



SURFACE PREPARATION AND APPLICATION GUIDE

**SERIES 1415 VINESTER
60-MIL BROADCAST SYSTEM (HORIZONTAL)
30-MIL MORTAR SYSTEM (VERTICAL)**

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Published technical data, instructions, and pricing are subject to change without notice. Contact your Tnemec technical representative for current technical data, instructions, and pricing. Warranty information: The service life of Tnemec's coatings will vary. For warranty, limitation of seller's liability, and product information, please refer to Tnemec's Product Data Sheets at www.tnemec.com or contact your Tnemec Technical Representative. 09/2020

TABLE OF CONTENTS

Introduction.....	1
Product Overview.....	1
Job Set-Up.....	1
Surface Preparation.....	1
Primer Installation.....	2
Basecoat Installation - Horizontal.....	2-3
Wall Installation - Vertical.....	3
Topcoat Installation.....	3-4
Inspection.....	4
Final Curing Time.....	4
Safety.....	4

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1.0 INTRODUCTION

The purpose of this guide is to acquaint applicators with the basic information necessary for properly ordering, storing and installing Tnemec's 60 Mil Vinester Broadcast System. Prior to starting work, please read this entire guide carefully. If you have questions, contact your Tnemec representative or call +1-816-483-3400. It is important that you obtain answers to any questions before work begins.

Also, reference the project specifications and compare them with this guide and the product data sheet. Resolve any inconsistencies prior to starting work.

This application guide cannot cover every issue that may be encountered in the field. If issues arise that are not addressed in this guide or the product data sheet, please contact your Tnemec representative or call 1-816-483-3400 for assistance.

2.0 PRODUCT OVERVIEW

The following contains information on the core components of the products used in this system.

2.1 SERIES 1415 SYSTEM

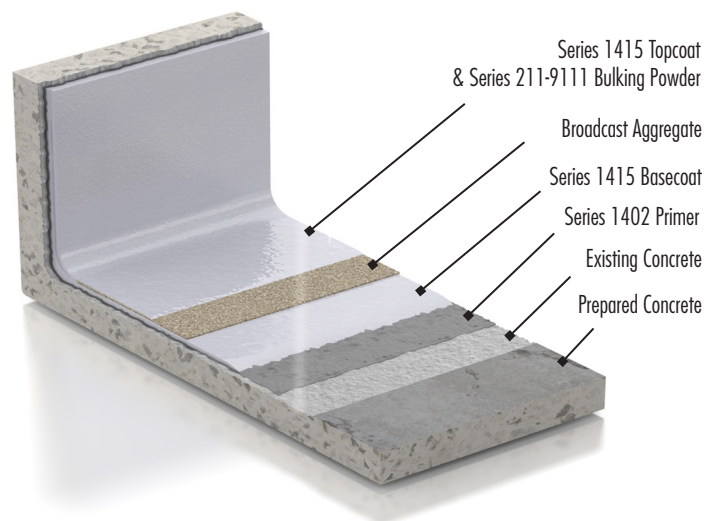
Series 1415 Vinester Broadcast System is trowel or squeegee-applied. The system results in a nominal or no less than 60 mils dry film thickness (DFT) when applied on horizontal surfaces and 30 mils when applied on vertical surfaces.

Series 1415 is a versatile selection for many secondary containment and process floors, best for caustic and high-pH applications, and when used as the base material for silica-free systems. Optionally, the system may be trowel-applied by replacing the broadcast aggregate with an appropriate Tnemec Bulking Powder, such as Series 211-9111, 211-9215 or 211-9106.

2.2 MATERIAL OVERVIEW

- Primer: Series 1402 ProPolymer
- Basecoat & Mortar Coat: Series 1415-900 Vinester
- Aggregate/Broadcast: 20/40 Sand (typically)
- Bulking Additive (mortar): Series 211-9111 Bulking Powder
- Topcoat: Series 1415-900 Vinester with 1400 Color Pack

2.3 SYSTEM OVERVIEW



3.0 JOB SET-UP

Prior to starting installation, please note the following:

- Itemize all materials ordered from Tnemec.
- Establish surface preparation requirements.
- Ensure all equipment is readily available and in working order.
- Set-up a mixing area clearly designated at least 50 feet away from heat, sparks, open flame, welding, or other sources of ignition.
- Communicate the installation, safety procedures, and requirements with all persons involved.

4.0 SURFACE PREPARATION

4.1 PREPARATION OF 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 a minimum ICRI-CSP 5 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.

4.2 PREPARATION OF STEEL

Immersion Service/Severe Exposure/Elevated Temperatures: SSPC SP5/ NACE No.1 White Metal Blast Cleaning or ISO Sa3 Blast Cleaning to Visually Clean with a minimum angular anchor profile of 3.0 mils (75 microns) is required.

