (138-193 bar)	3/8" (9.5 mm)	30 mesh (600 microns)

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

**Roller:** Use a synthetic cover. For smooth surfaces use 3/8" to 3/4" (9.5 mm to 19.0 mm) nap. For rough surfaces use 3/4" (19.0 mm) or longer nap. To obtain proper penetration for rough or porous surfaces, thin up to 5% or 1/4 pint (190 mL) per gallon. Force material into voids and hairline cracks with a brush or squeegee. Smooth out build-up at laps. Multiple coats may be required to achieve recommended film thickness, depending on applicator technique and roller nap size.

**Brush:** Use a stiff nylon brush. Work material into voids and avoid brushing out too thin.

**SURFACE TEMPERATURE**

Minimum 40°F (4°C) Maximum 90°F (32°C)  
The surface should be dry and at least 5°F (3°C) above the dew point.

**CLEANUP**

Flush and clean all equipment immediately after use water.

**CAUTION**

Dry overspray can be wiped or washed from most surfaces. Satisfactory dry-fall performance depends upon height of work, weather conditions, equipment adjustment and proper thinning. Low temperature and high humidity are of particular concern. Test for each application as follows: Spray from 15 to 25 feet towards paint container. The material then should readily wipe off. **Note:** Heat can fuse-dry overspray to surfaces. Always clean dry overspray from hot surfaces before fusing occurs. Be aware that exterior surface temperatures can be higher than air temperature.

† Values may vary with color.

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