

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamidoamine Epoxy
COMMON USAGE	Innovative potable water coating which offers high-build edge protection and allows for application at a wide range of temperatures (down to 35°F or 2°C with 44-700 Accelerator). For use on the interior and exterior of steel or concrete tanks, reservoirs, pipes, valves, pumps and equipment in potable water service.
COLORS	1211 Red, 1255 Beige, 00WH Tnemec White, 15BL Tank White, 35GR Black and 39BL Delft Blue. 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.
SPECIAL QUALIFICATIONS	Certified by NSF International in accordance with ANSI/NSF Std. 61. Series N140 manufactured by Tnemec Company in Kansas City, Missouri or Baltimore, Maryland; ambient air cured (with or without 44-700 Epoxy Accelerator) is qualified for use on tanks and reservoirs of 1,000 gallons (3,785 L) capacity or greater, pipes 18 inches (46 cm) in diameter or greater, valves four (4) inches (10 cm) in diameter or greater and fittings four (4) inches (10 cm) in diameter or greater. Series N140 manufactured by Tnemec Coatings in Shanghai, China; ambient air cured (with or without 44-700 Epoxy Accelerator) is qualified for use on pipes 18 inches (46 cm) in diameter or greater, valves four (4) inches (10 cm) in diameter or greater and fittings four (4) inches (10 cm) in diameter or greater.
	Certified by NSF International in accordance with NSF/ANSI/CAN Std. 61 and the extraction requirements of NSF/ANSI/CAN 600 for use as a primer or intermediate coat with any Tnemec NSF certified primer and topcoat coating system provided the primer, intermediate and topcoat meet their certified end uses. Series N140 is qualified for use on tanks and reservoirs of 500 gallons (1892 L) capacity or greater. Reference Tnemec's certified product listing at www.nsf.org for details on the maximum allowable DFT.
	Conforms to AWWA D102 Inside Systems No. 1 and No. 2 (with or without 44-700). Conforms to AWWA C210 (without 44-700). Contact your Tnemec representative for systems and additional information.
	A two-coat and three-coat system of Series N140 meets the requirements of AWWA C550 Protective Interior Coatings for Valves and Hydrants.
COATING SYSTEM	
SURFACER/FILLER/PATCHER	Series 215, 217, 218
PRIMERS	Self-priming, Series 22, 91-H ₂ O, 94-H ₂ O, L140, L140F, N140F, V140, V140F, 141
TOPCOATS	Interior: Series 22, FC22, L140, L140F, N140, N140F, V140, V140F, 141, 264, 265, 406. Exterior: Series 22, 27, 27WB, 30, 66, L69, L69F, N69, N69F, V69, V69F, 72, 73, 118, L140, L140F, N140, N140F, V140, V140F, 141, 156, 157, 161, 180, 181, 446, 700, V700, 701, V701, 740, 750, 1026, 1028, 1029, 1074, 1074U, 1075, 1075U, 1077, 1078, 1078V, 1080, 1081, 1094, 1095, 1096, 1224. Note: When topcoating with Series 700, V700, 701 or V701, an intermediate coat of Series 73, 1075, 1075U, 1095 or 1096 is required. Note: The following recoat times apply for Series N140. Immersion Service—Surface must be scarified by blasting with fine abrasive after 60 days. Atmospheric Service—After 60 days, scarification or an epoxy tie-coat is required. When topcoating with Series 740 or 750, recoat time for N140 is 21 days. Note: When topcoating with Series 406, recoat times will vary with temperature. Reference the Series 406 product data sheet for specific recoat times. Contact your Tnemec representative for specific recommendations.
SURFACE PREPARATION	

STEEL	Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. Note: Commercial Blast Cleaning generally produces the best coating performance for this exposure. If conditions will not permit this, in moderate exposures Series N140 may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).
CAST/DUCTILE IRON	All external surfaces of ductile iron pipe and fittings shall be delivered to the application facility without asphalt or any other protective lining on the exterior surface. All oils, small deposits of asphalt paint, grease, and soluble deposits should be removed and uniformly abrasive blasted using angular abrasive in accordance with NAPF 500-03-04: External Pipe Surface condition. When viewed without magnification, the exterior surfaces shall be free of all visible dirt, dust, loose annealing oxide, rust, mold coating and other foreign matter. Any area where rust reappears before application shall be reblasted. The surface shall contain a minimum angular anchor profile of 1.5 mils (38.1 microns) (Reference NACE RP0287 or ASTM D 4417, Method C).
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 in situ Probes" (relative humidity should not exceed 80%), or D 4263 "Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet 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 an ICRI-CSP 2-3 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.
PRIMED SURFACES	Immersion Service: Scarify the Series N140 prime coat by brush-blasting with fine abrasive before topcoating if: (a) the Series N140 prime coat has been in exterior exposure for 60 days or longer and Series 66, L69, L69F, N69, N69F, V69, V69F, L140, L140F, N140, N140F, V140, V140F or 161 is the specified topcoat; (b) the Series N140 prime coat has been in exterior exposure for 7 days or longer and Series 264 or 265 is the specified topcoat.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