Non-Immersion Service:

SSPC SP10/NACE No. 2 Near White Metal Blast Cleaning or ISO Sa 2 ½ Very Thorough Blast Cleaning with a minimum angular anchor profile of 3.0 mils (75 microns) is required.

4.3 MISCELLANEOUS METALS

Any miscellaneous metals or pipe penetrations scheduled to receive the coating system should be properly prepared in accordance with SSPC-SP10/NACE No. 2 Near-White Metal Blast Cleaning or SSPC-SP16 Brush-off Blast Cleaning of Non-Ferrous Metals, minimum 3.0 mils (75 microns) angular anchor profile.

4.4 TERMINATIONS

When the coating system is not scheduled to provide a monolithic surface, terminations must be built into the system. Examples include leading-edge sawcut terminations or overlapping onto pipes or other miscellaneous metals. Consult your Tnemec Representative for more information.

5.0 PRIMER INSTALLATION

5.1 SERIES 1402

The recommended primer for Series 1415 Vinester Broadcast System is Series 1402 ProPolymer, an elevated temperature vinyl ester coating. Contact Tnemec Technical Services to discuss alternate primers.

5.2 SERIES 1402 CURING TIME

TEMPERATURE	IMMERSION SERVICE	MIN. RECOAT	MAX. RECOAT
90°F (32°C)	24 Hours	2 Hours	24 Hours
70°F (21°C)	24 Hours	2 Hours	24 Hours

Note: If more than 24 hours has elapsed between coats, Series 1402 surface must be mechanically abraded before topcoating.

5.3 SERIES 1402 PACKAGING

KIT SIZE	PART A	PART B	YIELD (MIXED)
Medium	5 gallon pail	Pint bottle	5 gallons (18.9 L)
Small	1 gallon can	4 oz bottle	1 gallons (3.7 L)

5.4 SERIES 1402 COVERAGE RATES

DRY MILS (MICRONS)	SQ. FT./GAL (M ² /GAL)
2.0 - 6.0 (50 - 152)	682 - 227 (63 - 21)

5.5 SERIES 1402 MIXING

Power mix contents of Part A (base) thoroughly, making sure no pigment remains on the bottom of the can. Add Series 1402 Part B (catalyst) slowly to the Part A while under agitation. Ensure that all Part B is blended with Part A by scraping the pail walls with a flexible spatula. Continue to agitate until thoroughly mixed. Care should be exercised so as not to entrap air in the mixed material. Do not use mixed material beyond pot life limits.

5.6 SERIES 1402 THINNING

Do not thin.

5.7 SERIES 1402 SPRAY LIFE & POT LIFE

TEMPERATURE	SPRAY LIFE	POT LIFE
75°F (24°C)	25 Minutes	30 minutes

Note: At higher temperatures, pot life will decrease (use caution in spray equipment). In hot weather, material should be cooled to 65°F to 80°F (18°C to 27°C) prior to mixing and application to improve workability and avoid shortened pot life.

5.8 SERIES 1402 MATERIAL & STORAGE TEMPERATURE

Minimum storage temperature is 40°F (4°C) and maximum is 80°F (26°C). Prior to application, the material temperature should be between 60°F and 90°F (16°C and 32°C). It is suggested the material be stored at this temperature at least 48 hours prior to use.

Temperatures will affect workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

5.9 SERIES 1402 EQUIPMENT

Roller: Use 1/4" or 3/8" (6.5 mm to 9.5 mm) synthetic woven nap roller cover.

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

5.10 SERIES 1402 SURFACE TEMPERATURE

Minimum surface temperature is 60°F (16°C) and maximum is 90°F (32°C). The surface should be dry and at least 5°F (3°C) above the dew point. Coating will not cure below the minimum surface temperature.

5.11 SERIES 1402 CLEANUP

Clean and purge lines immediately after use with MEK.

6.0 BASECOAT INSTALLATION - HORIZONTAL

6.1 SERIES 1415 VINESTER

The base coat for Series 1415 Vinester Broadcast System is Series 1415 Vinester, an epoxy vinyl ester lining.

Reference the following charts for Series 1415 compositional specifics. Contact your Tnemec Representative with any additional questions.

6.2 SERIES 1415 VINESTER CURING TIME

TEMPERATURE	TO RECOAT	IMMERSION	MAXIMUM RECOAT†
90°F (32°C)	3 Hours	20 Hours	3 Days
75°F (24°C)	4 Hours	24 Hours	4 Days
50°F (10°C)	12 Hours	4 Days	5 Days

† **Note:** Certain service applications may require elevated temperature and/or longer cure times for placing in service.

