



Installation & Application Guide
Fiber-Reinforced Epoxy Systems



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1.0 - INTRODUCTION

Prior to starting work, read this entire guide carefully. If you have questions, call your Tnemec representative or Tnemec Company, Inc. at 1-800-TNEMEC1. It is important you obtain answers to any questions you have prior to starting work.

This installation and application guide is used in conjunction with the appropriate Product Data Sheets and addresses the application of the following products:

Series 201 Epoxoprime

Series 215 Surfacing Epoxy

Series 270 Stranlok

Series 273 Stranlok ML

Series 275 Stranlok

Series 280 Tneme-Glaze

Series 282 Tneme-Glaze

PRODUCTS

All kits, except Series 273 Stranlok ML, consist of Part A (resin) and Part B (converter). Series 273 Stranlok ML consists of Part A (resin), Part B (converter) and Part C (fiberglass mat). Series 270 and 275 are provided in premeasured kits and must be mixed in their entirety and not split down to a smaller size. In some instances, more than one kit can be mixed at a time if the crew size and mixing capacity are capable of handling a larger volume of material.

NOTE: Before getting started, it's important that the product temperature be between 70° F and 90° F at least 48-hr. prior to use. (See Storage & Handling on page two for more information.)

1.1 - TYPICAL FIBER-REINFORCED EPOXY SYSTEMS

Primer	Intermediate Coat (Fiber-reinforced)	Topcoat
Series 201 Epoxoprime	Series 270 Stranlok	Series 280 Tneme-Glaze ²
Series 201 Epoxoprime	Series 273 Stranlok ML ¹	Series 280 Tneme-Glaze ²
Series 201 Epoxoprime	Series 275 Stranlok	Series 282 Tneme-Glaze
Series 215 Surfacing Epoxy	Series 273 Stranlok ML	Series 280 Tneme-Glaze

¹ Series 273 can be self-priming over drywall.

² Additional topcoats are available. Please contact your Tnemec representative.

1.2 - MIXING AND APPLICATION OF 200 SERIES PRODUCTS

Each of the 200 Series products outlined in this guide are packaged in a kit comprised of two components, Part A and Part B. A separate clean pail, capable of holding five gallons, is recommended for ease of mixing. The Part B is always added to the Part A. It is important that any material which is transferred from one container to another be emptied out in its entirety by using a flexible spatula to scrape the sides clean.

MIXING NOTES

1. A large volume of mixed material will set up quickly if not applied or reduced in volume.
2. Mixing time is critical. Do not guess on mixing times. Use a watch or timer.

CAUTION: Do not reseal mixed materials. An explosion hazard may be created.

NOTE: For optimum application, handling and performance, the surface and material temperatures during application should be between 70° F and 90° F. For application below 70° F, contact your Tnemec representative for instructions and precautions. The substrate temperature should be at least 5° F above the dew point. Temperature will affect the workability. Cool temperatures increase viscosity and decrease workability. (See Storage & Handling on page two for further details.)

1.3 - TIMING BETWEEN APPLICATIONS

PRIMERS, INTERMEDIATE COATS AND TOPCOATS

Timing between primer, fiber-reinforced intermediates and topcoats is extremely important to ensure intercoat adhesion. The following information must be taken into consideration when planning a work schedule:

HORIZONTAL SURFACES

Install the fiber-reinforced products at least two hours but not more than 24 hours after the primer application.

VERTICAL AND OVERHEAD SURFACES

Install the fiber-reinforced products at least four hours but not more than 24 hours after the primer application.

NOTE: The primer must be sufficiently cured and "set" so that it does not flow, causing runs and sags when the fiber-reinforced system is applied. For best results, the primer should be tacky or pliable (two-six hours) when topcoated.

1.4 - CLEANUP

Clean all equipment immediately after use with a compatible solvent such as Methyl Ethyl Ketone (MEK) or Propylene Glycol Monomethyl Ether.

