TNEMEC®

EPOXOLINE® WB SERIES 1224-1288

PRODUCT DATA SHEET

PRODUCT PROFILE

GENERIC DESCRIPTION
Inorganic Hybrid Water-Based Epoxy

COMMON USAGE
An advanced generation, low odor, low VOC, water-based epoxy coating featuring HydroLink curing technology for exceptional durability and corrosion resistance. Used as a primer under Series 972 on bulkheads, overheads, tanks, pipes, ductwork, and other areas within marine vessels. Offers superior wetting for marginally prepared steel and tightly adhered existing coatings. Formula protected under U.S. patent.

COLORS
1288 Off-White

FINISH
Flat

SPECIAL QUALIFICATIONS
When used as part of a system with Series 972, Series 1224-1288 complies with the requirements for Bulkhead, Wall, and Ceiling applications in accordance with FTP Code IMO Parts 2 and 5.

USCG Approval 164.112/200/0 and ABS Certificate of PDA-25-0417561-PDA when used as part of a system with Series 972.

COATING SYSTEM

PRIMERS
Self-priming

TOPCOATS
Series 972

SURFACE PREPARATION

STEEL
SSPC-SP6/NACE 3 Commercial Blast Cleaning
Note: Abrasive blast cleaning generally produces the best coating performance. If conditions will not permit this, Series 1224-1288 may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces.

NON-FERROUS METAL
Contact Tnemec Technical Services for more information.

PAINTED SURFACES
Test patch is recommended in accordance with Technical Bulletin 98-10 latest revision.

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

TECHNICAL DATA

VOLUME SOLIDS
65% (mixed)

RECOMMENDED DFT
4.0 to 8.0 mils (100 to 205 microns) per coat.
Note: Two coats may be required for aggressive exposures.

CURING TIME

Temperature	To Touch	To Handle	To Recoat
120°F (49°C)	15 minutes	1 hour	2 hours
95°C (35°C)	30 minutes	2 hours	3 hours
75°F (24°C)	1 hour	6 hours	8 hours
55°F (13°C)	2 hours	8 hours	16 hours
45°F (7°C)	3 hours	10 hours	24 hours
35°F (2°C)	4 hours	3 days	4 days

Curing time varies with surface temperature, air movement, humidity and film thickness. Substrates containing integral water repellants can prolong cure times.

VOLATILE ORGANIC COMPOUNDS
Unthinned: 0.01 lbs/gallon (1 g/L)

HAPS
0.00 lbs/gal solids

THEORETICAL COVERAGE
1,049 sq ft/gal (25.7 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS
Two: Part A and Part B

MIXING RATIO
By volume: two (Part A) to one (Part B).

PACKAGING

	Part A (partially filled)	Part B (partially filled	Yield (mixed)
Large Kit	5 gallon pail	6 gallon pail	5 gallons (18.9 L)
Small Kit	2 gallon pail	3 gallon pail	2 gallons (7.5 L)

NET WEIGHT PER GALLON
14.71 ± 0.25 lbs (6.67 ± 0.11 kg)

STORAGE TEMPERATURE
Minimum 35°F (2°C) Maximum 110°F (43°C)
Protect from freezing

TEMPERATURE RESISTANCE
(Dry) Continuous 375°F (190°C) Intermittent 400°F (204°C)

SHELF LIFE
12 months at recommended storage temperature.

EPOXOLINE® WB|SERIES 1224-1288

FLASH POINT - SETA

Part A: >230°F (110°C) Part B: >230°F (110°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 (m²/Gal)
Suggested	6.0 (150)	9.0 (230)	175 (16.2)
Minimum	4.0 (100)	6.0 (150)	262 (24.4)
Maximum	8.0 (205)	12.0 (305)	131 (12.2)

(1) Note for Steel: Roller or brush application requires two or more coats to obtain recommended film thickness. Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thickness may adversely affect coating performance.

MIXING

Power mix the contents of each container, making sure no pigment remains on the bottom. Thin 5% to 10% by volume, adding the entire amount of desired thinner to the Part A container. Mix contents of Part A and thinner. Pour half of the thinned Part A material into Part B while under agitation. Scrape pail walls to ensure the material is mixed thoroughly. Once the contents of the Part B pail have reached the same color and consistency, add the remaining Part A, and continue mixing until the material is uniform. Do not use mixed material beyond pot life limits. **Note:** Both components should be above 50°F (10°C) prior to mixing.

THINNING

Use cool, clean tap water. For airless spray, roller, or brush applications, thin 5% (6.4 oz) to 10% (12.8 oz) per gallon. **Caution: Thinning with high-temperature water will significantly reduce the pot life. For best results, water temperature should not exceed 80°F (27°C).**

POT LIFE

2 hours at 70°F (21°C) 1 hour at 95°F (35°C)

APPLICATION

For best results whten applying to surfaces exceeding 150°F (66°C), Series 1224-1288 should be spray applied in mist coats. Reference Surface Temperature for additional information.

APPLICATION EQUIPMENT

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.019"-0.023" (483-584 microns)	3000-4500 psi (207-310 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.
Roller: Use a synthetic woven nap cover. For smooth surfaces use 3/8" to 1/2" (9.5 mm to 12.7 mm). To obtain proper penetration for rough or porous surfaces, use a longer nap cover. Smooth out build-up at laps.
Brush: Use a stiff nylon brush. Work material into voids and avoid brushing out too thin.

MATERIAL TEMPERATURE

For optimum application and handling, the material temperature during application should be between 65°F and 85°F (18°C and 29°C). Temperature will affect the workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

CLEANUP

Flush out and clean all equipment immediately after use with water, followed by a final flush with MEK or Methyl Acetate.

CERTIFICATIONS

ABS DESIGN ASSESSED

1408/25