**PRODUCT PROFILE**

**GENERIC DESCRIPTION**
Novolac Epoxy

**COMMON USAGE**
Spray applied, 100% solids, high build, reinforced epoxy formulated for general use as an internal lining for tanks and other aggressive chemical immersion service. Exhibits excellent range of chemical and solvent resistance combined with physical properties for long term durability and service life. Contact Tnemec for more information.

**COLORS**
1252 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. Refer to the Series 365 Application Guide.

**ALL SURFACES**
Must be clean, dry and free of oil, grease and other contaminants.

**TECHNICAL DATA**

**VOLUME SOLIDS**
100% (nominal)

**RECOMMENDED DFT**
20.0 to 60.0 mils (510 to 1,525 microns) one coat with multiple passes.

**CURING TIME**

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Touch</th>
<th>To Handle</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>2 hours</td>
<td>5 hours</td>
<td>24 to 48 hours</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. Cure time to achieve a minimum Shore D Hardness of 81 or Barcol GYZJ 935 hardness of 65 for immersion service is 24 to 48 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

**VOLATILE ORGANIC COMPOUNDS**
Unthinned: 0.32 lbs/gallon (39 grams/litre)

**HAPS**
0.07 lbs/gal solids

**THEORETICAL COVERAGE**
1,604 mil sq ft/gal (39.3 m²/L at 25 microns). See APPLICATION for coverage rates.

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

**PACKAGING**

<table>
<thead>
<tr>
<th>KITS CONSIST OF:</th>
<th>PART A (Partially filled)</th>
<th>PART B (Partially filled)</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Large Kit</td>
<td>2-55 gallon drums</td>
<td>1-55 gallon drum</td>
<td>150 gallons (567.8 L)</td>
</tr>
<tr>
<td>Medium Kit</td>
<td>2-6 gallon pails</td>
<td>1-6 gallon pail</td>
<td>15 gallons (56.78 L)</td>
</tr>
<tr>
<td>Small Kit</td>
<td>1-5 gallon pail</td>
<td>1-3 gallon pail</td>
<td>4 gallons (15.1 L)</td>
</tr>
</tbody>
</table>

**NET WEIGHT PER GALLON**
11.95 ± 0.25 lbs (5.40 ± 0.11 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**
24 months at recommended storage temperature.

**FLASH POINT - SETA**
Part A: >200°F (93°C) Part B: >200°F (93°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.
APPLICATION

COVERAGE RATES

Before commencing, obtain and thoroughly read the Series 365 Application Guide.

<table>
<thead>
<tr>
<th></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 (760)</td>
<td>30.0 (760)</td>
<td>53 (5.0)</td>
</tr>
<tr>
<td>Minimum</td>
<td>20.0 (510)</td>
<td>20.0 (510)</td>
<td>80 (7.5)</td>
</tr>
<tr>
<td>Maximum</td>
<td>60.0 (1525)</td>
<td>60.0 (1525)</td>
<td>27 (2.5)</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

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 365 Application Guide for details.

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 365 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.