1.5 - STORAGE AND HANDLING

All materials must be stored between 40° F and 90° F. Prior to application, the material must be between 70° F and 90° F for a minimum of 48 hours. Heating the material prior to mixing will lower the viscosity for better application properties but the trade off is a shorter pot life. For optimum application, handling and performance, the surface and material temperatures should be between 70° F and 90° F. For application below 70° F, contact your Tnemec representative for instructions and precautions. Surface and air temperatures should be at least 5° F above the dew point.

1.6 - SAFETY INFORMATION

These products contain solvents and/or chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. For information regarding the potential hazards associated with this product, please refer to the container label or request a Material Safety Data Sheet from Tnemec Company, Inc., at the address noted in this guide or call 1-800-TNEMEC1. Please direct your inquiries to the attention of the Safety Director.

1.7 - SURFACE PREPARATION AND EQUIPMENT

Prepare substrate by methods recommended on the Primer Product Data Sheet (Series 201 Epoxoprime). All surfaces must be clean, moisture free, physically sound and free of all grease, oil, dust or any foreign materials or contaminants that will interfere with primer adhesion and/or penetration. Existing coatings can be removed by abrasive blasting.

EQUIPMENT AND SUPPLIES

This list includes tools and supplies normally required for surface preparation, priming, mixing and installation of Tnemec fiber-reinforced systems. If a surfacer, filler or patching compound is used, see the appropriate Product Data Sheet for additional information.

SURFACE PREPARATION OF CONCRETE FLOORS AND OTHER HORIZONTAL CEMENTITIOUS SURFACES

- Heavy duty circular type industrial floor scrubbing machine with several head attachments.
- Self-contained blasting equipment, i.e. Blastrac Wheelabrator.
- Power saw with carbide or diamond tip blades for cutting exposed perimeters and joint details.
- Heavy duty industrial “wet” vacuum.

SURFACE PREPARATION OF WALLS AND OTHER VERTICAL CEMENTITIOUS SURFACES

- Abrasive blast equipment.
- Assortment of power tools to include grinders and sanders.
- Assortment of hand tools to include scrapers and wire brushes.

NOTE: When preparing concrete, consult ASTM D 4528 Surface Cleaning Concrete for Coating and ASTM D 4259 Abrading Concrete.

SURFACE PREPARATION OF STEEL

NON-IMMERSION

- Abrasive blasting equipment capable of achieving a minimum cleanliness of SSPC-SP6 Commercial Blast Cleaning/NACE 3.
- Power tools referenced by SSPC-SP11 “Power Tool Cleaning to Bare Metal” (minimum 3.0 mil profile) when making small repairs or when a confined location precludes abrasive blast cleaning.

IMMERSION

- Abrasive blasting capable of achieving an SSPC-SP10 Near White Blast Cleaning/NACE 2.

2.0 - RECOMMENDED PRIMERS

SERIES 270 AND 275 STRANLOK

Series 201 Epoxoprime is the suggested primer for Series 270 & 275 Stranlok. Prior to application, Haydite and lightweight block will require a filler/surfacer to provide a pinhole free finish. Series 130 Envirofill is the recommended block filler and Series 218 MortarClad is the recommended resurfacer.

NOTE: To remove joints in CMU or fill voids in dense concrete, a plastering material such as Series 215 Surfacing Epoxy, Series 218 MortarClad or Series 201 Epoxoprime mixed with Series 211 fumed silica is recommended. (Refer to technical bulletin No. 98-11 R-2.)

SERIES 273 STRANLOK ML

Series 273 Stranlok ML can be self-priming when applied over drywall. When Series 273 is applied to CMU or dense concrete substrates, all joints and surface voids must be filled and leveled with Series 215 Surfacing Epoxy, Series 218 MortarClad or Series 201 Epoxoprime mixed with Series 211 fumed silica (refer to technical bulletin No. 98-11 R-2) using typical plastering techniques.

