Hi-Build Epoxoline SERIES 66

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamide Epoxy
COMMON USAGE	Industry standard for epoxy coatings for nearly 30 years. Known for its forgiving application characteristics in adverse and varied conditions, and for benchmark performance.
COLORS	**Primer:** 1211 Red. **Topcoat:** Refer to Tnemec ColorBook. **Note:** Epoxies chalk with extended exposure to sunlight. 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 cause yellowing to occur.
FINISH	Satin
SPECIAL QUALIFICATIONS	Meets the performance requirements of **AWWA C 210-84** (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	**Steel:** Self-priming or Series 20, 27, 37H, 50-330, 69, 90, 160, 161, 163 **Galvanized Steel and Non-Ferrous Metal:** Self-priming **Concrete:** Self-priming, 54-660, 201, 216, 230 **CMU:** 54-562, 54-660, 130, 216, 230 **Drywall:** 51-792
TOPCOATS	46-413, 46H-413, 66, 69, 71, 73, 74, 75, 104, 113, 114, 161, 163, 175 Refer to COLORS on applicable topcoat data sheets for additional information. **Note:** Series 66 exterior exposed for 3 weeks or longer requires an epoxy intermediate coat or scarification prior to topcoating with Series 71. Refer to 71 product data sheet for additional information.

SURFACE PREPARATION

STEEL	**Immersion Service:** SSPC-SP10 Near-White Blast Cleaning **Non-Immersion Service:** SSPC-SP6 Commercial Blast Cleaning
PRIMED STEEL	**Immersion Service:** Scarify the Series 66 prime coat surface by brush-blasting with fine abrasive before topcoating if: (a) the 66 prime coat has been exposed to sunlight for 60 days or longer and 66, 46-413, 46H-413, 69, 161, or 163 is the specified topcoat; (b) the 66 prime coat has been exterior exposed for 14 days or longer and Series 104 is the specified topcoat.
GALVANIZED STEEL & NON-FERROUS METAL	Surface preparation recommendations will vary depending on substrate and exposure conditions. Contact your Tnemec representative or Tnemec Technical Services.
CAST/DUCTILE IRON	Contact your Tnemec representative or Tnemec Technical Services.
CONCRETE	**Immersion and Floors:** Allow new concrete to cure for 28 days. Brush-off blast vertical surfaces. Brush-off blast or acid etch horizontal surfaces.
CMU	Allow mortar to cure for 28 days. Level protrusions and mortar spatter.
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	**Primer:** 3.0 to 5.0 mils (75 to 125 microns) per coat. **Intermediate, Topcoat:** 4.0 to 6.0 mils (100 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.

VOLATILE ORGANIC COMPOUNDS

Unthinned	Thinned 5%	Thinned 10%
3.02-3.30 lbs/gallon (362-395 grams/litre)	3.21-3.47 lbs/gallon (384-415 grams/litre)	3.37-3.63 lbs/gallon (404-434 grams/litre)

THEORETICAL COVERAGE*	898 mil sq ft/gal (22.0 m²/L at 25 microns). See APPLICATION for coverage rates.
NUMBER OF COMPONENTS	Two: Part A and Part B

SERIES 66 Hi-Build Epoxoline

TECHNICAL DATA continued

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 12 months at recommended storage temperature.

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*

	Primer			Intermediate / Topcoat		
	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m^2/Gal)	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m^2/Gal)
Suggested (1)	4.0 (100)	7.0 (180)	225 (20.9)	5.0 (125)	9.0 (230	180 (16.7)
Minimum	3.0 (75)	5.5 (140)	299 (27.8)	4.0 (100)	7.0 (180	225 (20.9)
Maximum	5.0 (125)	9.0 (230)*	180 (16.7)	6.0 (150)	10.5 (265	150 (13.9)

(1) Note: Roller or brush application requires two or more coats to obtain recommended film thickness. 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 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).

POT LIFE 20 hours at 50°F (10°C) 10 hours at 77°F (25°C) 4 hours at 100°F (38°C)

THINNING Use No. 4 Thinner. For air spray, thin up to 10% or ¾ pint (380 mL) per gallon. For airless spray, roller or brush, thin up to 5% or ¼ pint (190 mL) per gallon.

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 won't cure below minimum surface temperature.

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	765 or 78	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)	1800-3000 psi (124-207 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 or 12.7 mm) synthetic nap covers.
Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

CLEANUP Flush and clean all equipment immediately after use with the recommended thinner or MEK.

*Values may vary with color.