



PRODUCT PROFILE

GENERIC DESCRIPTION Novolac Epoxy

COMMON USAGE Spray applied, 100% solids, high build, reinforced epoxy formulated for general use as an internal lining for tanks and other aggressive chemical immersion service. Exhibits excellent range of chemical and solvent resistance combined with physical properties for long term durability and service life. Contact Tnemec for more information.

COLORS 1232 Blue. **Note:** Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

FINISH Semi-gloss

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

SURFACER/FILLER/PATCHER Series 351

PRIMERS Self-priming

SURFACE PREPARATION

STEEL SSPC-SP5/NACE 1 White Metal Blast Cleaning or ISO Sa 3 Blast Cleaning to Visually Clean Steel with a minimum angular anchor profile of 3.0 mils. Refer to the Series 365 Application Guide.

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

TECHNICAL DATA

VOLUME SOLIDS 100% (nominal)

RECOMMENDED DFT 20.0 to 60.0 mils (510 to 1,525 microns) one coat with multiple passes.

CURING TIME

Temperature	To Touch	To Handle	Immersion
75°F (24°C)	2 hours	3 hours	24 to 48 hours

These times are based on a 20.0 mil (500 micron) dry film thickness. Higher film thicknesses, insufficient ventilation or cooler temperatures will require longer cure times. This coating commonly develops an amine-blush during cure. While this condition will not adversely affect performance of the coating, this blush must be removed by aggressive sweep blasting before applying additional coats. During high humidity conditions, it is recommended that the application be done while the temperatures are increasing. Cure time to achieve a minimum Shore D Hardness of 81 or Barcol GYZJ 935 hardness of 65 for immersion service is 24 to 48 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

VOLATILE ORGANIC COMPOUNDS

Unthinned: 0.32 lbs/gallon (39 grams/litre)

HAPS

0.07 lbs/gal solids

THEORETICAL COVERAGE

1,604 mil sq ft/gal (39.3 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS

Two: Two Part A (epoxy) to One: Part B (amine)

PACKAGING

KITS CONSIST OF:

	PART A (Partially filled)	PART B (Partially filled)	Yield (mixed)
Large Kit	2-55 gallon drums	1-55 gallon drum	150 gallons (567.8 L)
Medium Kit	2-6 gallon pails	1-6 gallon pail	15 gallons (56.78 L)
Small Kit	1-5 gallon pail	1-3 gallon pail	4 gallons (15.1 L)

NET WEIGHT PER GALLON

11.95 ± 0.25 lbs (5.40 ± .11 kg) (mixed)

STORAGE TEMPERATURE

Minimum 20°F (-7°C) Maximum 110°F (43°C)
For optimal handling and application characteristics, both material components should be stored at a minimum of 70°F (21°C) or higher for 48 hours prior to use.

TEMPERATURE RESISTANCE

Chemical resistance varies depending on chemical exposure and temperature. Refer to Tnemec's Chemical Resistance Guide for further information.

SHELF LIFE

24 months at recommended storage temperature.

FLASH POINT - SETA

Part A: >200°F (95°C) Part B: >200°F (95°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.

TANK ARMOR® | SERIES 365

APPLICATION

COVERAGE RATES

Before commencing, obtain and thoroughly read the Series 365 Application Guide.

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	30.0 (760)	30.0 (760)	53 (5.0)
Minimum	20.0 (510)	20.0 (510)	80 (7.5)
Maximum	60.0 (1525)	60.0 (1525)	27 (2.5)

Allow for overspray and surface irregularities. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING

Power mix contents of each container, making sure no pigment remains on the bottom.

Pre-Heating: Heat each component to 110°-120°F (43°-49°C) prior to spraying. Refer to the Series 365 Application Guide for details.

THINNING

Do Not Thin. Thinning will adversely affect performance properties.

PURGE TIME

Less than 60 seconds.

APPLICATION EQUIPMENT

HEATED PLURAL COMPONENT AIRLESS EQUIPMENT ONLY. Please refer to the Series 365 Application Guide for instructions on equipment. Contact Tnemec Technical Service for recommended equipment modifications.

Brush: Recommended for small areas, repairs and weld seams.

SURFACE TEMPERATURE

Minimum 50°F (10°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Do not apply when humidity exceeds 80%. For tanks, dehumidification equipment is recommended if humidity exceeds 80%.

CLEANUP

Clean up and purge lines immediately after use with No. 4 Thinner.

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