An alternative, labor-saving method is to apply Series 215 Surfacing Epoxy as a parge coat at a thickness of 1/32" - 1/8". This should completely smooth and level the concrete surface while at the same time create a bedding coat for placement of the Series 273 glass directly into the wet Series 215.

2.1 - SERIES 201 EPOXOPRIME

PACKAGING AND SUGGESTED COVERAGE

PACKAGING:

KIT SIZE	PART A	PART B	YIELD (MIXED)
Small	2 1-gallon cans	1 gallon can	3 gallons
Large	2 5-gallon pails	5 gallon pail	15 gallons
X-Large	2 55-gallon drums	55 gallon drum	165 gallons

COVERAGE RATES:

KIT SIZE	CONCRETE/DRYWALL (6.0 - 8.0 MILS)	STEEL (3.0 - 5.0 MILS)
Small	600 - 800	906 - 1602
Large	3000 - 4005	4800 - 8010
X-Large	33000 - 44055	52800 - 88110

NOTE: Mixed material for all the 200 Series products has a short pot life and should be ordered in kit sizes appropriate for the method of application to ensure the material can be applied within working times.

EQUIPMENT AND SUPPLIES

MIXING & APPLICATION OF SERIES 201 EPOXOPRIME

MIXING EQUIPMENT

Slow speed or variable speed (350 rpm or less) heavy duty (1/2" chuck or larger) electric or air driven drill fitted with a clean PS "Jiffy" mixing paddle.

SPRAY APPLICATION EQUIPMENT

A Graco "King" 45:1, 56:1, X50 or X60 airless spray pump may be used. Pump assembly should include a moisture trap and oiler, air regulator with gauge and fluid outlet drain valve. When spraying these non-fibered coatings, a high pressure manifold and 60 mesh filter is recommended. For convenience and better control, use a 3/8" to 1/2" I.D. material hose (4,000-5,000 psi working pressure rating). A Graco silver gun or XTR-7 gun for pressures greater than 5000 psi, or equivalent, may be used. The preferred tips with orifices ranging from .019" to .033" should be mounted in a Graco H.D. RAC Housing/Guard assembly. The suggested operating pressure should be between 3,500 psi and 4,500 psi at the gun.

BRUSH AND ROLLER APPLICATION EQUIPMENT

A high quality 3/8" - 1/2" shed resistant woven fabric roller cover and quality brushes are suggested (available through the Wooster Brush Co., Wooster, OH).

MIXING AND APPLICATION INSTRUCTIONS

MIXING

Using a variable speed drill with a PS "Jiffy" blade, slowly pre-mix the contents of 2 Parts A. While under agitation, add the contents of 1 Part B and mix for a minimum of two minutes. During the mixing process, about halfway through, scrape the sides of the container with a flexible spatula to ensure all of Parts A and B are blended together.

APPLICATION

Concrete: Apply the mixed material to the prepared surface at approximately 200 sq. ft. per gallon. Coverage will vary due to the profile of the concrete. Backrolling is required to ensure that the surface is thoroughly "wetted out" with the Series 201 Epoxoprime. For theoretical coverage rates, refer to the Series 201 Epoxoprime Product Data Sheet.

Steel: Immediately apply the mixed material evenly at a rate of about 400 sq. ft. per gallon. Do not allow to sag or curtain.

3.0 - INTERMEDIATE COATS

3.1 - SERIES 270 AND 275 STRANLOK

PACKAGING AND SUGGESTED COVERAGE

PACKAGING:

	PART A (PARTIALLY FILLED)	PART B (PARTIALLY FILLED)	YIELD (MIXED)
270			
Small	1 gallon can	1/2 gallon pail	1 gallon
Medium	3 1/2 gallon pail	1 gallon pail	2 1/2 gallons
Large	6 gallon pail	2 gallon pail	5 gallons

	PART A (PARTIALLY FILLED)	PART B (PARTIALLY FILLED)	YIELD (MIXED)
275			
Small	1 gallon can	1/2 gallon pail	1 gallon
Large	6 gallon pail	3 1/2 gallon pail	5 gallons

COVERAGE RATES:

KIT SIZE	SERIES 270 (25.0 - 40.0 MILS)	SERIES 275 (25.0 - 40.0 MILS)
Small	40 - 64	36 - 58
Medium	100 - 160	N/A
Large	200 - 320	180 - 290

If Series 270 or 275 Stranlok is spray-applied at 70° F or above, two coats (applied 30-60 minutes apart) are normally required to achieve the recommended mils outlined above without runs or sags. Should the temperature be below 70° F, more time should be allowed between passes.

