



# TANK ARMOR® SERIES 350

## PRODUCT PROFILE

<b>GENERIC DESCRIPTION</b>	Modified Phenolic Epoxy
<b>COMMON USAGE</b>	A high-build tightly cross-linked high performance epoxy with excellent resistance to a broad range of chemicals, solvents and petroleum over a wide range of temperatures. Refer to the Series 350 Chemical Resistance Guide.
<b>COLORS</b>	1232 Blue, 1214 White. <b>Note:</b> Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.
<b>FINISH</b>	Semi-gloss
<b>SPECIAL QUALIFICATIONS</b>	Series 350 conforms to API 652 for lining above ground storage tanks.
<b>PERFORMANCE CRITERIA</b>	Contact your Tnemec representative for specific test results.

## COATING SYSTEM

<b>SURFACER/FILLER/PATCHER</b>	Series 351
<b>PRIMERS</b>	Self-priming or Series 61, N69F, 161. <b>Note:</b> For surfaces with light to moderate pitting, priming the surface prior to the Series 350 application may help to prevent holidays in the cured film. <b>Note:</b> The following maximum recoat times apply when topcoating with Series 350; 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. <b>Note:</b> Series N69F or 161 are for crude oil service only.
<b>REPAIR/TOUCH-UP</b>	Series G312-1234TK

## SURFACE PREPARATION

<b>STEEL</b>	<b>Immersion Service:</b> 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. <b>Note:</b> 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.
<b>WELDS</b>	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. <b>Note:</b> A stripe coat of Series 61 or Series 350 should be applied to all welds, crevices, and sharp angles.
<b>ALL SURFACES</b>	Must be clean, dry and free of oil, grease and other contaminants.

## TECHNICAL DATA

<b>VOLUME SOLIDS</b>	100%
<b>RECOMMENDED DFT</b>	20.0 to 40.0 mils (508 to 1,016 microns) one coat with multiple passes.

**CURING TIME**

Temperature	To Touch	To Handle	Immersion
75°F (24°C)	3 hours	4 hours	24 to 36 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 77 or Barcol GYZJ 935 hardness of 55 for immersion service is 24 to 36 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

**VOLATILE ORGANIC COMPOUNDS** 0.19 lbs/gallon (23 grams/litre)

**HAPS** 0 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** KITS CONSIST OF:

	PART A (Partially filled)	PART B	Yield (mixed)
Large Kit	3-55 gallon drums	1-55 gal drum (partial fill)	200 gallons (757.0 L)
Medium Kit	3-6 gallon pails	1-6 gallon pail (partial fill)	20 gallons (75.70 L)
Small Kit	1-5 gallon pail	1-1 gallon can	4 gallons (15.1 L)

**Note:** Series G390-1232 TK can be used for repair or touch-up. Reference the Series 390 product data sheet for packaging and mixing information.

**NET WEIGHT PER GALLON** 12.1 ± 0.25 lbs (5.49 ± .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)

# TANK ARMOR® | SERIES 350

**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.**

**APPLICATION**

**COVERAGE RATES** Before commencing, obtain and thoroughly read the Series 350 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	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** 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 350 Application Guide for details on the heating and mixing of the material.

**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 350 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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