POTA-POX® PLUS | SERIES N140

VOLUME SOLIDS						
	$67.0 \pm 2.0\%$ (mixed—A, B & 4	4-700 Epoxy Accelerator) †				
RECOMMENDED DFT	2.0 to 10.0 mils (50 to 225 mic compliance with SSPC PA-2 ar requirements will vary with su	rons) per coat. Note: Dry film t ad ANSI/NSF Std. 61 certification abstrate, application method and	hickness that exceeds publishe ns, is acceptable. Note: The nu l exposure. Contact your Tneme	d recommendations but is mber of coats and thickness ec representative.		
URING TIME AT 5 MILS DFT	Without 44-700 Accelerator:		1 ,	1		
	Temperature	To Handle	To Recoat	Immersion		
	90°F (32°C)	5 hours	7 hours	7 days		
	80°F (27°C)	7 hours	9 hours	7 days		
	70°F (21°C)	9 hours	12 hours	7 days		
	60°F (16°C)	16 hours	22 hours	9 to 12 days		
	50°F (10°C)	24 hours	32 hours	12 to 14 days		
LE ORGANIC COMPOUNDS	Curing time varies with surface Pipes, valves and fittings: A mils (610 microns) DFT when product listing on www.nsf.org enclosed areas, provide adequ applications, add No. 44-700 E Unthinned: 2.4 lbs/gallon (28	e temperature, air movement, hr A minimum of 30 days cure at 75 cured for 120 days prior to imm g for specific potable water retu late ventilation during applicatic Epoxy Accelerator, see separate 35 grams/litre)	umidity and film thickness. 5°F (24°C) is required. Series N hersion (Kansas City manufactu rn to service information. Vent on and cure. Note: For faster cu product data sheet for cure info	140 may be applied up to red material). Refer to tilation: When used in ring and low temperature ormation.		
	Thinned 5% (#60): 2.6 lbs/ga Thinned 10% (#4): 2.8 lbs/ga	allon (311 grams/litre) allon (334 grams/litre) †				
HAPS	Unthinned: 2.4 lbs/gal solids	Thinned 5% (#60): 2.4 lbs/	gal solids			
THEODETICAL COVEDAGE	1 070 mil sa ft/aal (27.2 m ² /L	at solids	IN for coverage rates +			
	True Dart A (amine) and Dart	R (aparti) Opa (Dart A) to at	(Dart P) by volume			
	Two: Part A (annue) and Part	B (epoxy) — One (Part A) to of	Bert B	Viold (minod)		
rackaoino	Large Kit	5 gallon pail	5 gallon pail	10 callons (37.9.1)		
	Small Kit	1 gallon can) gallon pair	2 gallons (7.6 L)		
	Reference 4/ 700 Epoyy Accel	erator product data sheet for its	packaging information	2 galiolis (7.0 L)		
NET WEICHT DED CALLON	12.66 ± 0.25 lbs (5.82 ± 0.11 k	a) (mixed) +	packaging information.			
ALI WLIDIII I LK DALLUM	12.66 ± 0.25 lbs (5.82 ± 0.11 kg) (mixed) †					
	Minimum 200E (70C) Marrier	g, (initial)				
STORAGE TEMPERATURE	Minimum 20°F (-7°C) Maxim	um 110°F (43°C)				
STORAGE TEMPERATURE TEMPERATURE RESISTANCE	Minimum 20°F (-7°C) Maxim (Dry) Continuous 250°F (121°C)	um 110°F (43°C) C) Intermittent 275°F (135°C)				
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STORAGE TEMPERATURE TEMPERATURE RESISTANCE SHELF LIFE FLASH POINT - SETA	Minimum 20°F (-7°C) Maxim (Dry) Continuous 250°F (121°C) Part A: 24 months; Part B: 12 r Part A: 82°F (28°C) Part B:	um 110°F (43°C) C) Intermittent 275°F (135°C) nonths at recommended storage 80°F (27°C) 44-700: None	e temperature.			
STORAGE TEMPERATURE TEMPERATURE RESISTANCE SHELF LIFE FLASH POINT - SETA HEALTH & SAFETY	Minimum 20°F (-7°C) Maxim (Dry) Continuous 250°F (121°C) Part A: 24 months; Part B: 12 r Part A: 82°F (28°C) Part B: Paint products contain chemic	um 110°F (43°C) C) Intermittent 275°F (135°C) nonths at recommended storage 80°F (27°C) 44-700: None al ingredients which are conside	e temperature. ered hazardous. Read container	r label warning and Materi		
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STORAGE TEMPERATURE EMPERATURE RESISTANCE SHELF LIFE FLASH POINT - SETA HEALTH & SAFETY LICATION COVERAGE RATES	Minimum 20°F (-7°C) Maxim (Dry) Continuous 250°F (121°C Part A: 24 months; Part B: 12 r Part A: 82°F (28°C) Part B: Paint products contain chemic Safety Data Sheet for importan Keep out of reach of childre	um 110°F (43°C) C) Intermittent 275°F (135°C) nonths at recommended storage 80°F (27°C) 44-700: None al ingredients which are conside thealth and safety information en. Dry Mils (Microns)	e temperature. ered hazardous. Read container prior to the use of this product Wet Mils (Microns)	r label warning and Materi Sq Ft/Gal (m²/Gal)		