NOTE: Mixed material for all the 200 Series products has a short pot life and should be ordered in kit sizes appropriate for the method of application to ensure the material can be applied within working times.

EQUIPMENT AND SUPPLIES

MIXING EQUIPMENT

Slow speed or variable speed (350 rpm or less) heavy duty (1/2" chuck or larger) electric or air driven drill fitted with a clean PS "Jiffy" mixing paddle.

SPRAY APPLICATION EQUIPMENT

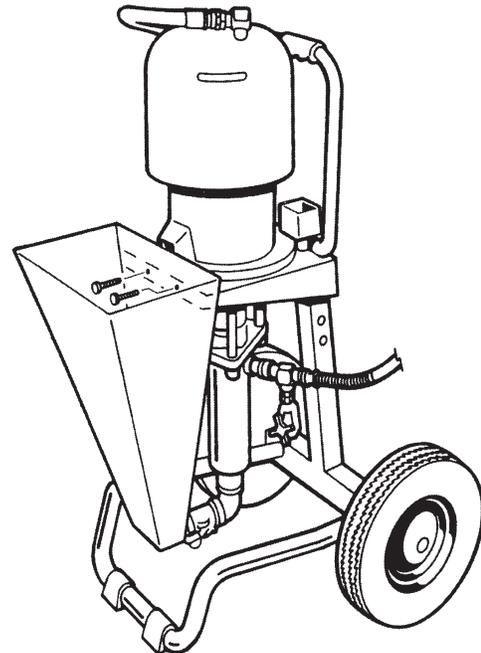
A Graco "King" 45:1, 56:1, X50 or X60 airless spray pump may be used. Pump assembly should include a moisture trap and oiler, air regulator with gauge and fluid outlet drain valve.

Use a 25-50 ft. 1/2" I.D. material hose (6,000 psi working pressure rating) fitted with a Graco Pistol Grip

Mastic Flo-Gun, Model 224-991. For convenience and better control, a three to six ft. 3/8" I.D. whip line and swivel may be attached between the gun and material hose. When more than 50 ft. of hose is necessary, an additional 25 ft. section of 3/4" I.D. material hose may be added between the pump and 1/2" I.D. material hose. Total length of material hose should not exceed 75 ft.

CAUTION: Use hoses that are compatible with strong solvents (cleanup). The suggested tips have orifices ranging from .045"-.055" for Series 270 or 275 Stranlok. The suggested tips should be mounted in a Graco H.D. RAC Housing/Guard Assembly. Fan width will be determined by jobsite conditions and applicator preference. The suggested operating pressure should be between 3,500 psi and 4,500 psi at the gun. A 150 CFM or greater compressor is needed, providing 100 psi through a 3/4" hose having no restrictions. No screens, filters or surge tanks should be used. The outlet hose is attached directly to the pump outlet without filter casing. The siphon hose must be removed so that the pump intake can be immersed directly into the fiber-reinforced product. Hopper attachments are highly recommended to feed pump by gravity (see Illustration I). Contact Themec Technical Services for more information at 1-800-TNEMEC1.

ILLUSTRATION I



A hopper attachment, available through Spray-Quip, Inc., Houston, TX, should be attached to the Graco "King" 45:1 or 56:1 to feed pump the fiber-reinforced epoxy by gravity.

TROWEL APPLICATION EQUIPMENT

An assortment of clean steel finishing trowels (type used for concrete) with 14"-16" maximum length. A mortar hawk or pan is also needed.

