**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Modified Polyamine Epoxy

**COMMON USAGE**
An advanced generation, 100% solids epoxy filler and surfacer for concrete or steel. Excellent material for surfacing, patching and filling voids and bugholes in concrete substrates. Generally topcoated with a variety of high performance epoxies and polyurethanes for use in mild to aggressive exposures.

**COLORS**
1200 White, 1212 Gray

**FINISH**
Semi-Gloss

**SPECIAL QUALIFICATIONS**
Certified by NSF International in accordance with NSF ANSI Std. 61. Ambient air cured Series 215 is qualified for use on the interior of potable water storage tanks and reservoirs of 200 gallons (757 L) capacity or greater at 80 mils DFT or 95 mils DFT with fiberglass mat (Fiberglass Mat Product No. S211-0215). Return to immersion time is seven days. Contact your Tnemec representative for approved systems and additional information on potential uses.

**COATING SYSTEM**

**SURFACER/FILLER/PATCHER**
Self-patching or Series 217, 218

**PRIMERS**

**TOPCOATS**

**SURFACE PREPARATION**

**STEEL**
Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum 3.0 mil angular anchor profile.

Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum 3.0 mil angular anchor profile.

**CONCRETE**
Allow new cast-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness in accordance with ASTM F 1869 “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” (moisture vapor transmission should not exceed three pounds per 1,000 square feet in a 24 hour period), F 2170 “Standard Test Method for Determining Relative Humidity in Concrete using situ Probes” (relative humidity should not exceed 80%), or D 4263 “Standard Test Method for Indicating Moisture in Concrete by the Plastic Membrane Method” (no moisture present). Prepare concrete surfaces in accordance with NACE No. 6/SSPC-SP13 Joint Surface Preparation Standards and ICRI Technical Guidelines. Abrasive blast, shot-blast, water jet or mechanically abrade concrete surfaces to remove laitance, curing compounds, hardeners, sealers and other contaminants and to provide a minimum ICRI-CSP 5 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.

**CMU**
Allow mortar to cure for 14 days. Level protrusions and mortar spatter.

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

**TECHNICAL DATA**

**VOLUME SOLIDS**
100% (mixed) †

**RECOMMENDED DFT**

**CURING TIME**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>Dry Through</th>
<th>Maximum to Recoat ‡</th>
</tr>
</thead>
<tbody>
<tr>
<td>95°F (35°C)</td>
<td>4 hours</td>
<td>12 hours</td>
<td>14 days</td>
</tr>
<tr>
<td>75°F (24°C)</td>
<td>10 hours</td>
<td>24 hours</td>
<td>21 days</td>
</tr>
<tr>
<td>55°F (13°C)</td>
<td>18 hours</td>
<td>48 hours</td>
<td>21 days</td>
</tr>
<tr>
<td>45°F (7°C)</td>
<td>24 hours</td>
<td>72 hours</td>
<td>21 days</td>
</tr>
<tr>
<td>35°F (2°C)</td>
<td>32 hours</td>
<td>96 hours</td>
<td>21 days</td>
</tr>
</tbody>
</table>

† Note: If the Series 215 surface is exterior exposed for more than seven days, scarification is required before topcoating.

‡ Note: Use “To Touch” cure information for minimum recoat times if succeeding topcoats are spray-applied and “Dry Through” if succeeding topcoats are applied by roller, brush, or trowel.

**VOLATILE ORGANIC COMPOUNDS**
1,604 ml sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates. †

**NUMBER OF COMPONENTS**
Two: Part A and Part B (1 Part A to 1 Part B by volume)
### Packaging

<table>
<thead>
<tr>
<th>PART A</th>
<th>PART B</th>
<th>When Mixed</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>3 gal. pail (partial fill)</td>
<td>5 gal. pail (partial fill)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1 gallon can</td>
<td>3 gal. pail (partial fill)</td>
</tr>
<tr>
<td>Touch-Up Kit</td>
<td>1 quart can</td>
<td>1 quart can</td>
</tr>
</tbody>
</table>

**Net Weight per Gallon**

- **Large Kit**: 13.28 ± 0.25 lbs (6.02 ± .11 kg) (mixed)
- **Small Kit**: 11.7 ± 0.2 lbs (5.31 ± .09 kg) (mixed)

**Storage Temperature**

- Minimum 20°F (-6°C) to Maximum 110°F (43°C)
- Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C).
- It is suggested that the material be stored at these temperatures at least 48 hours prior to use.

**Temperature Resistance**

- (Dry) Continuous 250°F (121°C)
- Intermittent 275°F (135°C)
- 12 months at recommended storage temperature.

**Shelf Life**

- Part A and Part B: N/A

**Flash Point - Seta**

- 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.

