TANK ARMOR®
PRODUCT DATA SHEET
SERIES 340

PRODUCT PROFILE

MODIFIED POLYAMINE EPOXY

A thick-film epoxy formulated for corrosion control and internal lining of petroleum storage tanks. Lining may also be used for select chemical storage tanks. Refer to the Tnemec Chemical Resistance Chart.

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

FINISH
Semi-gloss

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.

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 40.0 mils (508 to 1,016 microns) one coat with multiple passes.

CURING TIME

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>To Recoat (Max)</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>8 hours</td>
<td>7 days</td>
<td>7 days</td>
</tr>
</tbody>
</table>

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.

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

NUMBER OF COMPONENTS
Two: 2 (Part A epoxy) to 1 (Part B amine)

PACKAGING

<table>
<thead>
<tr>
<th>PART A</th>
<th>PART B</th>
<th>When Mixed</th>
</tr>
</thead>
<tbody>
<tr>
<td>Medium Kit</td>
<td>2-6 gallon pails</td>
<td>1-6 gallon pail</td>
</tr>
</tbody>
</table>

NET WEIGHT PER GALLON
13.36 ± 0.25 lbs (6.06 ± .11 kg) (mixed)

STORAGE TEMPERATURE
Minimum 20°F (-7°C) Maximum 110°F (43°C)

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

SHELF LIFE
12 months at recommended storage temperature.

FLASH POINT - SETA
Part A and Part B: N/A

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**

<table>
<thead>
<tr>
<th>COVERAGE RATES</th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested</td>
<td>30.0 (762)</td>
<td>30.0 (762)</td>
<td>53 (5.0)</td>
</tr>
<tr>
<td>Minimum</td>
<td>20.0 (508)</td>
<td>20.0 (508)</td>
<td>80 (7.5)</td>
</tr>
<tr>
<td>Maximum</td>
<td>40.0 (1016)</td>
<td>40.0 (1016)</td>
<td>40 (3.7)</td>
</tr>
</tbody>
</table>

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

**MIXING**

Medium Kit: Agitate Parts A & B making sure no pigment remains on the bottom of the can. **DO NOT MIX PART A WITH PART B.** Use a 2 (Part A epoxy) to 1 (Part B amine) mix ratio heated plural component airless spray unit. **Note:** Product component A (epoxy) must be heated to 120°F to 130°F (49°C to 54°C) and component B (amine) must be heated to 110°F to 120°F (43°C to 49°C) prior to and during plural component application. Do not heat component A (epoxy) above 130°F (54°C) or component B (amine) above 120°F (49°C). Prior to use: Keep containers tightly sealed.

**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 340 Application Guide for instructions on equipment. Contact Tnemec Technical Service for recommended equipment modifications.

**SURFACE TEMPERATURE**

Minimum 50°F (10°C)  Maximum 130°F (54°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. Use No. 68 Thinner when required by SCAQMD regulations.