MISCELLANEOUS EQUIPMENT

- Brushes
- Grinders
- Duct tape
- Rollers
- Gloves
- Timers
- Brooms
- Squeegees
- Spatulas
- Rags
- Clean pails
- Pail scrapers
- Thermometers
- Broad knife
- Pole extensions
- Utility knife
- Personal Protective Equipment
- Assortment of finishing trowels
- Assortment of resin coated sanding discs

MIXING AND APPLICATION INSTRUCTIONS

MIXING

Using a variable speed drill with a PS "Jiffy" blade, slowly pre-mix the contents of Part A. Using a flexible blade spatula, empty the entire contents of Part B into the center of the pre-mixed Part A. Mix for a minimum of two minutes. Holding the mixing container tightly, be sure to mix the material thoroughly by working the drill around the bottom and sides. During the mixing process, about halfway through, scrape the sides of the container with a flexible spatula to ensure all of Parts A and B are blended together. Mixing must be complete and thorough or soft and/or wet streaks will be noticed in the applied system the next day.

APPLICATION

Best results are achieved by spray application—limit trowelling to hard-to-reach areas, sumps, trenches and secondary containment. However, only trained or experienced contractors should consider spray application.

SPRAY APPLICATION

Spray application of the fiber-reinforced products on vertical surfaces normally requires two passes, applied 30-60 minutes apart at 75° F to achieve the recommended film thickness. Cooler substrates will lengthen the time required between passes. For Series 270 and 275, two passes at approximately 15.0-20.0 mils each (totaling 25.0-40.0 mils) are suggested. For spray application on horizontal surfaces, the entire recommended film thickness can be achieved in a single pass.

CAUTION: Care should be taken to avoid applying too much material on each pass, as runs and sags will result.

NOTE: Series 270 and 275 should not be applied if the temperature of the material is under 70° F.

TROWELLING

When trowelling on horizontal surfaces, the entire recommended film thickness of 25.0-40.0 mils can be achieved in a single pass. Pour out the material in long thin lines across the floor in a pattern that will allow

uniform spreading at the recommended thickness.

For application on vertical or overhead surfaces, mix 1-1.5 quarts by volume of fumed silica per mixed gallon of material (refer to technical bulletin No. 98-11 R-2). Work the fiber-reinforced material from a mortar hawk or pan using standard plastering techniques.

NOTE: Adding fumed silica to the fiber-reinforced product is suggested to enhance the trowelability of the material.

After placing the fibered products on the surface, spread the material with a clean steel trowel to a uniform thickness of 25.0-40.0 mils. Work in small areas, taking care to install the material without severe trowel marks. The steel trowel is for spreading only. Do not overwork the material. In corners, crevices, coving and other places which cannot be spread effectively with a trowel, apply the material with a brush.

All of the material should be removed from the mixing container within 15 minutes after mixing.

IMPROVING THE APPEARANCE OF SPRAY OR TROWEL APPLIED MATERIAL

The following methods can be used to improve the surface profile and appearance of the fiber-reinforced epoxy coated surface. For best results, complete any surface corrections 30-60 minutes after application:

1. Using a trowel or broad knife, pull material upward in the affected area to smooth.
2. Lightly roll the surface in one direction with a stipple or short nap roller cover fitted to an extension handle as required. It may be necessary to dampen the roller in solvent to avoid "pulling" the material. Use one of the solvents suggested for cleanup and avoid soaking the roller or material surface.

POLE SANDING

Prior to topcoating, Series 270 and 275 should be pole sanded with 50 grit resin coated sandpaper to level off the tops of sharp fibers that may protrude through the surface. Sanding should be done after the Stranlok has cured approximately eight hours.