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STORAGE TEMPERATURE EMPERATURE RESISTANCE SHELF LIFE FLASH POINT - SETA HEALTH & SAFETY ICATION COVERAGE RATES MIXING THINNING	Minimum 20°F (-7°C) Maxim (Dry) Continuous 250°F (121°C Part A: 24 months; Part B: 12 r Part A: 82°F (28°C) Part B: Paint products contain chemic Safety Data Sheet for importan Keep out of reach of childre Suggested Minimum Maximum Note: Roller or brush applicat and surface irregularities. Wet minimum or above maximum the NSF website at www.nsf.o Start with equal amounts of Se pigment remains on the bottor components. If Series 44-700 is under agitation. Continue agit above 50°F (10°C) prior to mis (16°C). If using Series 44-700 accelerat while under agitation and proo will adversely affect performar Thin by volume and thorough affect product's gloss and perf unaccelerated version to surfar 35°F to 50°F (2°C to 10°C), all. Use No. 4 or No. 60 Thinner. 1 to 5% or 1/4 pint (190 mL) per (190 mL) per gallon. Caution: for tanks and only No. 60 T certification.	um 110°F (43°C) C) Intermittent 275°F (135°C) nonths at recommended storage 80°F (27°C) 44-700: None al ingredients which are conside thealth and safety information en. Dry Mils (Microns) 6.0 (150) 2.0 (50) 10.0 (225) ion requires two or more coats film thickness is rounded to the recommended dry film thicknes rg for details on the maximum a rg for details on the maximum a sn ob being used, proceed with ation until the two components king. For optimum mixing and a tor, slowly add four (4) fluid ou ceed with adding Part B. Note: nce. ly mix. Failure to thoroughly mi ormance. Do not use mixed ma ces between 50°F to 60°F (10°C ow mixed material to stand 30 r For air spray, thin up to 10% or Series N140 NSF certificatio Chinner for pipe, valves and f	e temperature. ered hazardous. Read container prior to the use of this product 9.0 (230) 3.0 (75) 15.0 (375) to obtain recommended film the earerst 0.5 mil or 5 microns. J sees may adversely affect coatir allowable DFT. † • mix contents of each container la mixing and add an equal volur are thoroughly mixed. Note: B upplication properties, the mate nces of 44-700 per gallon to See The use of more than the recording the second the seco	sq Ft/Gal (m²/Gal) 179 (16.6) 537 (49.9) 107 (10.0) ickness. Allow for oversp Application of coating beld g performance. Reference r separately, making sure rge enough to hold both ne of Part A to Part B whi toth components must be trial should be above 60°F eries N140 Part A material mmended amount of 44-7 nents prior to thinning can ote: For application of the sion to surfaces between the No. 4 Thinner or thin thin up to 5% or 1/4 pint No. 4 or No. 60 Thinne the voids ANSI/NSF Std. 6		

PRODUCT DATA SHEET

POTA-POX® PLUS | SERIES N140

SPRAY LIFE

Without 44-700: 1 hour at 77°F (25°C) With 44-700: 30 minutes at 75°F (24°C)

Note: Spray application after listed times will adversely affect ability to achieve recommended dry film thickness.

APPLICATION EQUIPMENT

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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)	50-80 psi (3.4-5.5 bar)	10-20 psi (0.7-1.4 bar)

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019"	3000-4800 psi	1/4" or 3/8"	60 mesh
(380-485 microns)	(207-330 bar)	(6.4 or 9.5 mm)	(250 microns)

Low temperatures or longer hoses require higher pot pressure. Use appropriate tip/atomizing pressure for equipment, **Roller:** Use 3/8" or 1/2" (9.5 mm to 12.7 mm) synthetic woven nap roller cover. Use longer nap to obtain penetration on

rough or porous surfaces.

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

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

Without 44-700: Min. 50°F (10°C), Max. 135°F (57°C) With 44-700: Min. 35°F (2°C), Max. 135°F (57°C) The surface should be dry and at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature.

CLEANUP

† Values may vary with color.

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