



TNEME-LINER SERIES 61

PRODUCT PROFILE

GENERIC DESCRIPTION	Cycloaliphatic Amine Epoxy
COMMON USAGE	Tightly cross-linked epoxy with excellent corrosion and chemical resistance. Principally used for immersion service, including fuel storage, chemical containment and wastewater treatment.
COLORS	5002 Beige (prime coat) and 5001 Gray (finish coat)
FINISH	Semi-gloss
SPECIAL QUALIFICATIONS	A two-coat system of Series 61 at 4.0 to 6.0 dry mils (100-150 dry microns) per coat passes the performance requirements of MIL-PRF-4556F .
PERFORMANCE CRITERIA	Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS	Steel: Self-priming Concrete: Self-priming or Series 215, 218 CMU: Series 215, 218
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SURFACE PREPARATION

STEEL	Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning obtaining a minimum angular anchor profile of 2.0 mils (50 microns).
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.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	82.0 ± 2.0% (mixed) †
RECOMMENDED DFT	1. For JP-4, JP-5, JP-8, Aviation Gas and Jet A-1: 4.0 to 6.0 mils (100 to 150 microns) per coat (minimum of two coats). 2. Most Other Applications: 8.0 to 12.0 mils (205 to 305 microns) per coat (minimum of two coats). Contact your Tnemec representative for specific recommendations.

CURING TIME	Temperature	To Handle	To Recoat	Immersion
	75°F (24°C)	6 hours at 4.0 mils (100 microns)	16-18 hours •	5 to 7 days
		11 hours at 12.0 mils (305 microns)	16-18 hours •	5 to 7 days

Curing time varies with surface temperature, air movement, humidity and film thickness.
 • Maximum recoat time is 72 hours. If more than 72 hours have elapsed between coats, the coated surface must be scarified before topcoating.

VOLATILE ORGANIC COMPOUNDS	EPA Method 24 Unthinned: 0.36 lbs/gallon (45 grams/litre) Thinned 6%: 0.71 lbs/gallon (85 grams/litre) Thinned 10%: 1.21 lbs/gallon (145 grams/litre) †
HAPS	Unthinned: 1.59 lbs/gal solids Thinned 10%: 2.49 lbs/gal solids
THEORETICAL COVERAGE	1,315 mil sq ft/gal (32.3 m ² /L at 25 microns). See APPLICATION for coverage rates. †
NUMBER OF COMPONENTS	Two: Part A (amine) and Part B (epoxy)
PACKAGING	5 gallon (18.9L) pails and 1 gallon (3.79L) cans — Order in multiples of 2.
NET WEIGHT PER GALLON	13.10 ± 0.25 lbs (5.94 ± .11 kg) †
STORAGE TEMPERATURE	Minimum 20°F (-7°C) Maximum 110°F (43°C) For optimum application properties, material temperature should be above 60°F (16°C) prior to application.
TEMPERATURE RESISTANCE	(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C) Uninsulated Tanks (Immersion Service): Continuous 120°F (49°C) Intermittent 140°F (60°C) Insulated Tanks (Immersion Service): Continuous 180°F (82°C) Intermittent 210°F (99°C) Performance in high temperature immersion applications depends on liquid media, temperature and substrate. Contact your Tnemec representative for more information.
SHelf LIFE	24 months at recommended storage temperature.
FLASH POINT - SETA	Parts A & B: 81°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

For JP-4, JP-5, JP-8
Aviation Gas, Jet A-1 Service

	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	5.0 (125)	6.0 (150)	263 (24.4)
Minimum	4.0 (100)	5.0 (125)	329 (30.6)
Maximum	6.0 (150)	7.5 (190)	219 (20.4)

Most Other Applications

	Dry Mills (Microns)	Wet Mills (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	10.0 (255)	12.0 (305)	132 (12.2)
Minimum	8.0 (205)	10.0 (255)	164 (15.3)
Maximum	12.0 (305)	14.5 (355)	110 (10.2)

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

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 must be above 60°F (16°C) prior to mixing. Mixing ratio is one to one by volume. A large volume of material will set up quickly if not applied or reduced in volume. **Caution: Do not reseal mixed material. An explosion hazard may be created.**

THINNING

Use No. 2 Thinner. For air spray, thin up to 10% or 3/4 pint (380 mL) per gallon. For airless spray or brush, thin up to 5% or 1/4 pint (190 mL) per gallon. **Note:** A maximum of 6% of No. 2 Thinner may be used to comply with VOC regulations.

POT LIFE

2 1/2 hours at 60°F (16°C) 1 1/2 to 2 hours at 77°F (25°C) 3/4 to 1 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)	60-90 psi (4.1-6.2 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"-0.021" (380-535 microns)	3000-3800 psi (207-262 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.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes. **Note:** Two or more coats may be required to obtain recommended film thicknesses.

SURFACE TEMPERATURE

Minimum 60°F (16°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, xylol or MEK.

† Values may vary with color.

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