3.2 - SERIES 273 STRANLOK ML

PACKAGING AND SUGGESTED COVERAGE

PACKAGING:

273	PART A	PART B	YIELD (MIXED)
Small	2 1-gallon cans	1 1-gallon pail	3 gallons
Large	2 5-gallon pails	1 5-gallon pail	15 gallons

COVERAGE RATES:

KIT SIZE	BASE COAT (8.0 - 12.0 MILS)	SATURANT COAT (6.0 - 8.0 MILS)
Small	405 - 600	600 - 810
Large	2025 - 3000	3000 - 4050

NOTE: Mixed material for all the 200 Series products has a short pot life and should be ordered in kit sizes appropriate for the method of application to ensure the material can be applied within working times.

EQUIPMENT AND SUPPLIES

MIXING EQUIPMENT

Slow speed or variable speed (350 rpm or less) heavy duty ($\frac{1}{2}$ " chuck or larger) electric or air driven drill fitted with a clean PS "Jiffy" mixing paddle.

SPRAY APPLICATION EQUIPMENT

A Graco "King" 45:1, 56:1, X50 or X60 airless spray pump may be used. Pump assembly should include a moisture trap and oiler, air regulator with gauge and fluid outlet drain valve. When spraying this non-fibered coating, a high pressure manifold and 60 mesh filter is recommended. For convenience and better control, use a $\frac{3}{8}$ " to $\frac{1}{2}$ " I.D. material hose (4,000-5,000 psi working pressure rating). A Graco silver gun or XTR-7 gun for pressures greater than 5000 psi, or equivalent, may be used. The preferred tips with orifices ranging from .019" to .033" should be mounted in a Graco H.D. RAC Housing/Guard assembly. The suggested operating pressure should be between 3,500 psi and 4,500 psi at the gun.

NOTE: Backrolling of saturant coat over the placed reinforcing mat is required to ensure the mat is embedded in the base coat and fully "wet-out".

ROLLER APPLICATION EQUIPMENT

A high quality $\frac{3}{8}$ " or $\frac{1}{2}$ " shed resistant woven fabric roller cover is suggested (available through the Wooster Brush Co., Wooster, OH).

FILLING AND RESURFACING

Before applying the Series 273 basecoat to either CMU or concrete, all surface voids and joints must be filled and leveled smooth with either Series 218 MortarClad, Series 215 Surfacing Epoxy or Series 201 Epoxoprime mixed with Series 211 fumed silica. (Reference 2.0)

An alternative, labor-saving method when addressing CMU is to apply Series 215 Surfacing Epoxy as a parge coat at a thickness of $\frac{1}{32}$ " - $\frac{1}{8}$ ". This should completely smooth and level the CMU surface while at the same time create a bedding coat for placement of the Series 273 glass directly into the wet Series 215.

MIXING AND APPLICATION INSTRUCTIONS

MIXING

Using a variable speed drill with PS "Jiffy" blade, slowly pre-mix the contents of Part A. While under agitation, add the contents of Part B and mix for a minimum of two minutes. During the mixing process, about halfway through, scrape the sides of the container with a flexible spatula to ensure all of Parts A and B are blended together.

APPLICATION

The Series 273 Part "C" fiberglass reinforcing mat is available in 3' x 180' rolls. Using a utility knife, cut the mat to fit the area to be covered. Apply 8.0-12.0 wet mils of Series 273 liquid to the area and immediately place pre-cut glass mat on the liquids. Apply an additional 6.0-8.0 wet mils of liquids immediately over placed mat using a $\frac{3}{8}$ " - $\frac{1}{2}$ " nap roller. Completely "wet-out" and smooth the glass mat, making sure air pockets do not form beneath the mat.

NOTE: Brush application of liquids at the top, bottom and corners of the surface may be required before mat application.

NOTE: When forming a seam with two pieces of glass mat, "butt-joint" or overlap $\frac{1}{2}$ " and double cut the mat similar to wallpapering. It may be necessary, when double cutting, to roller apply additional liquids in joint area.

4.0 - TOPCOATS

RECOMMENDED TOPCOATS

The fiber-reinforced systems require topcoats for finish uniformity, cleanability and chemical resistance.