6.3 SERIES 1415 PACKAGING

KIT SIZE	PART A (PARTIALLY FILLED)	PART B (PARTIALLY FILLED)	YIELD (MIXED)
Medium	5 gallon pail	Pint bottle	4.76 gallons (18 L)
Small	1 gallon can	4 oz bottle	0.95 gallons (3.6 L)

6.4 SERIES 1415 COVERAGE RATES

Saturant

DRY MILS (MICRONS)	SQ. FT./GAL (M ² /GAL)	SERIES 1400 COLORANTS	BULKING ADDITIVES*
20.0 (510)	68 - 340 (6.3 - 31.6)	N/A	N/A

Pigmented

DRY MILS (MICRONS)	SQ. FT./GAL (M ² /GAL)	SERIES 1400 COLORANTS	BULKING ADDITIVES*
20.0 (510)	68 - 340 (6.3 - 31.6)	Half Pint - Quart	See 1415 Product Data Sheet for information

Mortar

DRY MILS (MICRONS)	SQ. FT./GAL (M ² /GAL)	SERIES 1400 COLORANTS	BULKING ADDITIVES*
50.0 (1270)	49 - 250 (4.6 - 23.2)	Half Pint - Quart	1 bag - 2 bags

*Bulking additives: Series 211-9106, 211-9111 or 211-9215.

6.5 SERIES 1415 VINESTER MIXING

The basecoat is generally applied in Clear. If desired a Series 1400 Color Pack may be added to the Part A to have a pigmented basecoat. If used, Series 1400 Color Pack shall be added and fully mixed into Series 1415 Part A until a uniform color is achieved. Series 1402 Part B is then blended into the Part A.

6.6 SERIES 1415 VINESTER BASECOAT APPLICATION

The catalyzed Series 1415 should be immediately transferred to the surface and spread using a flat squeegee or roller to level the topping to 25 to 30 mils wet film thickness (WFT) for a coverage rate of 45-55 square feet per gallon.

6.7 SERIES 1415 VINESTER BROADCAST APPLICATION

Immediately broadcast selected aggregate into the wet Series 1415 resin until no dry spots are visible. Typically, 20/40 mesh sand will require 1 to 1.5 pounds per square foot.

6.8 SERIES 1415 VINESTER BASECOAT CURING

Allow the system to cure. Once fully cured, sweep up all excess aggregate. If appropriate, proceed to vertical application. Otherwise, proceed directly to 8.0 Topcoat Installation.

6.9 SERIES 1415 THINNING

Do not thin.

6.10 SERIES 1415 POT LIFE

TEMPERATURE	POT LIFE
75°F (24°C)	45 Minutes

6.11 SERIES 1415 MATERIAL & STORAGE TEMPERATURE

Minimum storage temperature is 35°F (2°C) and maximum is 75°F (24°C). Prior to application, the material temperature should be between 60°F and 90°F (16°C and 32°C). It is suggested the material be stored at this temperature at least 48 hours prior to use. Temperatures will affect workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

6.12 SERIES 1415 SURFACE TEMPERATURE

Minimum surface temperature is 60°F (16°C) and maximum is 90°F (32°C). The surface should be dry and at least 5°F (3°C) above the dew point. Coating won't cure below the minimum surface temperature. To minimize outgassing, concrete temperature should be stabilized or in a descending temperature mode and the concrete primed with a suitable epoxy primer.

6.13 SERIES 1415 CLEANUP

Clean all equipment and tools immediately after use with MEK.

7.0 WALL INSTALLATION - VERTICAL

7.1 SERIES 1415 VINESTER MIXING VERTICAL APPLICATION

The vertical application is generally completed using Series 1415 clear. If desired, a Series 1400 Color Pack may be added to the Part A to create a pigmented mortar coat. If used, Series 1400 Color Pack shall be added and fully mixed into Series 1415 Part A until a uniform color is achieved. Series 1402 Part B is then blended into the Part A.

The catalyzed Series 1415 shall be split or poured into larger containers to accommodate the immediate addition of Series 211-9111 Bulking Powder. Add approximately 20 pounds per gallon and fully mix into the resin using a box blade Jiffy Mixer or similar equipment.

7.2 SERIES 1415 VINESTER VERTICAL APPLICATION

Apply the mixed mortar to the vertical surface using a trowel to achieve 20 to 30 mils WFT on the surface for a coverage rate of approximately 50 to 60 square feet per gallon.

Smooth and remove trowel marks using a 3/8-inch nap roller lightly wetted with Series 44-809 Smoothing Liquid.

Allow system to cure and proceed to 8.0 Topcoat Installation.

8.0 TOPCOAT INSTALLATION

8.1 SERIES 1415 VINESTER

The topcoat for Series 1415 Vinester Broadcast System is Series 1415 Vinester with Series 1400 Color Packs to create a pigmented finish coat.

