TNEMEC

TANK ARMOR® SERIES 340

PRODUCT DATA SHEET

PRODUCT PROFILE

GENERIC DESCRIPTION Modified Polyamine Epoxy

COMMON USAGE 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

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.

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

Temperature	To Handle	To Recoat (Max)	Immersion
75°F (24°C)	8 hours	7 days	7 days

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.

VOLATILE ORGANIC COMPOUNDS EPA Method 24
Unthinned: 0.06 lbs/gallon (7 grams/litre)

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

	PART A	PART B	When Mixed
Medium Kit	2-6 gallon pails	1-6 gallon pail	15 gallons (56.78 L)

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)
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 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

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	40.0 (1016)	40.0 (1016)	40 (3.7)

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

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.