FIBER-REINFORCED PRODUCT	TOPCOAT
Series 270	Series 280 ¹
Series 273	Series 280 ¹
Series 275	Series 282

¹ Additional topcoats are available for added color and gloss. Please contact your Tnemec representative.

TOPCOATING THE SERIES 270, 273 & 275 STRANLOK SYSTEMS

Apply the recommended Tneme-Glaze topcoat at least eight hours but not more than 24 hours after the Stranlok application.

NOTE: If these intercoat times are exceeded, the surface must be mechanically abraded before proceeding. Call Tnemec Technical Services for details at 1-800-TNEMEC1.

4.1 - SERIES 280 AND 282 TNEME-GLAZE

PACKAGING AND SUGGESTED COVERAGE

PACKAGING:

	PART A	PART B	YIELD MIXED
280			
Small	2 1-gallon cans	1 gallon pail	3 gallons
Large	2 5-gallon pails	5 gallon pail	15 gallons

	PART A	PART B	YIELD MIXED
282			
Small	1 gallon can	1 gallon pail	2 gallons
Large	5 gallon pail	5 gallon pail	10 gallons

COVERAGE RATES:

KIT SIZE	SERIES 280 (6.0 - 8.0 MILS)	SERIES 282 (6.0 - 8.0 MILS)
Small	600 - 800	400 - 535
Large	3000 - 4005	2000 - 2670

NOTE: Mixed material for all the 200 Series products has a short pot life and should be ordered in kit sizes appropriate for the method of application to ensure the material can be applied within working times.

EQUIPMENT AND SUPPLIES

MIXING EQUIPMENT

Slow speed or variable speed (350 rpm or less) heavy duty ($\frac{1}{2}$ " chuck or larger) electric or air driven drill fitted with a clean PS "Jiffy" mixing paddle.

SPRAY APPLICATION EQUIPMENT

A Graco "King" 45:1, 56:1, X50 or X60 airless spray pump may be used. Pump assembly should include a moisture trap and oiler, air regulator with gauge and fluid outlet drain valve. When spraying these non-fibered coatings, a high pressure manifold and 60 mesh filter is recommended. For convenience and better control, use a $\frac{3}{8}$ "- $\frac{1}{2}$ " I.D. material hose (4,000-5,000 psi working pressure rating). A Graco silver gun or XTR-7 gun for pressures greater than 5000 psi, or equivalent, may be used. The preferred tips with orifices ranging from .019" to .033" should be mounted in a Graco H.D. RAC Housing/Guard assembly. The suggested operating pressure should be between 3,500 psi and 4,500 psi at the gun.

BRUSH AND ROLLER APPLICATION EQUIPMENT

A high quality $\frac{3}{8}$ "- $\frac{1}{2}$ " shed resistant woven fabric roller cover and quality brushes are suggested (available through the Wooster Brush Co., Wooster, OH).

MIXING AND APPLICATION INSTRUCTIONS

MIXING

Using a variable speed drill with PS "Jiffy" blade, slowly pre-mix the contents of two Parts A. While under agitation, add the contents of one Part B and mix for a minimum of two minutes. During the mixing process, about halfway through, scrape the sides of the container with a flexible spatula to ensure all of Parts A and B are blended together.

APPLICATION

Apply Series 280 and 282 after the Stranlok has cured eight to 24 hours. If more than 24 hours have elapsed, it is mandatory that the Stranlok coated surface be thoroughly mechanically abraded before being topcoated with Tneme-Glaze.

Apply the mixed material to the Stranlok coated surface, spreading to a uniform thickness of 6.0-8.0 mils. If spray-applied, usually one coat of Tneme-Glaze is needed. Roller or brush application may require an additional coat. If a second application of Tneme-Glaze is desired, recoat after eight hours and before 24 hours. If more than 24 hours have elapsed, the surface must be thoroughly mechanically abraded before applying an additional coat. Allow to cure for 24 hours before placing into service.

T N E M E C C O M P A N Y I N C O R P O R A T E D

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