



H.B. TNEMECOL SERIES 46-465

PRODUCT PROFILE

GENERIC DESCRIPTION	Coal Tar
COMMON USAGE	Versatile coal tar coating for use in immersion, splash and spillage, chemical fumes and below-grade environments.
COLORS	Black
FINISH	Semi-gloss

COATING SYSTEM

PRIMERS	Self-priming
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SURFACE PREPARATION

	Prepare by method suitable for exposure and service.
STEEL	Immersion Service: SSPC-SP6 Commercial Blast Cleaning
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.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants. Concrete surfaces must also be free of all form release agents, curing compounds/sealers, hardeners and membranes.

TECHNICAL DATA

VOLUME SOLIDS	64.0 ± 2.0%
RECOMMENDED DFT	8.0 to 12.0 mils (205 to 305 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 Recoat	Immersion
75°F (24°C)	2 hours	24 hours	7 days

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

VOLITILE ORGANIC COMPOUNDS

Unthinned: 2.56 lbs/gallon (306 grams/litre)
Thinned 5%: 2.78 lbs/gallon (333 grams/litre)

THEORETICAL COVERAGE 1,026 mil sq ft/gal (25.2 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS One

PACKAGING 55 gallon (208.2L) drums, 5 gallon (18.9L) pails and 1 gallon (3.79L) cans.

NET WEIGHT PER GALLON 13.08 ± 0.25 lbs (5.93 ± .11 kg)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 120°F (49°C)

TEMPERATURE RESISTANCE (Dry) Continuous 140°F (60°C) Immersion Service 120°F (49°C)

SHELF LIFE 12 months at recommended storage temperature.

FLASH POINT - SETA 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.

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	10.0 (255)	15.5 (395)	103 (9.5)
Minimum	8.0 (205)	12.5 (320)	128 (11.9)
Maximum	12.0 (305)	19.0 (480)	86 (7.9)

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 thoroughly, making sure no pigment remains on the bottom of the can.

THINNING

Use No. 2 Thinner. For air or airless spray, brush or roller, thin up to 5% or 1/4 pint (190 mL) per gallon if necessary. Drum heaters or inline heaters may be necessary to maintain application viscosity during cool weather.

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APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss MBC or JGA	E	704	3/8" or 1/2" (9.5 or 12.7 mm)	1/2" or 3/4" (12.7 or 19 mm)	50 psi (3.4 bar)	20 psi (1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.031" (430-785 microns)	2400-3000 psi (165-207 bar)	3/8" or 1/2" (9.5 or 12.7 mm)	60 mesh (250 microns)

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

Roller: Use high quality synthetic nap covers. Short nap for smooth surfaces. Long nap for rough surfaces. **Note:** Two or more coats may be required to obtain recommended film thicknesses.

Brush: Use high quality nylon or synthetic bristle brushes. **Note:** Two or more coats may be required to obtain recommended film thicknesses.

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 135°F (57°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 with the recommended thinner or xylol.

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