



EPOXOLINE SERIES 142

PRODUCT PROFILE

GENERIC DESCRIPTION Modified Polyamine Epoxy

COMMON USAGE Abrasion resistant, high solids, <100 g/L VOC epoxy coating which offers high-build edge protection and excellent corrosion resistance. Contains micro-fiber reinforcement for improved film integrity. For use on the interior and exterior of steel or concrete tanks, pipes, and other heavy-duty equipment in industrial service.

COLORS 1255 Beige, 33GR Gray, and WH14 Off-White. **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. **Caution: Resin properties contribute to color variations or inconsistencies. Contact your Tnemec representative for more information.**

PERFORMANCE CRITERIA Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

SURFACER/FILLER/PATCHER Series 215, 217, 218

PRIMERS **Steel:** Self-priming, 1, 27, 37H, L69, L69F, N69, N69F, V69, V69F, 90E-92, 90G-1K97, 90-97, H90-97, 90-98, 94-H₂O, 135, 394, 530
Concrete: Self-priming, 27, L69, L69F, N69, N69F, V69, V69F
CMU: Self-priming or Series 130, 1254

TOPCOATS **Exterior:** Series 73, 180, 290, 1028, 1029, 1074, 1074U, 1075, 1075U, 1080, 1081. **Note:** The following maximum recoat time applies when using Series 73, 180, 290, 1074, 1074U, 1075, 1075U, 1080 or 1081: fourteen (14) days. If this time limit is exceeded, Series 142 must be uniformly scarified prior to topcoating.

SURFACE PREPARATION

PRIMED STEEL **Immersion Service:** Scarify the Series L69, L69F, N69, N69F, V69 or V69F prime coat surface by brush-blasting with fine abrasive before topcoating if it has been exterior exposed for 30 days or longer and 142 is the specified topcoat.

STEEL **Immersion Service:** SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum angular anchor profile of 2.0 mils
Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 2.0 mils

CONCRETE Allow new cast-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness and prepare concrete surfaces in accordance with NACE 6/SSPC-SP13 Joint Surface Preparation Standards and ICRI Technical Guidelines. Moisture vapor transmission should not exceed three lbs per 1,000 sq ft in a 24 hour period (Reference ASTM F 1869 "Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride"). Relative humidity should not exceed 80% (Reference ASTM F 2170 "Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes"). 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 3 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.

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

TECHNICAL DATA

VOLUME SOLIDS 82% ± 2.0% (mixed) †

RECOMMENDED DFT 8.0 to 18.0 mils (205 to 455 microns) in one coat. **Note:** Thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME	Temperature	To Handle	To Topcoat	Immersion
	75°F (24°C)	6 hours	9 hours	7 days
	35°F (0°C)	64 hours	72 hours	30 days

Curing time varies with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS EPA Method 24
Unthinned: 0.52 lbs/gallon (63 grams/litre)
Thinned 4% (No. 4 Thinner): 0.75 lbs/gallon (90 grams/litre) †

HAPS **Unthinned:** 1.3 lbs/gal solids
Thinned 4% (No. 4 Thinner): 1.5 lbs/gal solids

THEORETICAL COVERAGE 1,315 mil sq ft/gal (32.2 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS Two: Part A (amine) and Part B (epoxy)

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

PACKAGING	PART A (Partially Filled)	PART B (Partially Filled)	When Mixed
Large Kit	1-3 gallon pail	1-5 gallon pail	4 gallons
Small Kit	1-1 gallon can	1-1 half gallon can	1 gallon

NET WEIGHT PER GALLON 14.63 ± 0.25 lbs (6.65 ± .11 kg) †

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)
 Prior to application, the material temperature should be above 60°F (16°C). It is suggested the material be stored at this temperature at least 48 hours prior to use.

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: 94°F (34°C) Part B: 111°F (44°C)

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HEALTH & SAFETY

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.
Keep out of the reach of children.

APPLICATION

COVERAGE RATES

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Minimum	8.0 (205)	10.0 (255)	164 (15.3)
Maximum	18.0 (455)	22.0 (560)	73 (6.8)

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 thicknesses may adversely affect coating performance. †

MIXING

Mix the entire contents of Part A and Part B separately. Scrape all of the Part A into the Part B pail by using a flexible spatula. While under agitation use a variable speed drill with a PS Jiffy blade and mix the blended components for a minimum of three minutes. During mixing, scrape the container walls to aid in complete blending of the two components. Apply the mixed material within pot life limits after agitation. Both components must be above 50°F (10°C) prior to mixing. For optimum application properties, the material temperature should be above 60°F (16°C). For applications to surfaces between 40°F to 50°F (4°C to 10°C) allow mixed material to stand 30 minutes and restir before use. **Note:** A large volume of material will set up quickly if not applied or lessened in mass. **Caution: Do not reseal mixed material. An explosion hazard may be created.**

THINNING

Caution: Do not add thinner to Part A prior to mixing with Part B. Use No. 4 Thinner. For airless spray, roller or brush, thin up to 4% per gallon. For air spray, thin up to 10% per gallon. To comply with SCAQMD VOC regulations, maximum thinning is 4%.

POT LIFE

2 hours at 77°F (21°C) 1 hour at 90°F (32°C)

SPRAY LIFE

1 hour at 77°F (21°C) 30 minutes at 90°F (32°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)	75-100 psi (5.2-6.9 bar)	25-35 psi (1.7-2.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.017"-0.021" (430-535 microns)	3400-3800 psi (234-262 bar)	3/8" (9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Roller application optional when environmental restrictions do not allow spraying. Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic woven nap covers.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Minimum 35°F (2°C) Maximum 135°F (57°C)
 The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.
 † Values may vary with color.

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