



PRODUCT PROFILE

**GENERIC DESCRIPTION** Polyamine Epoxy

**COMMON USAGE** Internally reinforced, 100% solids epoxy lining that provides protection against corrosion and chemical attack in ground storage and transport tanks. Specified for use as a protective lining in finished fuels, sweet/sour crude and brine immersion exposures for above ground and transport tanks, and pipelines. Series 335 provides long-term durability and corrosion control for extended service life. Contact Tnemec for more information.

**COLORS** 1234 Blue  
**Note:** Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

**FINISH** Semi-gloss

**SPECIAL QUALIFICATIONS** Series 335 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 335 application may help to prevent holidays in the cured film. **Note:** The following maximum recoat times apply when topcoating with Series 335; 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 Service 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 335 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 335 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)	1/2 hour	2 hours	16 hours
75°F (24°C)	3/4 hour	4 hours	1 day
55°F (13°C)	3 hours	16 hours	6 days
35°F (2°C)	5 hours	24 hours	12 days

**Note:** The above cure schedule provides for immersion service, temporary or full storage of recommended chemical exposures below 100°F (38°C). For temperature service >100°F (38°C), consult your Tnemec representative or Tnemec Technical Services. **Note:** If more than 24 hours have elapsed between coats, the Series 335 coated surface must be mechanically abraded before topcoating.

**VOLATILE ORGANIC COMPOUNDS** **Unthinned:** 0.10 lbs/gallon (11 grams/litre)

**HAPS** **Unthinned:** 0.00 lbs/gal solids

**THEORETICAL COVERAGE** 1,604 mil sq ft/gal (39.4 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates.

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

**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.

**Note:** Series G312-1234 TK can be used for repair or touch-up. Reference the Series 312 product data sheet for packaging and mixing information.

**NET WEIGHT PER GALLON** 13.59 ± 0.25 lbs (6.15 ± .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** Chemical resistance varies depending on chemical exposure and temperature. Refer to Tnemec's Chemical Resistance Guide 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: >230°F (>110°C)

# TANK ARMOR® | SERIES 335

**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** Before commencing, obtain and thoroughly reach the Tank Armor Application Guide.

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m <sup>2</sup> /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** Less than 60 seconds.

**APPLICATION** **HEATED PLURAL COMPONENT AIRLESS EQUIPMENT ONLY. Please refer to the Series 335 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 35°F (2°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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