



PRODUCT PROFILE

GENERIC DESCRIPTION Polysulfide Epoxy Novolac Polymer

COMMON USAGE A 100% solids flexible polymer formulated for general use as a trowel grade filler/surfacer for steel and provides protection against chemical attack and environmental degradation. Resistant to a wide range of petroleum products, fuels, gasohol, waste, alkalis, and organic and inorganic acids. Compatible with a variety of topcoats. **Note:** Contact your Tnemec representative or Tnemec Technical Service with specific chemical exposures.

COLORS 1232 Blue.

FINISH Semi-gloss

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Self-priming

TOPCOATS Series 330, 345, 350, 365, 390, 396

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%

RECOMMENDED DFT Trowelled: 40 mils to 1/4 inch (6.35 mm)

CURING TIME

Temperature	To Touch	To Handle	Immersion
75°F (24°C)	10 hours	14 hours	3 to 7 days

These times are based on a 50.0 mil (1270 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 85 or Barcol GYZJ 935 hardness of 79 for immersion service is 3 to 7 days. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

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

HAPS 0.14 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: One Part A (epoxy) to One: Part B (amine)

PACKAGING KIT CONSISTS OF:

	PART A (Partially filled)	PART B (Partially filled)	Yield (mixed)
Medium Kit	1-5 gallon pail	1-5 gallon pail	4 gallons (15.1 L)
Small Kit	1 gallon can	1 gallon can	1 gallon (3.79 L)

NET WEIGHT PER GALLON 13.43 ± 0.25 lbs (6.09 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 20°F (-7°C) Maximum 100°F (38°C)

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)

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.

TANK ARMOR® | SERIES 351

APPLICATION

COVERAGE RATES	One gallon will cover 40 square feet (3.7 m ²) at 40.0 dry mils (1016 microns), or will cover 6.4 square feet (0.6 m ²) at 1/4 inch.
MIXING	Mix ratio is 1:1 by volume. Use a minimum 10 amp 3/4 inch heavy duty drill with a 4 inch jiffy blade. Mix the contents of Part A and Part B separately. Using a spatula, scrape all of the Part B into the Part A while under agitation. Blend the components for two minutes and scrape the sides and bottom of the container. Blend the material for another two minutes until fully blended and the material is a consistent color without white or blue streaks in the material. Do not use mixed material beyond pot life limits. Note: A large volume of material will set up quickly if not applied quickly or reduced in volume. Caution: Do not reseal mixed material. An explosion hazard may be created.
THINNING	Do Not Thin. Thinning will adversely affect performance properties.
POT LIFE	10 minutes
APPLICATION EQUIPMENT	Spot fill pits with a putty knife or trowel. Apply to large surfaces with a trowel and spread uniformly with a medium hardness rubber float or trowel.
SURFACE TEMPERATURE	Minimum 45°F (7°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%.
MATERIAL TEMPERATURE	For optimum application and handling, the material temperature prior to the application should be between 70°F (21°C) and 80°F (27°C). Temperature will affect the workability. Cool temperatures will increase the viscosity and decrease workability. Warm temperatures will decrease the viscosity and shorten pot life.
CLEANUP	Clean up immediately after use with No. 4 Thinner.

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