**Health & Safety**

- Keep out of the reach of children.

### Application

**Coverage Rates**

<table>
<thead>
<tr>
<th>Thickness</th>
<th>Large Kit</th>
<th>Small Kit</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/32” (31 mils)</td>
<td>207 sq ft (19.2 m²)</td>
<td>103 sq ft (9.6 m²)</td>
</tr>
<tr>
<td>1/16” (62 mils)</td>
<td>103 sq ft (9.6 m²)</td>
<td>52 sq ft (4.8 m²)</td>
</tr>
<tr>
<td>1/8” (125 mils)</td>
<td>51 sq ft (4.8 m²)</td>
<td>26 sq ft (2.4 m²)</td>
</tr>
<tr>
<td>1/2” (500 mils)</td>
<td>13 sq ft (1.2 m²)</td>
<td>6 sq ft (0.6 m²)</td>
</tr>
</tbody>
</table>

**Mixing**

Mix the entire contents of Part A and Part B separately. Scrape all of the Part A material from the pail and into the Part B container by using a flexible spatula. Use a variable speed drill with a PVC Jiffy blade and mix the blended components for a minimum of two minutes. Apply the mixed material within the pot life limits after agitation. Normally not required. A large volume of material will gel quickly if not applied or reduced in volume.

**Thinning**

- Normally not required.
- Caution: Do not reseal mixed material. An explosion hazard may be created.

**Pot Life**

- 45 minutes at 70°F (21°C) to 25 minutes at 90°F (32°C)
- Material temperatures above 90°F (32°C) will significantly reduce the pot life.

**Application Equipment**

**Spray Application Equipment**

<table>
<thead>
<tr>
<th>Pump</th>
<th>Fluid Line</th>
<th>Spray Gun</th>
<th>Fluid Tips</th>
<th>Fluid Pressure</th>
<th>Atomizing Pressure</th>
<th>Hopper</th>
</tr>
</thead>
<tbody>
<tr>
<td>WIWA 410 9:1 Ratio</td>
<td>25’ 1” Diameter 10” 3/4” Diameter</td>
<td>WIWA Pole Gun</td>
<td>1/4” to 3/8”</td>
<td>180 to 360 psi (Adjust as necessary)</td>
<td>Adjust at gun for proper atomization</td>
<td>6.5 Gallons Stainless Steel</td>
</tr>
<tr>
<td>Graco 551, 561, X50, X60</td>
<td>3/8” to 1/2” I.D</td>
<td>XTR-7</td>
<td>0.031” to 0.041”</td>
<td>3500-4500 psi</td>
<td>N/A</td>
<td>6.5 Gallons Stainless Steel</td>
</tr>
<tr>
<td>Graco M680 10:1 Ratio</td>
<td>25’ 1” Diameter 10” 3/4” Diameter</td>
<td>Flex Hose</td>
<td>No. 5 Nozzle</td>
<td>200 psi (Adjust as necessary)</td>
<td>Adjust at gun for proper atomization</td>
<td>10 Gallons Stainless Steel</td>
</tr>
<tr>
<td>Graco M680 10:1 Ratio</td>
<td>25’ 1” Diameter 10” 3/4” Diameter</td>
<td>HTX</td>
<td>4F Fine Finish</td>
<td>250 psi (Adjust as necessary)</td>
<td>Adjust at gun for proper atomization</td>
<td>10 Gallons Stainless Steel</td>
</tr>
</tbody>
</table>

**Cart mounted 9:1 ratio, air operated pump with air filter, regulator and lubricator, air control manifold, fluid outlet drain with drain valve and control air hose assembly.**

**Surface Temperature**

- Minimum 35°F (2°C), maximum 130°F (54°C)
- The surface temperature should be at least 5°F (3°C) above the dew point.

**Material Temperature**

- Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested that the material be stored at these temperatures at least 48 hours prior to use.

**Cleanup**

- Flush and clean all equipment immediately after use with xylene, MEK, or when required by SCAQMD regulations, No. 74 Thinner.

**Values may vary with color.**

**Warranty & Limitation of Seller's Liability**

Tnemec Company Inc. warrants only that its coatings represented herein meet the formulation standards of Tnemec Company, Inc. The Warranties described in the above paragraph shall be in lieu of any other warranty, expressed or implied, including but not limited to, any implied warranty of merchantability or fitness for a particular purpose. There are no warranties that extend beyond the description on the face hereof. The buyer’s sole and exclusive remedy against Tnemec Company, Inc. shall be for replacement of the product in the event a defective condition of the product should be found to exist and the exclusive remedy shall not have failed its essential purpose as long as Tnemec is willing to provide comparable replacement product to the buyer. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, ENVIRONMENTAL INJURIES OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Tnemec Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.