



PRODUCT PROFILE

GENERIC DESCRIPTION Polyamine Epoxy

COMMON USAGE A versatile, high-build, epoxy internal lining applied in a single coat by plural component equipment. Its enhanced chemical resistance and physical properties make it an excellent, cost-effective choice for corrosion control in tanks handling brine water, drilling mud, mild temperature backflow, and a wide range of chemicals used in the oil and gas industry. Series 307 contains micro-fiber reinforcement for enhanced film integrity.

COLORS 1237 Blue, 1239 Gray
Note: Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

FINISH Semi-gloss

SPECIAL QUALIFICATIONS Series 307 conforms to API 652 for lining above ground storage tanks.

COATING SYSTEM

PRIMERS Self-priming or Series 61, N69F, 161. **Note:** For surfaces with light to moderate pitting, priming the surface prior to the Series 307 application may help to prevent holidays in the cured film. **Note:** The following maximum recoat times apply when topcoating with Series 307; Series 61, 14 days; Series N69F and 161, 30 days. If this time limit is exceeded, or if Series N69F or 161 is exterior exposed more than 14 days, the primer must be uniformly scarified prior to topcoating. **Note:** Series N69F or 161 are for crude oil service only.

REPAIR/TOUCH-UP Series G312-1234TK

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 3.0 mils. **Note:** For aggressive cargo exposures or immersion in elevated temperatures, an SSPC-SP5/NACE 1 or ISO Sa 3 Blast Cleaning to Visually Clean Steel with a minimum angular anchor profile of 3.0 mils may be required. Contact Tnemec Technical Services for more information.

WELDS Remove weld spatter, burrs, or protrusions; remove and/or round sharp edges; and smooth rough welds prior to abrasive blasting. Welds should be ground to remove any irregularities and are considered ready for painting when a minimum finishing level of a C designation, as defined by NACE SP0178 latest revision, has been achieved. **Note:** A stripe coat of Series 61 or Series 307 should be applied to all welds, crevices, and sharp angles.

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

TECHNICAL DATA

VOLUME SOLIDS 100% (mixed)

RECOMMENDED DFT 20.0 to 50.0 mils (500 to 1,270 microns), one coat with multiple passes. **Note:** Series 307 can be applied to an optional high build thickness of 60.0 mils in a single coat to horizontal surfaces.

CURING TIME

Temperature	To Touch	To Handle	Immersion
95°F (35°C)	1 hour	2-3 hours	1 day
75°F (24°C)	1 hour	4-5 hours	3 days
55°F (13°C)	1.5 hours	13-15 hours	5 days

Note: The above cure schedule provides for immersion service, temporary or full storage of recommended chemical exposures below 100°F (37°C). For temperature service >100°F (37°C), consult your Tnemec representative or Tnemec Technical Services. **Note:** If more than 7 days have elapsed between coats, the Series 307 coated surface must be mechanically abraded before topcoating.

VOLATILE ORGANIC COMPOUNDS 0.26 lbs/gallon (32 grams/litre)

HAPS 0.09 lbs/gal solids

THEORETICAL COVERAGE 1,604 mil sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Three Part A (epoxy) to One Part B (amine)

MIXING RATIO Three (Part A) to One (Part B) by volume

PACKAGING

	PART A (Partially filled)	PART B (Partially filled)	Yield (mixed)
Large Kit †	3-55 gallon drums	1-55 gallon drum	200 gallons
Medium Kit †	3-6 gallon pails	1-6 gallon pail	20 gallons

† Plural Component application only.

NET WEIGHT PER GALLON 12.33 ± 0.25 lbs (5.59 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 110°F (43°C)
Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested the material be stored at these temperatures at least 48 hours prior to use.

TEMPERATURE RESISTANCE Contact your Tnemec Representative for further information.

SHELF LIFE Part A: 24 months and Part B: 24 months at recommended storage temperature

FLASH POINT - SETA Part A: >230°F (>110°C) Part B: 140°F (60°C)

TANK ARMOR® | SERIES 307

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 (m²/Gal)
Suggested	30.0 (762)	30.0 (762)	53 (5.0)
Minimum	20.0 (508)	20.0 (508)	80 (7.5)
Maximum	50.0 (1270)	50.0 (1270)	32 (3.0)

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°F-120°F (43°C-49°C) prior to spraying.

THINNING

DO NOT THIN. Thinning will adversely affect performance properties.

PURGE TIME

One minute

APPLICATION

HEATED PLURAL COMPONENT AIRLESS EQUIPMENT ONLY. Contact Tnemec Technical Service for recommended equipment modifications.

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

SURFACE TEMPERATURE

Minimum 40°F (4°C) Maximum 110°F (43°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

CLEANUP

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

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