8.2 SERIES 1415 VINESTER PIGMENTED TOPCOAT MIXING

The topcoat application uses Series 1415 Clear with the addition of a selected Series 1400 Color Pack. Series 1400 Color Pack is added and fully mixed into Series 1415 Part A until a uniform color is achieved. Series 1402 Part B is then blended into the now-pigmented material.

8.3 SERIES 1415 VINESTER PIGMENTED TOPCOAT APPLICATION

Immediately begin applying Series 1415 topcoat over all horizontal and vertical surfaces using an appropriate squeegee or roller to seal the mortar coat on the walls and over the rough basecoat at 15 to 20 mils DFT or a coverage rate of 55 to 90 square feet per gallon.

On vertical applications, 8 to 10 pounds per gallon of Series 211-9111 may be added to Series 1415 Vinester topcoat to assist in the film build without affecting the sheen or grit of the finish coat.

Actual topcoat application may be adjusted to achieve the desired level of finish, but it should be no less than 15 mils DFT.

8.4 SERIES 1415 THINNING

Do not thin.

8.5 SERIES 1415 POT LIFE

TEMPERATURE	POT LIFE
75°F (32°C)	25 minutes with 5% thinning

8.6 SERIES 1415 MATERIAL & STORAGE TEMPERATURE

Minimum storage temperature is 35°F (2°C) and maximum is 75°F (24°C). Prior to application, the material temperature should be between 60°F and 90°F (16°C and 32°C). It is suggested the material be stored at this temperature at least 48 hours prior to use.

Temperatures will affect workability. Cool temperatures increase viscosity and decrease workability. Warm temperatures will decrease viscosity and shorten pot life.

8.7 SERIES 1415 SURFACE TEMPERATURE

Minimum surface temperature is 60°F (16°C) and maximum is 90°F (32°C). The surface should be dry and at least 5°F (3°C) above the dew point. Coating won't cure below the minimum surface temperature.

8.8 SERIES 1415 CLEANUP

Clean all equipment and tools immediately after use with MEK.

9.0 INSPECTION

Examine the application for any air bubbles or blisters. If present, they must be cut out and repaired. Refer to Tnemec Technical Bulletin 98-11 for additional information.

Unless directed by the specification, NACE SP0188 is generally not required when this system is applied to concrete surfaces on process floors, intermittent immersion or secondary containment services. High voltage discontinuity (spark) testing may be used to determine the presence and number of discontinuities in the nonconductive Vinester 60 Mil Broadcast System applied to a conductive surface. All high voltage discontinuity (spark) testing shall be performed in accordance with NACE SP0188 and the procedure's outlines therein.

Coatings shall be applied and allowed to cure within the parameters of the corresponding product data sheets. Sufficient curing time of the coating system shall be allowed prior to conducting a holiday test, as indicated by the "To Place in Service" or "Return to Service" duration on the product data sheets. Curing time will vary with surface temperature, air movement, humidity, and film thickness.

If the substrate is incompatible or if thickness constraints are not applicable for a non-destructive dry film thickness gauge, measurements of the coating system thickness are to be performed during application of each system component using a wet film gauge, feeler gauge, or other measurement device that can accurately measure the coating wet film thickness. These coating measurements are to be tabulated to determine the total system thickness.

To perform holiday testing, attach a ground wire from the instrument ground output terminal to the conductive substrate and ensure proper electrical contact. Test conductivity by attaching the instrument ground wire to rebar or other metallic ground permanently installed into the concrete and touch the electrode to the bare concrete. If metallic ground is not visible, the ground wire can be placed directly against a bare concrete surface and weighted with a damp cloth and sand-filled paper bag. Make contact with the exploring electrode on the conductive substrate to verify the instrument is properly grounded. If the test proves negative, determining discontinuities with a high voltage spark test will be ineffective. Under no circumstances shall the voltage be increased above the recommended voltage potential.

10.0 FINAL CURING TIME

10.1 RECOMMENDED VOLTAGES FOR HIGH VOLTAGE SPARK TESTING WITH TINKER & RASOR MODEL AP/

TOTAL DRY FILM THICKNESS (MILS)	VOLTAGES (V)
100-124	12,500
125-134	15,000
135-159	16,000
160-174	17,500
175-214	20,000
215-269	27,000
270-299	31,000
300-350	35,000

Holiday testing of repaired areas shall be performed using the same testing procedures as outlined above. If utilizing alternate high voltage DC holiday detectors, never exceed 100 volts DC per mil or contact Tnemec Technical Services for recommended voltage settings. **Excessive voltage may produce a holiday in the coating film.**

Allow 7 days at 75°F (24°C) final cure before placing into service. Contact Tnemec Technical Service if deviations are required.

11.0 SAFETY

These products may contain solvents and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, application and curing. For action regarding the potential hazards associated with these products, please refer to the container label or request a Material Safety Data Sheet from Tnemec Company, Inc. at +1-816-483-3400 or www.tnemec.com.